

# Product information

## AquaTec 7650

Cooling concentrate

Page 1/2

Our cooling concentrate AquaTec 7650 is a water-soluble EP cooling lubricant, developed especially for the general chipping of aluminum alloys. It is also suitable for cast materials and higher alloyed steels. Particularly when working with tools with guide bars (Reaming & fine boring) one can obtain an excellent surface quality. AquaTec 7650 is free of amines according to the TRGS 611 and does not contain organochlorines.

AquaTec 7650 is foam-inhibited and enables long emulsion lifetimes leading to low maintenance costs. When mixed with water, it forms a solution of high stability, excellent rinsing effect. AquaTec 7650 can be solved in soft and hard water qualities. This cooling concentrate is harmless to the skin compatibility and has a pleasant odour.

AquaTec 7650 is suitable for the use of single filled machines as well as for central systems.

### Recommended concentrations:

Chipping of aluminium alloys	7 – 10 %
Heavy chipping	8 – 20 %

### Technical facts:

Colour of the concentrate	brown
Mineral oil content	ca. 45 %
Density at +15°C [g/cm <sup>3</sup> ]	0,94
pH-value of a 5 % emulsion	9,2
Corrosive effect 6%	mark 1

### Mixing instructions:

Always mix AquaTec 7650 into water under simultaneous stirring, never the other way around. The concentration can be checked with a hand refractometer. Refractometer factor = 1,05.

Concentration	3% (1:33)	4% (1:25)	5% (1:20)	6% (1:17)	7% (1:14)	10% (1:10)
Refractometer factor	2,9	3,8	4,8	5,7	6,7	9,5

# Product information

## **AquaTec 7650** Cooling concentrate

Page 2/2

Emulsions must not be mixed with pure drinking water, otherwise they lose their stability. Instead add a very low concentrated emulsion of the used emulsion. The use of deionised or demineralised water for refilling increases the stability of the emulsion, avoids the formation of deposits and reduces the consumption of the concentrate.

Before preparing a new solution the system must be cleaned thoroughly with a system cleaner. Used solutions must be disposed by means of legal waste disposers.

### Notes

- The latest 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.

11/2012