

MWF-PLUS WS GEN 28

WATER SOLUBLE METALWORKING FLUIDS (GENERAL MACHINING)

325303401

DYADE
LUBRICANTS



GENERAL MACHINING METALWORKING FLUID

This formaldehyde-free product is a versatile high-performance water-soluble cutting fluid that offers exceptional stability and performance even in harsh environments with high humidity and pollution. When mixed with water, it forms stable milky emulsions with low foam and provides excellent extreme pressure (EP) and lubricating properties, as well as effective corrosion protection. Additionally, the product contains additives that enable it to outperform conventional emulsions in terms of tool life and finishing quality, when used at the recommended concentration. The microfine emulsion of this product enhances the lubrication and cooling properties, facilitating better penetration of the fluid into the critical tool/chip interface, leading to a superior finish on components and prolonged tool life. It is particularly recommended for threading and MAPAL reaming operations on aluminum, and it is also suitable for machining steels and nonferrous metals. The product can be used in all types of CNC, transfer, and metalworking machines.

HOW TO APPLY

For mixing, introduce the concentrate into water at the designated ratio and stir well, or use a proper mixer. Use tap water or treated water for make-up or top-up, ideally with a hardness of 100-300 ppm CaCO₃ and chloride levels below 0.1 g/L. When changing over from old fluid with bacteria, fungus, or contamination, use a system cleaner. The recommended concentration is 6-8% depending on the severity of the application. Concentration accuracy can be verified using a refractometer with the formula: % Concentration = Refractometer Reading x 1.3. Monitor the system weekly using a refractometer and pH meter/stick, routinely remove tramp oil, and store the fresh (concentrate) product between 5°C and 45°C.

CATEGORY

- Metalworking Fluids

BENEFITS

- Coolant universal application
- Excellent lubricant and EP characteristics
- Good service life
- Environmentally acceptable
- Does not contain nitrite, boron, amines or chlorine
- Does not form sticky deposits on machine surface
- Suitable for systems with tendency to biological pollution
- Multi metal
- Formaldehyde free

STATUS	PROPERTY	VALUE
Neat	Appearance	Amber liquid
Neat	Density at 20 °C, kg/m ³	960
Neat	Pour Point, °C	-5
5% Emulsion tap water 150 ppm	Appearance	Milky translucent
5% Emulsion tap water 150 ppm	pH	9,3
5% Emulsion tap water 150 ppm	Corrosion test IP-287	No corrosion
5% Emulsion tap water 150 ppm	Corrosion Aluminium	No corrosion
5% Emulsion tap water 150 ppm	Corrosion Copper	No corrosion

All data on this technical data sheet is indicative only

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