



COOLANT CONTROL^{INC.}

The right chemistry...

...the right solution

Product Bulletin

Orion 7116

Heavy Duty Synthetic Cutting and Grinding Fluid

Description

Orion 7116 is a moderate pH synthetic fluid developed for the heavy duty machining of aluminum alloys including aerospace alloys and titanium. The unique proprietary lubricants in **Orion 7116** were designed for high speeds and feed rates and provides extremely high lubricity in a variety of aluminum machining operations. This oil-rejecting fluid outperforms conventional coolants in difficult operations such as tapping and gun drilling. **Orion 7116** provides excellent bimetallic corrosion protection to keep parts and machine tools free from in-process rust. In hard or soft water, **Orion 7116** forms a stable solution that will not foam. **Orion 7116** is a clean fluid that runs with trouble-free dependability.

Performance Benefits

- Increased lubrication verses other synthetic fluids
- Rejects tramp oils for easy skimming
- Biostable formula extends fluid life
- Low foaming in all water conditions
- Excellent lubrication allowing for moderate machining
- Excellent corrosion protection protects parts, machines and tools
- Settles chips quickly for a clean work environment

Recommended Applications

| Application | Concentration |
|-------------|---------------|
| Machining | 7% to 12% |

5% is the minimum concentration to protect equipment from corrosion

Typical Characteristics

| | |
|---|---------------------|
| Appearance | Clear yellow liquid |
| Specific Gravity @72F | 1.04 to 1.07 |
| pH (Neat) | 9.0 to 10.0 |
| pH (typical operating concentration) | 9.0 to 10.0 |
| Tap Torque, 800 RPM, Titanium @ 10%, standard deviation | 112.2 |
| RI factor | 1.78 |