

## RATAK 6210

Water miscible universal metal cutting and forming fluid

### Description

RATAK 6210 is a water miscible cutting fluid based on highly refined mineral oil. When mixed into water it forms a milky, stable and bioresistant emulsion. The product offers good lubricity and normal load carrying properties.

RATAK 6210 is chlorine free RATAK 6210 is free from secondary amines and complies with TRGS 611 point 3.1, 3.2(1) I 3.2(2).

### Application

RATAK 6210 is used for cutting of wide range of materials, including steel, cast steel, grey cast iron as well as for metal forming applications.

Recommended concentration

coarse machining and metal forming 5 – 15 %

normal machining 5 - 10%

### Benefits

- good surface after machining
- optimum wetting, cooling and flushing performance
- low foaming
- excellent corrosion protection
- high cutting performance
- stable in hard water

### Storage conditions:

Store in sealed containers.

Maximum storage time: 6 months from production.

Store under roof in dry conditions, at temperature range of + 5 - + 40 °C.

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### Typical chemical and physical properties

| Property                             | Unit                | Data  | Test method  |
|--------------------------------------|---------------------|-------|--------------|
| Density at 15 °C                     | g/ml                | 0,893 | DIN 51 757   |
| Color Index                          |                     | 3     | DIN ISO 2049 |
| Kinematic viscosity at 40 °C         | mm <sup>2</sup> /s  | 40    | DIN 51 562-1 |
| Corrosion test emulsion ≥ 10,0 %     | degree of corrosion | 0 – 0 | DIN 51 360-2 |
| pH-value 10 % emulsion (Water 20 dH) |                     | 9,5   | DIN 51 369   |
| Handheld refractometer factor        |                     | 1,0   | FLV-T 5 *)   |

\*) FLV = Test procedure of FUCHS SCHMIERSTOFFE GMBH

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