

TECHNICAL DATA SHEET

F680 ER

Universal high-performance cutting oil

Product made with **materials of vegetable origin admixed with ER** (Energy Release, specific additive for very high pressures), with high performance and a high lubricating and cooling effect.

Environmentally-friendly product, particularly recommended in **tapping** works; it does **not drip**; the extreme adhesive force allows the product to grip the material or tool; it does not disperse; it lubricates, cools and protects the tool; **it improves its durability up to 10 times more**. It **does not contain** mineral oils, toxic solvents and chlorofluorocarbons (CFC). **It is not inflammable**.

Available as spray and liquid.

APPLICATION AREAS:

mechanical industry in general; high versatility of components and the Energy Release additive allow its application on steel, stainless steel, titanium, aluminium and all metals that are difficult to work.

It is suitable for tapping, drilling and milling operations carried out with drills, tapping machines, mills, punches, cutters, threaders and so on.

It improves the tool durability by up to 10 times more.

Spray USE: apply the product in the most suitable way, after shaking the aerosol cylinder carefully.

Spray FEATURES:

- Appearance: oily liquid in gas dispersion, light brown
- Odour: none
- Propellant: Propane/Butane
- Appearance of the jet: directional

Liquid USE: apply the **diluted** product on parts to be worked or on the tool, by means of a brush, atomiser, spraying systems or minimal lubrication systems.

Recommended dilution percentages:

To work **steel, stainless steel, titanium and for all metals that are difficult to work** 5%-7% in the tapping, milling, milling with hob, multiple drilling operations, works on automatic lathes, 3%-5% in the turning operations with a single tool, cutting with a circular saw.

For works on **Aluminium, copper and their alloys** 5% in the tapping, turning, boring, drilling, milling and cutting with circular saw operations.

Liquid FEATURES:

- Appearance: milky
- Relative density: about 0.90 gr/ml
- Viscosity at 40°C: 8.5 mm²/s
- Emulsion pH: 7.8
- Refractometric factor: 1.2