Trent Cool 6500 AL

Water Soluble Formaldehyde Release Biocide Free Metalworking Fluid

Description

Trent Cool 6500 AL is a high-performance Formaldehyde release biocide free, semi synthetic watersoluble metal working fluid designed for arduous machining applications where foaming can cause concern.

Trent Cool 6500 AL is a medium oil content product created using chlorine free lubricity additives which assist in offering excellent cutting performance and a superior surface finish

Application

Trent Cool 6500 AL is an advanced, high lubricity metal removal fluid specially formulated for machining of tough ferrous and non-ferrous alloys.

Trent Cool 6500 AL is extremely low foaming and performs well in through spindle and high coolant volume delivery applications.

Benefits

Very long sump life
Ultra-low foam
Exceptional tool performance
Operator Friendly
Superior lubricity
Exceptional tool performance

Typic<mark>al Inspection Data</mark>

Properties	Inspection Data	
Appearance/ Colour	Amber Liquid	
Emulsion Type	Semi Translucent	
Density at 20°C	0.97 typical Nil foam after 5 seconds	
Foaming t <mark>endency @ 5% in 5</mark> 0ppm water		
pH Diluted @ 5%	9.6 typical	
Refractom <mark>ete</mark> r Factor	1.4	
IP 287 Corrosion Break Point, % Volume:	2.0	

Concentration Range

4-10% depending on type of operation.

Mixing

Use coolant mixing valves where possible. When mixing by hand slowly add concentrate to water whilst stirring vigorously. Coolants should not be mixed in the machine sump and avoid using chilled water.

Тор Uр

Coolant concentration may increase in use due to water evaporation. To maintain the recommended concentration, top up should be made with a more dilute concentration and not by water alone.





Trent Oil (Lubricants) Limited, Phoenix House, Kemmel Road, Bulwell, Nottingham, England NG6 9FH

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OPERATIONS	DILUTION	
Turning	4-6 %	•
Milling	4-6 %	•
Drilling	4-6 %	•
Tapping-Threading	5-7 %	•
Reaming	8-10 %	•
Deep Hole Drilling	8-10 %	•
Sawing	5-7 %	•

ciı	ng Fluid	
	MATERIALS	
	Steel	
	High Alloy Steel	
	Stainless Steel	
	Aluminium Alloys	
	Aero Aluminium Alloys	7/1
	Copper Alloys	
	Titanium	\bigcirc
	Main Application O Possible Application	

Fluid Maintenance

Poor or incorrect emulsion preparation may lead to instability and could considerably shorten the life of the emulsion. Prior to making any fresh fill, we would highly recommend full cleaning including the use of a compatible system cleaner.

Water Quality

Coolant performance can be affected by extremes of water quality. Hard water (in excess of 300 ppm CaCO3) and high levels of chlorides and sulphates can reduce the stability of emulsions and reduce corrosion protection. Please contact your Trent Lubricants area manager and they will gladly advise on local water quality.

Contamination

Where possible avoid contamination from foreign matter and other fluids. Remove swarf and tramp oil from the machine sumps frequently.

Disposal

Discarded metal working coolants may be removed by a competent waste contractor. Alternatively, the product may be treated by conventional oil separation and effluent disposal methods. Specific advice is available on request. Product concentrate or diluted fluid should not be introduced into waterways. It is advisable to consult the Local Water Authority regarding disposal.

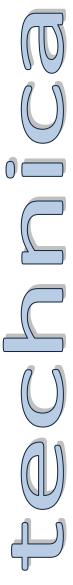
Storage

Metal working coolants should be stored indoors in clean, dry conditions. Protect from frost as the recommended storage temperature with all metal working products is between 4°C and 35°C. A shelf life of six months can be anticipated.

Health and Safety

Please refer to the relevant Trent Safety Data Sheet.

Prior to using this product, consult the Material Safety Data Sheet for instructions regarding safe handling and environmental issues. The information contained herein is based on data available to us and is believed to be accurate. HOWEVER, NO WARRANTY OF MERCHANTABILITY, FITNESS FOR ANY USE, OR ANY OTHER WARRANTY IS EXPRESSED OR TO BE IMPLIED, REGARDING THE ACCURACY OF THESE DATA. THE RESULTS TO BE OBTAINED FROM THE USE THEREOF, OR THE HAZARDS CONNECTED WITH THE USE OF THE PRODUCT. Trent Oil Lubricants Ltd. assumes no liability for any alleged ineffectiveness of the product or any injury or damage, direct or consequential, resulting from the use of this product unless such injury or damage is solely attributable to negligence on the part of Trent Oil Lubricants Ltd.



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