

linelube FS2603 Cutting Fluid

Product Description

FS2603 is a high performance general-purpose biostable emulsion type cutting fluid concentrate designed for more arduous machining operations including CNC reaming, drilling and tapping.

Features & Benefits

- Suitable for a wide range of materials
- Long sump life
- Excellent rancidity control
- Excellent corrosion control
- Permits higher cutting speeds
- Stable in harder water areas
- Advanced design giving good lubrication
- Low foaming / Low misting
- EP additives reduce tool wear
- Clean and pleasant to use
- Offers versatility for mixed machining operations, can replace neat oils
- Triazine free

Applications

FS2603 has been specifically designed with a blend of surface active and hydrodynamic lubrication additives and can be used on ferrous, non-ferrous, and materials such as stainless steels and nimonic alloys. FS2603 is capable of replacing the use of neat oils in multi-spindle and automatic machining centres where machine design permits the use of water-based fluids. Long sump life can be expected due to the modern bio-stability chemistry. Machining applications range from light duty grinding to high speed CNC milling and turning, concentrations will be variable dependant on severity of application.

Recommended Starting Concentrations

Grinding	3 - 5%
Light to Medium Duty Machining	4 - 6%
Medium to Heavy Duty Machining	6 - 8%
Extremely Heavy Applications or as a replacement for neat oils	8 - 12%

Top up Concentrations should always be made with a diluted mix of concentrate and water to maintain the recommended strength in the machine.

Concentration Analysis

To check and maintain concentration a refractometer is recommended, the resulting reading multiplied by a factor of 1.4 will give concentration strength.

Typical Physical Characteristics

Emulsion @ 5%	
Appearance	Opaque
Odour	Bland
pH (in use)	8.8 – 9.5

Concentrate	
Appearance	Translucent
Specific Gravity @ 20°C	1.010

Health & Safety

For health and safety information please refer to the relevant health & safety data sheet on our website. The contents of this data sheet is given in good faith but without warranty.