

# Technical Data Sheet

## Coolant MG1890

It is a high oil content, stable, water soluble metal working fluid, specifically designed for use when machining Magnesium alloys, giving the maximum lubricity and corrosion protection of a high oil content product.

Boron-free, Chlorine-free.

Coolant MG1890 is suitable for machining a wide variety of materials including cast iron, mild steels, stainless steels and other easy to medium machine-ability materials. Excellent for Magnesium alloys.

### Key Benefits

- Tolerant to Mg++ ions
- Long Sump Life
- Improved Tool Life
- Excellent surface finish
- Excellent visibility
- Operator Friendly
- Excellent Corrosion Protection
- Low Foam in soft water.
- Reduced Sticky Deposits
- Reduced soap formation

### Typical Applications

- |                                       |       |
|---------------------------------------|-------|
| • General Machining                   | 4-6%  |
| • Deep hole drilling, boring, tapping | 6-8%  |
| • Mapal reaming                       | 8-10% |
| • Creep feed grinding                 | 5-10% |

### Typical Data

#### Concentrate

Appearance	Amber Fluid
Specific Gravity	0.95
Mineral Oil Content %	60

#### Emulsion

Appearance	Translucent /Milky
pH at 5%	9.3
IP287 pass at %	3.0
Refractometer Factor	1

### Emulsion Type

- Translucent/Milky emulsion
- High Oil Content
- Lubricity additives.

### Compatibility

- Ferrous metals including stainless steel.
- Aluminium alloys
- Magnesium alloys
- Inconel and other high spec alloys
- Titanium alloys
- Plastics

### General Compatibility

- Waters from 100ppm to 1000ppm (Calcium hardness)
- Low foaming tendency ( in hard water)
- Suitable for medium pressure applications
- Suitable for low pressure applications

### Health and Safety

Full health and safety data sheet is available on request.

### Storage

- Store indoors
- Store between 4 °C and 34°C
- Shelf life is 6 months from date of supply
- Store undercover or if outdoors on its side.

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