

Technical Data Sheet



Water-Based Micro-Emulsion additive package HD360

Overview

HD360 Water-Based Micro-Emulsion additive package is formulated with high-efficiency rust inhibitors, emulsifiers, extreme-pressure lubricants, specialized amines, and a bactericidal system. The cutting fluid prepared with this additive demonstrates stable performance (no layering), excellent emulsification, superior lubrication and rust prevention, improved machining accuracy, extended equipment lifespan, and effective bacterial suppression to prolong working fluid service life. The semi-synthetic micro-emulsion cutting fluid made by this additive package is suitable for the processing of iron castings as well as various non-ferrous and ferrous metals. This product does not contain toxic substances.

Formulation:

Recommended formula ratio for products

Product	Dosage	Refractive Index of Stock Solution	Rust prevention method
HD360 Water-Based Micro-Emulsion Compound Agent	40%	Refractive index 36	(5% concentration) ± 35°C cast iron chips pass test within 2 hours.
Tap water	60%		
HD360 Water-Based Micro-Emulsion Compound Agent	50%	Refractive index 45	
Tap water	50%		
HD360 Water-Based Micro-Emulsion Compound Agent	60%	Refractive index 53	
Tap water	40%		
HD360 Water-Based Micro-Emulsion Compound Agent	70%	Refractive index 60	
Tap water	30%		

Note:

This product is mainly used for processing ferrous metals such as cast iron. If processing aluminum alloy, it is necessary to add 1.2% A8 aluminum antioxidant and 1.2% A9 aluminum antioxidant.

Properties of Final Product

Concentrate: Golden-yellow liquid, concentration around 50%

5% Dilution: Milky-white emulsion, PH 9.0–9.5

Applications

Suitable for general-purpose products primarily involving aluminum-based materials. Offers excellent compatibility and performance in machining processes.

GuangZhou Rolitom Lubricant Technology CO.,LTD

ADD: Room 610 NO.1 XiangPu Street, TianHe District, Guangzhou City, China

Tel: 0597-3210807, 86-13826030637

Website: www.rolitom.com