



## TYPICAL PROPERTIES

Appearance: Amber liquid  
pH: 9.0  
Operating temperature: 70°F  
(21°C) - 130°F (54°C) maximum

## SHIPPING

Rolube 6001 is shipped in 1 gallon plastic jugs, 5 gallon plastic buckets, or 55 gallon closed head plastic drums.

# ROLUBE 6001

ROLLING MILL LUBRICANT /  
COOLANT FOR COPPER/BRASS

## Description

Rolube 6001 is engineered specifically for cold rolling copper and brass. It easily forms an emulsion with water. It is designed to allow separation of tramp oil and metal fines with minimum staining of Copper and Brass surfaces. During the annealing process Rolube 6001 has excellent burn off characteristics. Rolube 6001 is resistant to bacterial degradation and contains no phenols, PCBs, nitrites or heavy metal compounds. Rolube 6001 also functions as a drawing and stamping compound for brass, copper and aluminum.

## Recommended Application

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Concentration (% by volume with water)

Temper Roll: 0.5 - 3.0 Intermediate: 3.0 - 5.0  
Breakdown: 5.0 - 8.0

## Benefits

- Low viscosity, high polarity
- Leaves very little residue
- Not affected by aluminum, copper or zinc

## Storage

Do not freeze. Mix prior to using if separation occurs. Keep drums closed when not in use.

## Application

The water properties needed to form an emulsion with Rolube 6001 is pH of 6.9 - 7.6. Total hardness of water should be 100-275 Ppm as Ca Co<sub>3</sub>. The pH of working bath will normally buffer off to 8.5 - 9.0 and will remain there. Concentration of the rolling emulsion should be maintained using a refractometer. It will give you direct concentration reading.

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