

# LACTUCA MU 68



*Metalworking*



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**Multifunctional soluble cutting fluid for machining and lubrication.**

## UTILISATIONS

- **LACTUCA MU 68** is designed for routine machining of non ferrous metals and fine carbon steels.
- Recommended rate of use: 4%.
- **LACTUCA MU 68** can also be used in hydraulic circuits and lubrication systems, rails, mechanical transmissions (ISO grade: 68).

## SPECIFICATIONS

ISO 6743/7

- ISO-L MAB

## ADVANTAGES

### In emulsion at 5%:

- **LACTUCA MU 68** is very easy to use, simply by pouring it into good quality water.
- Excellent cooling and lubricant power.
- Efficient protection of machined parts and machines against corrosion.
- Good mechanical performances, providing:
  - Reduced cutting efforts
  - Extended tool lifetime
  - Very good surface finish to parts.
- Properties in service:
  - Excellent stability over time increases drain intervals;
  - Cuttings have low rate of humidity;
  - Good anti-foaming properties.
- Resist to the development of bacteria and mould very well, so is more environmentally and operator friendly.

### Direct use of concentrate:

**LACTUCA MU 68** can be used directly in concentrate form, for rail type applications, with the following properties:

- Excellent hydrolytic stability
- Good compatibility with seals.
- Detergent, dispersive.
- No reaction with a large number of paints.
- Compatible with a large number of mineral lubrication oils.

This specific application of **LACTUCA MU 68** solves your problems of incompatibility due to lubrication oil leaking into baths of soluble cutting fluids. Less maintenance, cleaner machines, fewer bad odours, leading to savings on installation running costs.

## HEALTH AND SAFETY

- Free of formaldehyde liberators and boron.
- Free of chlorine, PTBB, nitrites, NPE, DEA.

TYPICAL CHARACTERISTICS	METHODS	UNITS	LACTUCA MU 68
Appearance	ISSO 2049	-	Slightly cloudy
Density at 15°C	ISO 12185	kg/m <sup>3</sup>	926
Colour	ISSO 2049	-	4,5
Viscosity at 40 °C	ISO 3104	mm <sup>2</sup> /s	68
Flash point	ISSO 2592	°C	183
Pour point	NF T 60105	°C	- 24
<b>Mixed in water at 5%:</b>			
pH	NF T 60 193	-	8,7
Aspect	Visuel	-	Milky
Corrosion: non ferrous, aluminium, copper, brass, bronze	CNOMO D635223	-	0/0
Ferrous corrosion	NF T 6186	-	0/0
Correction factor	-	-	1

The values of the characteristics featured on this table are typical values given as indications only.

## RECOMMENDATIONS FOR USE

- To ensure good conservation of the fluid's properties through time and thus increase its lifetime, we recommend:
  - Regular monitoring of the concentration of the bath with a refractometer. Do not forget to multiply the reading value by the refractometric factor.
  - Regular monitoring of the pH of the emulsion and the hardness of the water.
- Total offers its clients a regular laboratory fluid analysis service: *SOLUBLE CHECK*.  
Get in touch with your sales contact to obtain further information.
- Before using any fluid for the first time or before each change, we recommend cleaning the machine with a specific cleaning product: *CONTRAM CB 3*.
- If punctual top-ups of Biocide are required, Total offers an efficient product: *EBOTEC BT 80*.

Your sales and technical contacts are ready to provide you further information.