

# GENERAX SE-LF/14

## HIGH PERFORMANCE VEGETABLE OIL BASED METALWORKING FLUID

### PRODUCT DESCRIPTION

GENERAX SE LF/14 is a water soluble semi-synthetic vegetable-oil based metal working fluid, which does not contain any mineral oil. Its semi-synthetic structure derived from self-emulsifiable esters as and at the same time, they cause GENERAX SE LF/14 to be an environmentally friendly product. It is formulated with a well-balanced additive content which consist of strong emulsifiers and corrosion, foam and microorganism preventive chemicals.

### APPLICATION / USAGE

It is used for iron, aluminum and copper materials.

When machined parts is kilned before tempering operation without washing process, the desired tempering layer is easily obtained.

Normal machining	: % 5-7
Grinding Taşlama	: % 3-5
Aluminium Grinding	: % 5-8
Finishing	: % 3-5
Honing	: % 10-22

Concentration ranges mentioned above are valid in case of water with a Total Hardness of 5-20 °dH is used in the emulsion.

The emulsion should be prepared by adding GENERAX SE LF/14 on the water meeting the recommended water specifications and blending slowly, in an emulsion preparation tank if possible. It is recommended to use mechanical mixers for blending process. As unstable emulsions occur as a result, water should never be added on the product during preparation. % Concentration value should be periodically controlled during usage and GENERAX SE LF/14 should be added to the system when necessary. It is imperative that the filtration and circulations systems work effectively in order to prolong the service life of the emulsion.

### ADVANTAGES / BENEFITS

- Provides effective protection against corrosion during the operation and short-term storage,

- Since it does not contain mineral oil, it simplifies the disposal of emulsions in the treatment plants,
- Provides high detergency power and contains special esters for lubricity. It extends the life of the cutting tools, and prevents downtimes by increasing the tool change periods,
- Provides long service life for the solution due to its resistance to microorganism production,
- Provides superior surface quality for the processed material,
- Carries the metal chips and other foreign substances away to the emulsion tank and thus ensures that the emulsion cleanliness is maintained,
- Transports the undesirable mineral oils (hydraulic, gear oils etc.) to the emulsion surface and helps these oils to be removed from the system,
- Long-lasting and economical product,
- In case of usage at recommended concentration ranges, it does not cause any harm to the machining tool paint and/or tool sealing and closure apparatus. It provides cleanliness of the machining tools and pipelines,
- Since its pH value adjusted it does not cause sensitivity or harm on the skin,
- Does not contain Nitrite, Phenol and/or Chlorine compounds,

### STORAGE

Protect from direct sunlight and rain. Store in the original closed drums and in covered areas. Storage temperature must be between (+5)-(+40)°C.

### HEALTH AND SAFETY

This product is unlikely to present any significant health or safety hazard when properly used in the recommended application. Used or waste product should not be allowed to contaminate soil or water. Used or waste product should be disposed of in accordance with local regulations. For further guidance on product Health and Safety refer to the appropriate Material Safety Data Sheet.

"The above information is derived from our quality checks. Given values are typical of current production. While future production will conform to our specification, variations in these characteristics may occur. Quality Control Analysis Report for to learn properties of the product that is supplied can give. It does not relieve the purchaser from examining product upon delivery and gives no assurance of the product for any particular purpose. Due to continual product research and development, the information contained herein is subject to change without notification."

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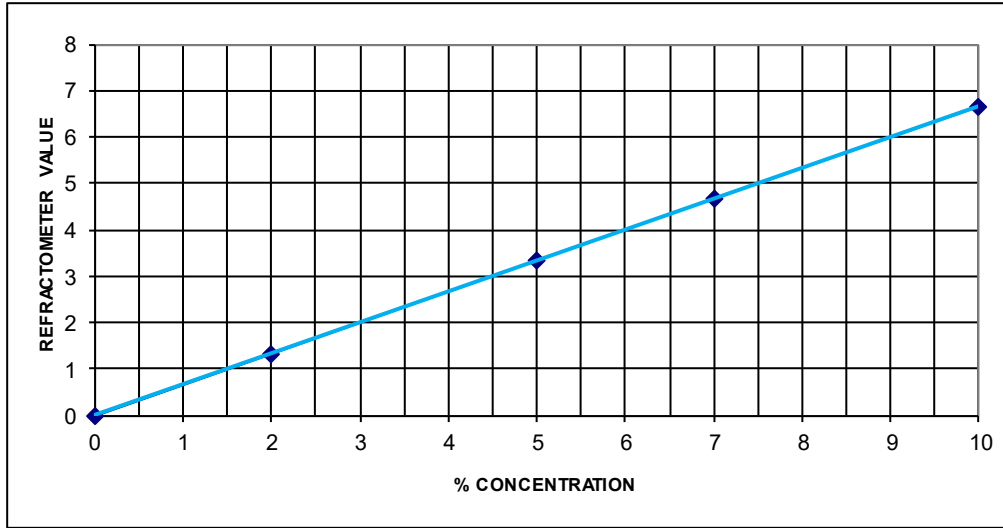
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TECHNICAL PROPERTIES	TEST VALUES	TEST METHOD
Appearance	Dark green, clear	-
Emulsion Appearance (%5)	Green, transparent	-
Density (20 °C, g/mL)	1,048	ASTM D 1298
pH (%5)	9,6	ASTM D 1287
Corrosion Test (5-10 °dH , %5, 2h)	0-0	DIN 51360/2
Refractometer Factor	1,5	Hand Refractometer

### Concentration Control:

% Concentration	Refractometer Value
2	1,3
5	3,3
7	4,7
10	6,7



The data provided for the % concentration control is prepared according to the data obtained for the freshly prepared emulsion. As the utilization time of the emulsion and the undesired oil/contamination amount in the system increases, deviations from the data stated above should be taken into account.

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