

# Product information

## AquaTec 7539

Semisynthetic cutting and grinding fluid concentrate

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AquaTec 7539 is a high performance semisynthetic cutting and grinding fluid concentrate for moderate to heavy-duty metalworking applications. Mixed with water, it provides excellent lubrication and corrosion inhibition in grinding and cutting of steels, cast iron and most aluminium alloys. It is not recommended for magnesium alloys. AquaTec 7539 has been formulated to significantly extend fluid life.

AquaTec 7539 is recommended for a wide variety of heavy duty metalworking operations including CNC milling, turning, drilling, boring, tapping, threading and grinding. It is a true, multipurpose product for all kind of heavy duty operations. By its proven combination of lubricity additives it clearly improves tool life and surface finish. AquaTec 7539 can be used in "stand-alone" machines and central systems.

### Advantages

- Wide range of application
- Extended fluid life
- Excellent lubrication and anticorrosion for ferrous- and non-ferrous metals
- Excellent rinsing properties for open cutting
- Extremely low foaming in high pressure and flood type applications
- Low foam, odour and mist levels

AquaTec 7539 does not contain chlorine, nitrite, silicone or phenolic biocides.

### Recommended concentrations

ID, OD, centerless grinding	5 %
Milling, Drilling, Turning	5 %
Heavy duty machining (Tapping, Reaming)	6 %

The above-mentioned concentrations are an average. After on site check our oelheld specialist will recommend an adapted concentration and topping up rate for your application.

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### Technical Data

Form	Brown clear liquid	Typical operating pH-value	8.8 – 9.0
Density at +20°C	1.0 g/cm <sup>3</sup>	Flashpoint	n.a.

### Mixing instructions

Always add AquaTec 7539 to water. Mixed concentration can be determined using a refractometer. **Refractometer factor = 1.5**

Concentration	4% (1:25)	5% (1:20)	6% (1:17)	7% (1:14)	8% (1:13)	10% (1:10)
Refractometer reading	2.7	3.3	4.0	4.7	5.3	6.7

A mixing device and the use of premixed concentrate as makeup will improve performance and reduce usage. The specific makeup concentration selected for your situation should balance the water evaporation rate with the coolant carry-off-rate. Adding makeup concentrate at 20 – 30% of the desired working concentration will generally maintain the proper concentration in use. The use of deionized or mineral-free water for makeup will also improve performance, prolong sump life, and reduce concentrate usage.

A thoroughly cleaning of the machine sump or central system with system cleaner is recommended to remove oily residues, dirt deposits and biofilms of bacteria and mould before refilling the system.

### Notes

- The most recent MSDS is available from either oelheld or your authorized oelheld distributor
- Consult oelheld before using this product on any metals or applications not specifically recommended
- Do not use any metalworking fluid additives except as recommended by oelheld
- The general description, recommended uses, application data and statements in the product literature are guidelines. Because this product may be used for a variety of applications over which oelheld has no control, oelheld assumes no liability for incidental, consequential, or direct damages of any kind, regardless of causes, including negligence.

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