

Product	Type
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COOLSURF™ RCO-70
Metal Processing
Ethanolamine-free alkanolamide
Application

Coolsurf RCO-70 is an amide resulting from the reaction of diisopropanolamine and a vegetable oil rich in oleic acid

Coolsurf RCO-70 is an excellent co-emulsifier providing excellent oxidative stability, good boundary lubrication, high reserve alkalinity and excellent corrosion protection for soluble oils, semi-synthetics, synthetics, and cleaners.

Typical Properties

Test	Typical
Appearance	Amber, viscous fluid
Specific gravity at 15.6° C	0.96
pH at 1%	10
Total base number mg KOH/g	50
Water wt. %	3

Benefits

- Water soluble and dispersible in oil
- Very low foam
- High reserve alkalinity
- Good emulsifying properties
- Boundary lubrication and oxidative stability
- Non-staining on aluminum
- Excellent hard water stability
- Dispersible in oil and water

Suggested Formulation Details

Semi-synthetic fluid concentrate

PART I

First: Prepare the oil phase as follows

100 SUS naphthenic oil	63.0%
Coolsurf RCO-70	14.0%
Counter Rust™ HW-100	2.0%
Tall Oil 25/30 rosin acid	8.0%
Glycol Ether TPnB	8.0%
TMP oleate.....	5.0%

PART II

Second: Add oil phase into water while mixing

Water	20% - 35%
Counter Rust T-43	11.5% - 12.5%
Part I (Oil Phase)	50% - 65%
Defoamer	0% - 0.2%
Fungicide	0% - 1.0%

RECOMMENDED USAGE

	<u>Fluid Concentrate</u>	<u>Water</u>
General Machining	5 – 7%.....	Balance
Heavy-Duty Machining	10 – 12%.....	Balance

Storage and Handling

Recommended Maximum Long Term Storage Temperature	Ambient
Recommended Minimum Temperature for Use	Ambient
Flash Point	>190° C COC



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