



Eco friendly machining



Characteristic

- Usable for
 - Non-alloy Steel
 - Low-alloy Steel
 - Special steel to carbon
 - Brass
 - Aluminium
 - Copper
- Compatible with micro pump systems (VIP4)
- Compatible with Venturi systems (MKD)
- Greater duration to the tools job
- Decrease cycle time

MK 100

MLQ oil used in minimal systems for all the alloys of good tough ability

This is a neat multipurpose machining oil. It is very fluid and does not contain any mineral oils. It has been designed for plastic deformation procedures, for shearing steel plates and strips, and for traditional chip-removal operations which employ mineral oil fogging lubrication systems.



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It is made up of a synthetic ester mixed with greasing compounds, antioxidants and metal passivators.

Working synergetically, these ingredients ensure:

- the absence of fumes or vapors during the machining operations;
- a high flashpoint and absolute safety;
- an excellent fluidity, even at low temperature and a superb wetting power,
- thanks to which the oil spreads over metallic surfaces quickly and uniformly;
- outstanding greasing and detacking power, for high quality finish;
- good resistance to oxidation and rust;
- good antiwear properties;
- an excellent antiwelding power;
- heat removal efficiency even at low temperatures of the pieces being machined.

This product does not contain chlorinated derivatives.

Ideal for

Good tough ability

Applications

- Plastic deformation procedures
- Shearing
- Steel plates and strips
- Chip-removal operations

Order Informations

INFORMATIONS ON SPECIFIC WEIGHT AND DIMENSIONS

PART NUMBERS	DESCRIPTION
3226665	MK 100 19,38 Liter Pack

AVERAGE CHEMICAL AND PHYSICAL PROPERTIES

Density a 20° C	ASTM D 1298	0,877 Kg/lt
Viscosity a 40° C	ASTM D 445	11,3 cSt
Viscosity a 100° C	ASTM D 445	3,41 cSt
Viscosity Index	ASTM D 2270	199
Flashpoint	ASTM D 92	210°C
Pourpoint	ASTM D 97	<15°C



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Systems MQL Informations

MINIMAL QUANTITY LUBRICATION (MQL) & NEAR DRY MACHINING

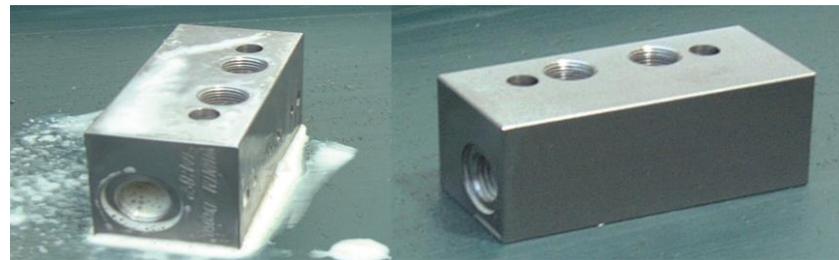
The aim of near dry machining is to replace traditional coolant and pure oil flood systems in a machining environment with an accurately controlled compressed air stream that carries minimal quantities of oil lubrication in an "aerosol" format to the cutting surface. This ensures lubrication of the cutting surface and allows for high performance machining.

Lubricating Aerosol is transported to the cutting surface in two ways:



With **External** Lubrication: oil is transported via a nozzle to the cutting surface. Dropsa has a complete product line from simple, easy to install products such as the **Grip** and **Vip4Tools** series for External lubrication (please ask for documentation).

With **Internal** or "**through-the-tool**" lubrication: oil is transported through internal lubrication holes in the cutting tools. The **MKD-Dual** product leads the way with patented technology that generates specifically profiled micron-sized oil aerosol particles that can be injected through existing spindles and tool-holders to the leading edge of the cutting tool.



Coolant is eliminated



Cycle times are reduced



Tool life is increased

THE BENEFIT OF DROPSA NEAR-DRY MACHINING TECHNOLOGY

- Reduce work cycle times, generally by **25% to 80%**.
- Increase tool life thus increasing time between tool change and gain productivity.
- Better surface finish and tolerances can be achieved.
- Eliminate coolant – make your plant more environmentally friendly.
- Parts finish machining with a mild rust inhibiting oil coating – not coolant contamination.
- Water and oil consumption drastically reduced.
- Our technology works on diverse materials and machining operations.
- Eliminate capital cost of high pressure thru-tool coolant system on new systems.
- Side-by-side Implementation parallel to existing coolant system gives you peace of mind and maximum flexibility.
- MKD DUAL Uses Patented Auto-adaptive technology eliminating complex and continual adjustment between tool change.
- No complicated electronic control systems needed thanks to the patented Auto-adaptive system



**ADVICE ON TOOLING
AND APPLICATIONS AVAILABLE**