

## **WS 600N (M)**

### **Technical Data Sheet**

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**WS 600N (M)** is economical and environment- friendly, long life water-soluble oil, suitable for all moderate machining and grinding operations on all ferrous and non-ferrous metals except titanium and magnesium. Formulated with refined naphthenic base oil, corrosion inhibitor package and biocides, **WS 600N (M)** is designed to give at least two times more sump life as compared to the conventional coolants. Excellent flushing ability of the product enhances the cooling and chip removal ability.



#### **Features and benefits:**

- Special biocide package enhances the sump life.
- Corrosion inhibitor package protects the job and machine from rusting. Reduces wheel loading and dressing frequency.
- Reduces machine down time.
- Reduces disposal and labor costs.
- No Hazardous ingredients as per OSHA Hazardous standards.

#### **Directions for use:**

**WS 600N (M)** should be diluted with water in the range of 10:1 to 60:1 depending upon the severity of the operation, work piece material and water hardness. The following practices help in achieving the full benefits of the product.

- Always add oil to water and never the other way.
- Usage of low hardness (< 100 PPM), Low chlorides (< 30 PPM) water. Never add product directly to the sump. Add in the emulsion form. Always clean the sump thoroughly before a fresh charge.

## Typical properties:

Attributes	Ref. Method	Specifications
Appearance	Visual	Amber clear liquid
Odor		Mild odor
Specific gravity @ 27 Deg C	ASTM D 1298	0.88 – 0.920
Emulsion type	Visual	Bluish opaque
Emulsion stability test 5% in 400 ppm hard water	Internal	No oil separation
pH of 5% solution	Internal	10.0±0.5
Foam depression in secs 5% in D.M Water	IP 312/74	45 seconds max
Cast iron corrosion test 5% 200 ppm water	IP 287	Less than 1%
Refractometer reading (1: 20)	Internal	5.6 – 6.0
Oil content	Internal	70 % Minimum

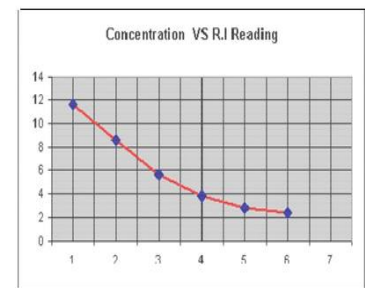
- Technical data details should be considered representative or typical values only and should not be used for specification purposes.

**Note\*:** Changes in the appearance of the product have no detrimental effect on the Quality /Performance of the product.

Metal	Compatibility
Ferrous	Yes
Aluminum	Yes
Brass/Copper	Yes
Titanium	No
Magnesium	No

Operation	Conc.
Drilling	01:15
Broaching	01:10
Grinding	01:20
Tapping	01:10
Milling	01:25

X-Axis	Y-axis
Conc.	R.I
01:10	11.6
01:15	8.6
01:20	5.8
01:40	2.8



## Material Compatibility:

- Recommended for ferrous metals & ferrous alloys.

**Packaging Details:** Available in 20 & 205 liter drums.

**Storage & Safety:** This product is unlikely to present any significant health or safety hazard when used as recommended. Good standards of personal and industrial hygiene are to be maintained by the user - (*Refer Safety Data Sheet*).

**Disclaimer:** Information contained in this data sheet is based upon the properties and applications of use known to us. However, generally no legal liability may be deducted from such information.



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