



Metalworking **LACTUCA 3000 IN**



Chlorine free water soluble cutting Fluid

PRODUCT PROFILE



- Lactuca 3000 IN is made out of specialty esters, rust inhibitors, biocides and EP additives. The superior anti-wear characteristic ensures quick swarf removal, thereby increasing tool life and productivity.

APPLICATIONS

- Lactuca 3000 IN is designed for use in most production engineering application, conventional machining (stand alone and centralized system) application
- Recommended for both ferrous and non ferrous metal machining operations.
- Exhibits satisfactory results in carbon steel.

ADVANTAGES

- Excellent emulsion stability helps in achieving longer coolant life
- Extreme pressure property helps in improving productivity
- Reduces wheel dressing and improves tool life by avoiding welding of metals.
- Improves shelf life of machined components due to higher degree of corrosion protection.
- Extremely low foaming nature helps in better component visibility and continued lubrication
- Free from malodours reduces down time and operational cost
- Operator and environment friendly as it is chemically stable and non toxic.

Typical Characteristics	Reference Methods	LACTUCA 3000 IN
Colour	Visual	Light brown liquid
Density at 29.5°	ASTM D 1298	0.88
Flash point PMCC, C	ASTM D 93	155
pH of 5 % soln	ASTM D 70	8.9
Emulsion stability	IS 1115	Passes
Cast iron corrosion test	IS 1115	0/0/1
Refract meter correction factor	Internal	0.86

Above characteristics are mean values given as an information.

TOTAL OIL INDIA PVT. LTD.

Head Office : 3rd Floor, The Leela Galleria, Andheri-Kurla Road, Andheri (E), Mumbai - 400 059. Tel. : 022 66407700 Fax : 022 66407720
Regional Offices : Chennai Tel. 044 28412790/28412823, Mumbai Tel. 022 25705775/6/7, Noida Tel. 0120 2516794/5/6, Kolkata Tel. : 033 66228200 / 8209

Date 01/12

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RECOMMENDED DILUTION CHART

Operation	Cast Iron	Stainless Steel	Non Ferrous
Turning	3- 4 %	4- 5 %	4- 5 %
Drilling	3- 4 %	4- 5 %	4- 5 %
Boring	3- 4 %	4- 5 %	4- 5 %
Milling	3- 4 %	4- 5 %	4- 5 %
Tapping	4- 5 %	5- 7 %	6- 8 %
Grinding	3- 4 %	3- 4 %	2- 3 %
Sawing	4- 6 %	5- 7 %	6- 8 %
Screw cutting	4- 6 %	5- 7 %	6- 8 %

To attain best results, the following procedure is suggested

A) Pre System Cleaning :

Prior to the charge of fresh coolant/emulsion ensure the whole system is thoroughly cleaned. The following steps are recommended for effective cleaning.

1. Circulate the old coolant in the system with available biocides/system cleaner for at least 2 - 4 Hrs prior to coolant change over.
2. Drain/discharge the coolant and clean the tank manually.
3. Refill the tank with minimum quantity of water along with 0.02% of system cleaner solution and circulate it for 2 Hrs. Then drain the cleaning solution.
4. Recharge the system with 0.5% of proposed coolant and circulate it for 2 Hrs. Drain the coolant completely.

B) Coolant Preparation :

1. Always add oil to water under agitation. Make sure that only clean container is used for mixing.
2. Do not use galvanized container.
3. Do not mix in machine sumps.

C) To Get The Best :

Monitor pH, concentration level regularly. Periodically remove tramp oil.

D) Disposal Of Coolant :

Never discharge the coolant directly to drain, sewer, river and streams. Follow local regulation.

REMEMBER A GOOD MIXING ENSURES LONGER COOLANT LIFE.

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