

# Adrana D 408

## Water Miscible Metalworking Fluid

### DESCRIPTION

Adrana D 408 is recommended for light to medium duty operations over a broad water hardness range, for general machining operations on cast-iron, steel and aluminum alloys. Adrana D 408 is also suitable for machining of copper alloys.

### RECOMMENDED CONCENTRATIONS

The concentration varies depending on the type of machining operation, the water hardness and the required inter-operational corrosion protection. The recommended concentration for use in medium water hardness is:

- General machining                      5 – 7 %
- Heavy Duty machining                 8 – 12 %
- Grinding                                    4 – 5 %

### DATA (TYPICAL VALUES)

	Unit	Method	Adrana D 408
Mineral Oil Content	%		30
Density at 20°C	kg/dm <sup>3</sup>	ASTM D 1298	0.98
pH of the Emulsion at 5 %		DIN 51369	9.07
Min.Anti-Cor. Protection Limit (0-0)	%	DIN 51360/2	5.0
Refractometer factor			1.40
Acid Split Factor			1.53

Date | version  
Code

### FEATURES/ BENEFITS

- Low foam in soft water
- Good stability ensuring prolonged sump life
- Good corrosion protection
- Good detergency offering low drag out, clean parts and machine tools, a better working environment
- Operator friendly
- Enhanced lubricity provides extended tool life and reduces tooling cost.
- Provides improved part finish which reduces overall cost through reduced rework and scrap rates
- Allows grinding wheels to run clean with less loading which saves money by extending time between wheel dressing and wheel changes.
- Provides enhanced corrosion inhibition eliminating costly machine tool repair and scrap rate.

### HEALTH AND SAFETY

Refer to MSDS for proper handling and disposal. Please note that the MSDS includes handling, health and disposal information which should be passed on to your employees, and to anyone else who comes in contact with our product. Additional advice can also be obtained from your local Houghton representative.

NOTE: Read and understand all precautions on container labels before using this product.



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