



TOWERSOL 340-MG

DESCRIPTION

TOWERSOL 340-MG is a high-performance mineral oil and chlorine-free based metalworking fluid especially designed for use on magnesium and magnesium alloys. The unique chemistry will provide performance and emulsion stability which is so critical when machining magnesium. **TOWERSOL 340-MG** is designed to produce stable emulsions without splitting in hardness up to 5500 ppm. **TOWERSOL 340-MG** does not contain additives based on sulfur, chlorine, phosphorous or boron and provides excellent corrosion protection for ferrous and non-ferrous metals and machine tools. It is suitable for other non-ferrous alloys including brass and bronze as it will not form insoluble lead soaps. For high zinc containing alloys (which have a propensity to stain) it is recommended to test for staining before use.

USAGE

Starting dilutions for machining operations should be between 5 to 10% and grinding 4 to 6%. Make-up fluid is typically added at half the target concentration. For proper mixing it is recommended that **TOWERSOL 340-MG** concentrate is added **to** water with agitation.

PHYSICAL CHARACTERISTICS

Density:	7.69 lb./gal
Concentrate appearance:	Yellow fluid
Emulsion appearance:	Milky, white and stable
Odor:	Mineral oil
pH @ 10% in DI water:	9.4 – 10.2
Mineral oil content:	> 50%
Refractometer factor:	1.0

BENEFITS

- **Non-hazardous, no pictograms on the label**
- **Low odor and light color**
- **Stable emulsions in hard water**
- **Rejects tramp oil**
- **Excellent surface finish**
- **No chlorine or sulfur-based additives**
- **Maintains stable pH values**
- **Machines run clean without sticky residues**

TECHNICAL SUPPORT

This is a Proprietary product. TOWER wants to assist you in evaluation and selection of suitable products. We urge you to take advantage of this service. This information sheet and TOWER's assistance, however, are not a substitute for your own testing and evaluation.