

# r.meta TS 30 PT

**r.meta TS 30 PT** is a water-miscible, semi-synthetic EP metalworking fluid based on amines and boric acid for universal application of machining operations.

## Application

**r.meta TS 30 PT** is suitable for almost any kind of machining operation of steel, grey cast, aluminium and other non-ferrous metals. Universal product for use on single machines and central systems. Due to its good flushing effect teamed up with excellent low foaming properties, the product can also very well be applied for grinding operations.

## Properties

- high EP loading – EP Reichert effect at 5 %: approx. 16 mm<sup>2</sup>
- long tool life – improved surface finish
- finely dispersed, opalescent – low topping up concentrations
- very low foaming in soft and hard water
- excellent flushing effect – clean machines
- high stability – long sump life
- long time corrosion protection stability – easy removal of tramp oils
- not subject to marking specifications – good skin tolerance
- pleasant odour
- favourable process costs

## Technical Data

Concentrate		Emulsion	
Viscosity 20 °C (mm <sup>2</sup> /s)	Content of mineral oil %	pH-value fresh preparation 5 %	Corrosion- protection (DIN 51360/1)
approx. 210	approx. 21	9,4	4 % grade 0

## Remarks

To prepare operating emulsion slowly add the coolant concentrate to drinking quality water assuring thorough mixing. Mixing can also be done by means of an automatic mixer.

Recommended mixing ratio:

Machining of steel, cast and aluminium alloys	from 5 %
Machining of alloyed steels	from 8 %
Grinding	from 4 %

The concentration of the operating emulsion can be determined by means of a pocket refractometer. The Brix value multiplied by the refractometer value equals the concentration in %. Sometimes reading of scale is more difficult with older emulsions because of the more coarse dispersivity.

## Refractometer factor

1,4

Rhenus metal working fluids are free of nitrite and secondary amines. They contain natural raw materials. Therefore, slight degradations of colour and appearance are possible, however, quality and function of the product are not affected at all.

Subject to modification of the technical data. Please refer to the material safety data sheet for additional information or contact our application engineers.

## Edition

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