

r. rhenus XY 120 HM

r. rhenus XY 120 HM is a water soluble metalworking fluid free of mineral oil. A product of the amine-free generation offering high technical performance and maximum protection for operator and machine.

Application

r. rhenus XY 120 HM is a product specifically developed for carbide metal grinding. It can also be used for grinding operations of standard steel and cast materials as well as for general applications.

r. rhenus XY 120 HM avoids leaching of cobalt ions in grinding solutions and, therefore, no staining involved. Therefore, working protection for the operator has considerably been improved.

In order to guarantee a proper function of the grinding solution make sure that sufficient filtration is available, preferably band filtering. Insufficient filtration may cause increased foaming and machine contamination.

Properties

- transparent solutions
- high stability and low dragout losses
- low foaming even at high coolant pressures
- efficient protection against corrosion
- good cooling and rinsing effects
- long sump life of grinding solution
- water dangerous class 1

Technical Data

Concentrate		Solution	
viscosity 20 °C (mm ² /s)	pH-value at 3 %	foam UT (3 % - NW 5)	corrosion- protection (DIN 51360/2)
100	9,2	< 1.5 min	at 4 % grade 0

Remarks

To prepare the operating solution slowly add the coolant concentrate to drinking quality water assuring thorough mixing. For best results mixing an automatic mixer is recommended.

Recommended Mixing ratios:

Grinding of carbide metal and steel: from 3 %
Grinding of cast iron: from 4 %

The concentration of operating solutions can easily be checked by means of a pocket refractometer.

Refractometer factor

1,1

Rhenus metal working fluids are free of chlororganic substances, nitrite and secondary amines. They contain natural raw materials. Therefore, slight degradations of colour and appearance are possible, however, quality and function of the product are not affected at all.

Subject to modification of the technical data. Please refer to the material safety data sheet for additional information or contact our application engineers.

Edition

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