

TECHNICAL DATA SHEET

XP6000

Code 7468

High Performance Semi Synthetic Metalworking Coolant

DESCRIPTION

Callington XP 6000 is a chlorine free, high lubricity, semi synthetic metalworking fluid.

A combination of high mineral oil content and unique additive package provides excellent lubrication and machining cleanliness in a wide range of applications. It produces an extremely stable semi translucent type emulsion, which provides consistent performance in a wide range of water types.

APPLICATION

Callington XP 6000 is particularly recommended for applications where a high degree of lubricity is required, as well as cleanliness and easy wash out properties, such as required in HDD and electronic component machining.

It is also suitable for the machining of low to high alloy steels. It is non- staining to copper, and aluminium and its alloys, making it ideal for use in automotive, electronics and aerospace aluminium applications.

The products versatility and long service life makes it ideal for use as a multi purpose fluid, and is equally suited for use in single sump machines and centralised coolant systems.

Recommended make up water range is 50ppm – 400ppm hardness as CaCO₃

BENEFITS

- Product rationalisation – one product for multi – metal machining operations.
- Excellent coolant stability ensures consistent machining performance, minimises rejects.
- Stable emulsion, with excellent wetting properties means less drag out and lower top up rates, lower residues and improved machine cleanliness.
- Low foam performance in softer waters, eliminating use of antifoams and reducing maintenance costs.
- Effective antimicrobial additive system providing long coolant life.
- Chlorine, phenol and nitrite free, meeting local legislation, waste treatment and environmental requirements

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RECOMMENDED DILUTIONS

Material	Low Si Aluminium	High Si Aluminium	Low alloy steels	High Alloy Steels
Operation				
Grinding	3-5%	3-5%		
Turning	5-7%	5-7%	5-7%	5-7%
Drilling				
Heavy Duty Milling				
Tapping	7%	8-10%	7%	7%
Reaming				
Broaching	7%	8-10%		

TYPICAL DATA (note: data is typical; and does not constitute a specification)

Concentrate	Test method	Typical result
Appearance	Visual	Clear yellow liquid
Density @ 30C	DIN 51757, ASTM D1298	0.95
Emulsion		
Appearance	Visual	White, semi-transparent
pH 5%	DIN 51361, ASTM E70-97	9.0
Refractometer Factor		1.12

Storage: Keep container closed, prevent exposure to frost, and prevent water ingress. Store in cool, dry conditions, and avoid direct sunlight. Indoor storage is preferable.

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Created 10 October 2008 Date Printed 28/03/2018 4:20 AM

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