



FUMIO LUBE

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LUBRICATING OIL

FL FUMICOOL SB - 25

FL FUMICOOL SB-25 is emulsion type low septic EP cutting and grinding fluid for general use.

❖ SPECIAL FEATURES

1. Used for general cutting/ grinding works of steel, featured to extend service life of tools and to improve smoothness of finished surface.
2. Excellently protect steel and non-ferrous metals from rust and corrosion.
3. Used good anti-septic agent to suppress fluid deterioration, make it possible to use the fluid/ solution for a longer period.
4. Good cleaning ability and de-foaming characteristics provide good workability.

❖ TYPICAL USES AND STANDARD DILUTING RATIOS

Material to work : General cutting / grinding work of steel (including stainless steel) and aluminum. Detailed works :

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| 1. Cutting works of steel (incl. stainless steel)
by NC lathe, boring, milling and transfer machine | 5 % ~ 10 % |
| 2. Cutting works of aluminum alloys by
NC Lathe, boring, milling and transfer machine | 3 % ~ 10 % |
| 3. Threading, Tapping and reaming | 5 % ~ 20 % |
| 4. Grinding works of steel (incl. stainless steel and aluminum alloys) | 3 % ~ 5 % |
| 5. Sawing works of steel and non –ferrous metals by machine saw | 3 % ~ 5 % |

❖ TYPICAL PROPERTIES

*** (Tested with diluted solution of 10%)**

Density	(15%)g/cm ³	0.951
Appearance, Raw Fluid		Reddish brown fluid
Appearance, Diluted Solution (*)		Milky white emulsion
PH (*)		9.35
Surface Tension (*)	dyne/cm	34.0
Rust Preventing	2.5 % diluted solution	Chip method/ No Change
Performance FC-20 24 hr	5 % times diluted solution	Match method/ No Change
Influence on non-ferrous metals (*)		Steel (C-1100P)/ No discolor
Room Temperature x 48 hr		Aluminum (A-1050p)/ No discolor
Emulsion Stability (*)	ml/100ml, Room temp x 24 hr	Oil cream/ Trace

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