

LACTUCA 5304 S



METALWORKING



TOTAL

Heavy-Duty, Macro-Emulsion for Ferrous and Non-Ferrous Metals.

APPLICATIONS

- **LACTUCA 5304 S** is a heavy duty, chlorinated oil which was designed to perform satisfactorily in all of the most severe machining operations. By design, this product releases chlorine to form a pressure resistant barrier between the workpiece and die. This barrier prevents abrasion of the workpiece and extends the life of the die.
- **LACTUCA 5304 S** is fortified with the latest technology in chlorinated extreme pressure agents which provide long tool life and high production rates. It forms a light blue emulsion, which is very stable in hard water and leaves an oily residue.
- **LACTUCA 5304 S** is used on all cutting operations on all ferrous and non-ferrous metals. It is highly recommended for machining all carbon steels, stainless, high nickel steels, aluminum, brass, and copper. Non-ferrous metal parts should be cleaned soon after manufacture.
- Operations include: machining such boring, drilling, milling, turning, sawing, thread rolling, gear hobbing, tapping, broaching, grinding, and stamping.

ADVANTAGES

- Resistant to microbiological growth.
- Extreme pressure and anti-wear agents.
- Increases tool/die life, prevents ridging, promotes good surface finish.
- Excellent lubricity properties--Increases the tool/die life on a large scale of cutting parameters maintaining an additive layer on the chip / die / workpiece / tool surface.
- Excellent corrosion protection for parts and machinery.
- Contains no nitrites, PCB's, mercurials, phosphates or phenols.
- Low foaming.
- Settles fines rapidly and keeps wheels clean when grinding.

TYPICAL CHARACTERISTICS	LACTUCA 5304 S
Appearance	Dark Blue Liquid
Copper Strip Corrosion	1A - 1B
Density @ 60 °F, lbs./gal.	8.34
Specific Gravity @ 60/60 °F	1.0
Sulfur, %wt.	None
Chlorine, %wt.	12.0
pH @ 1:9 (10%)	9.0
Refractive Index Factor	1.0

Standard dilution of water to oil is 10:1. May be mixed satisfactorily from 10:1 to 3:1 depending on the type and severity of the operation. The concentration should be adjusted as necessary to maximize performance. When preparing mixtures, ALWAYS add **LACTUCA 5304 S** to water and not vice-versa.

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