

## **SYNTHETIC MICROEMULSION METALWORKING FLUID**

**XL-5300** is water-based synthetic micro-emulsion metalworking fluid, recommended for preparing functional fluids for use with various ferrous and non-ferrous metals. **XL-5300** is non-corrosive to most metals.

**XL-5300** has proven performance successes in both metal removal and metal forming operations.

### **APPLICATIONS**

- Drilling
- Boring
- Broaching
- Threading
- Tapping of High Carbon
- Steel
- Aluminum and Aluminum alloys.
- Deep Hole Gun drilling.
- Metal Forming and Stamping

### **BENEFITS:**

- Excellent EP/anti-wear properties
- Good surface finish
- Improved die life
- Excellent rust inhibition
- Environmentally acceptable
- Ease of disposal
- Does NOT contain chlorinated paraffins or phosphorous.
- Easily removed by aqueous cleaners

### **DILUTION:**

**XL-5300** should be diluted in tap water for the following applications:

- General metal removal: 5%
- Heavy duty metal removal: 10%
- Metal Forming (Stamping): 10-20%
- Metal Forming (Drawing): 10-50% (Depending upon the severity of the draw)

### **CONTROL CHARACTERISTICS:**

Boron	0.015 %wt.
Nitrogen	0.75 %wt.
Calcium	3.2 %wt.
Sulfur	0.2 %wt.
Specific Gravity	1.038 g/ml



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