

### WS 8025

#### GENERAL DESCRIPTION

WS 8025 is a light to medium-duty, oil-rejecting synthetic machining and grinding fluid formulated for use on ferrous metals. This product does not contain chlorinated, sulfurized, or phosphorus-containing additives or DEA. WS 8025 is fortified against attack from micro-organisms.

#### PERFORMANCE BENEFITS

- Superior Tool Life
- Non-Tacky Residue
- Excellent Sump Life
- Operator Friendly
- Non-Foaming
- Excellent Corrosion Protection

#### TYPICAL PROPERTIES

Appearance..... Clear Blue Liquid  
pH Value, 5% solution..... 9.0  
Density, lbs/gal..... 8.54  
Refractometer Factor.....4.9

#### RECOMMENDED CONCENTRATION

#### REFRACTOMETER READING

Surface Grinding.....	3 - 5 %	0.6 - 1.0
Cylindrical Grinding.....	4 - 6 %	0.8 - 1.2
Centerless Grinding.....	3 - 5 %	0.6 - 1.0
CNC Machining.....	6 - 10%	1.2 - 2.0

#### CONCENTRATION CALCULATION

% Concentration = Refractometer Reading x Refractometer Factor

Note: Always calibrate the refractometer so that it reads 0.0 with water that will be mixed with the machining coolant.

### **THE EFFECTS OF WATER QUALITY ON EMULSION STABILITY**

To obtain the best performance from any water miscible metalworking fluid, good quality water is essential. Water hardness is a key determinate of water quality. It is typically measured in parts per million (PPM) of calcium carbonate and varies by region of the country. The ideal water hardness range is between 75 PPM and 175 PPM. For soft water (less than 75 PPM), the metalworking fluid may foam. Exceptionally hard water (above 200 PPM) can have a de-stabilizing effect on the coolant. For high water hardness, we recommend using the hard water version of our coolant. In addition to water hardness, high levels of chloride ions can adversely affect the rust inhibiting characteristic of a coolant. Our lab can help you determine the quality of your water.

### **MIXING INSTRUCTIONS**

- Always pre-mix coolant before adding it to the machine.
- If mixing by hand, always **add the coolant concentrate** to water, then agitate.
- For best results, a proportioner should be used.
- Since water evaporates from the coolant, the concentration will increase over time.  
To maintain the recommended concentration, makeup coolant should be pre-mixed at half the % concentration as the initial fill.

### **HEALTH & SAFETY**

Material Safety Data Sheets are available for all Wallover products. Consult the MSDS for information regarding the storage, handling and disposal of a product.

### **WARRANTY**

All reasonable effort has been made to ensure that the information provided in this publication is accurate. No warranties are expressed or implied since the use of this product is beyond our control.