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Product Bulletin

Orion 7116B

Heavy Duty Synthetic Cutting and Grinding Fluid

Description

Orion 7116B is a moderate pH synthetic fluid developed for the heavy duty machining of aluminum alloys including aerospace alloys. The unique proprietary lubricants in **Orion 7116B** 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 7116B** provides excellent bimetallic corrosion protection to keep parts and machine tools free from in-process rust. In hard or soft water, **Orion 7116B** forms a stable solution that will not foam. **Orion 7116B** 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 blue liquid
Specific Gravity @72F	1.04 to 1.07
pH (Neat)	9.0- 10.0
pH (typical operating concentration)	9.0-10.0