



# FLUIDS WITH A SHARPER EDGE

## AMPLIFI 40000

### Product Description

AmpliFi 40000 is an ester based cutting fluid having no mineral oil content. The cutting fluid is manufactured using specialty esters that provide excellent tool life, excellent extreme pressure performance, superior wettability of the parts, improved cleanliness of the machines & parts, infinite sump life and longer corrosion prevention after processing.

The AmpliFi Series truly amplifies the performance during operation and provides economies of cutting tool costs, improvement in product finish & quality enhancement and corrosion and stain prevention upon use. The product has unlimited tank life and no bacterial fouling due to absence of mineral oils in the product. The presence of defoamers controls the foaming of the fluid during operation.



### Advantages

- Longer Tool Life
- Rapid Heat Dissipation
- Rejects Tramp Oils and prevents contamination
- Infinite Sump Life – No bacterial or fungal attack
- No fouling or Monday smell
- Excellent Machine Cleanliness
- Improves Part Millipore
- No Foaming
- Higher Corrosion Protection after machining

### Dosage

Operation	Dosage	Refractrometer Reading
Heavy Duty machining	5%	2.7-2.8
Grinding	2%	1.1-1.2

A PRODUCT OF:  
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Chemical Parameters	
Total alkalinity (%KOH)	10.8
pH @ 5 % Concentration in	
Deionised water	9.45
200ppm Hard water	9.33
500 ppm Hard water	9.32
Performance Parameters	
Emulsion Stability - @ 5% concentration in	
Deionised water	Translucent, Stable O/N
200 ppm Hard water	Semi Translucent, Opaque Stable O/N
500 ppm Hard water	Semi Translucent, Opaque Stable O/N
1000 ppm Hard water	Opaque-Milky, Trace scum O/N
Spec - 19 Hard water	Opaque-Milky, Trace scum O/N
Defoaming by Cylinder Shake Test @ 5% in 50 ppm	Nil after 8 sec.
CNOMO Test @ 5 % in 50 ppm	300/200/20/1/4
TOYODA Demulsification (Tramp Oil Rejection)	90/1/9
Corrosion Test - IP 287 (Chip/Filter Paper Method)	2.5% Break Point
Corrosion Test - IP 287 (Chip/Filter Paper Method)	3 % Clean Paper
Multimetal Corrosion Test - Aluminium 6 Alloys.	Moderate staining
Taping Torque Test	
Max Torque	206.0
Mean Torque	162.0
Delta T	6.87
Brix Multiplication Factor	1.80 ( 2.8 Refractometer Reading X 1.8 Brix Factor = 5% Concentration)
Suitable For	Ideal for Ferrous Metals Compatible with other metals – trial recommended