



## FS 386 LF

FS 386 LF is a heavy-duty, high-oil metalworking fluid that is exceptionally low foaming. It is formulated to fit the all-purpose needs of both large and small plant operations and may be used in hard or DI water applications (however, DI water is the best). Those wishing to utilize one coolant for heavy-duty machining and grinding of all metals, including automotive cast 319 aluminum, should seriously consider this formulation.

FS 386 LF contains unique extreme pressure additives that provide excellent lubricity, form clean and stable emulsions, and keep the machine and tool surfaces residue free. The synergistic effect of these chemistries also make this coolant exceptionally resistant to biological growth. In independent studies, FS 386 LF outperformed the leading bio-stable coolant and is now being considered the new standard for laboratory testing and evaluation. The product also has exceptional rust-inhibiting qualities, important to the life of the machine tool and the parts being worked.

FS 386 LF has successfully replaced several competitive soluble oils containing up to 10% chlorine in the formulation. This product is strongly recommended for anyone wishing to increase production, tool life, reduce waste, or effectively recycle metalworking fluids.

### Typical Specifications and Performance Data:

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Fluid Type	Microemulsion
Appearance of Emulsion	White
Specific Gravity @ 25°C	1.0
pH 10% in De-ionized Water	9.2
Flash Point C.O.C.	NA
Weight per Gallon	8.0 lbs.
Freeze-Thaw Cycle	Stable
Rust Protection	Excellent
Metal Staining	NA, safe on ferrous and non-ferrous metal
Chlorine	0.0%
Sulfur	0.0%
Foam	Exceptionally low in DI



### **Recommended Refractive Readings:**

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Grinding: 3.0–5.0

Drilling/Tapping: 7.0–10.0

Machining: 7.0–10.0

### **Health and Safety:**

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FS 386 LF is free of diethanolamines (DEA), diethanolamides, chlorine, and sulfur. Refer to Material Safety Data Sheet for safe handling procedures.

### **Product Availability:**

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- 5-gal. Pails
- 55-gal. Drums
- 265-gal. Mini-bulk