



HNTI Limited

Harkool M50

Product Datasheet

Description

HARKOOL M50 is Nitrite free high-performing coolant designed to reduce coolant consumption, pro long system life and meet your machining needs when working with a wide range of materials like aluminium, cast iron or other ferrous alloys.

Typical Characteristics

Properties	Results	Method
Appearance	Clear Amber Liquid	Visual
Density @ 29.5°C, g/mL	0.89	ASTM D 1298
pH of 5% in DI Water	9.2	ASTM E70
Viscosity at 40°C, cSt	50	ASTM D 445
Flashpoint COC, °C	160	ASTM D 56

Benefits

- Chlorine and nitrite free to fulfill your local legislation, waste treatment and environmental requirements
- Low foam in recommended water conditions
- Excellent wetting properties reduce coolant drag out and deliver clean machine tools and components
- Resists fungal and bacterial attack to extend fluid life and reduce maintenance and machine downtime
- Lubrication package specifically designed to enhance tool life and improve surface finish in components.

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Application

	Aluminium	Low alloy to high alloy Steel	Cast Iron
General Machining	✓	✓	✓
Reaming	✓	✓	✓
Honing	✓	✓	✓
Broaching	✓	✓	✓
Tapping	✓	✓	✓
Grinding	✓	✓	✓

Operating Conditions

Temperature	Ambient
Concentration	5 to 10%*
pH @ 29.5°C	9 - 10
Water TDS	0- 400 ppm

Solubility

When mixed with water, they form a milky emulsion that is an excellent choice for general purpose machining.

Storage

Store in (34 to 122°F / 1 to 50°C), dry place and away from sunlight in original packaging for up to 6 months from the date of manufacture.

Safety & Warning: Review Material Safety Data Sheet for appropriate health and safety warnings before use.

Spillage : Flush with water. Clean and dispose of in accordance with federal, state, or local regulations.

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