

LACTUCA DDC 5000



Metalworking

Extreme pressure macro-emulsion without formaldehyde for difficult machining operations.

UTILISATIONS

- **LACTUCA DDC 5000** provides all the main functions of efficient cutting fluids making it possible to perform all types of difficult machining on ferrous and non ferrous metals.
- **LACTUCA DDC 5000** contains an extreme pressure chlorinated paraffin based additive and is adapted for performing difficult machining. The extreme pressure additive reduces friction between chips and the tool, ensuring good surfaces and increasing tool lifetime.
- Recommended rate of use:
 - severe machining: 5 to 9%
 - very severe machining: 7 to 12%
 - gear cutting **LACTUCA DDC 5000** : 10 to 15%

SPECIFICATIONS

ISO 6743/7

- ISO-L-MAD

ADVANTAGES

- **LACTUCA DDC 5000** is very easy to use, simply by pouring it into good quality water.
- Excellent cooling and lubricant power.
- Efficient protection of machined parts and machines against corrosion.
- Good mechanical performances, providing:
 - Reduced cutting efforts
 - Extended tool lifetime
 - Very good surface finish to parts.
- Properties in service:
 - Excellent stability over time increases drain intervals;
 - Cuttings have low rate of humidity;
 - Good anti-foaming properties.
- Resist to the development of bacteria and mould very well, so is more environmentally and operator friendly.
- Highly efficient on very difficult applications thanks to chlorinated extreme pressure additives.

HEALTH AND SAFETY

- Free of formaldehyde liberators and boron.
- Free of PTBB, nitrites, NPE, DEA.
- Contains chlorinated paraffins.

TYPICAL CHARACTERISTICS	METHODS	UNITS	LACTUCA DDC 5000
Density at 15 °C	NF T 60101	Kg/m ³	998
Kinematic viscosity at 40 °C	ISO 3104	mm ² /s	99
Appearance of emulsion	visual		milky
pH of emulsion at 5%	NF T 60193		9.2
Refractometric factor	NF T 60193		0.96

The values of the characteristics featured on this table are typical values given as indications only.

RECOMMENDATIONS FOR USE

- To ensure good conservation of the fluid's properties through time and thus increase its lifetime, we recommend:
 - Regular monitoring of the concentration of the bath with a refractometer. Do not forget to multiply the reading value by the refractometric factor.
 - Regular monitoring of the pH of the emulsion and the hardness of the water.
- Total offers its clients a regular laboratory fluid analysis service: *SOLUBLE CHECK*.
Get in touch with your sales contact to obtain further information.
- Before using any fluid for the first time or before each change, we recommend cleaning the machine with a specific cleaning product: *CONTRAM CB 3*.
- If punctual top-ups of Biocide are required, Total offers an efficient product: *EBOTEC BT 80*.

Your sales and technical contacts are ready to provide you further information.