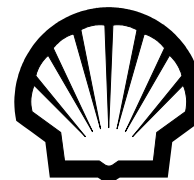


# Shell Dromus B

## New Generation, Biostable Water Soluble Cutting oil



Shell Dromus B is a highly stable oil-in-water emulsion developed for use as a cost effective, metalworking fluid. It is widely used for Aluminium machining.

### Applications

- General Machining
- Grinding
- Aluminium Machining

### Performance Features

- **Nitrite free**  
Operators' health & safety. Reduced risk of the formation of nitrosamines
- **Phenol & chlorine free**  
Environmentally safe. Low disposal costs
- **Excellent lubricity**  
High oil content provides excellent machine tool lubrication
- **Emulsion stability**  
Tolerant to difficult diluent waters
- **Corrosion inhibition**  
High level of corrosion inhibition on tool, slideways and components

### Materials

- Low to medium tensile steels
- Aluminium, copper and their alloys

### Recommended Concentrations

	%	Ratio
Grinding	2 - 3	50:1 - 30:1
General Machining, non-ferrous materials	3 - 5	30:1 - 20:1
General Machining ferrous metals	5	20:1

Concentrations may need to be increased when machining difficult materials and where the water hardness of the diluent has an effect on corrosion inhibition.

### Mixing

Shell Dromus B should be added gradually into the full volume of water - never the reverse, and gentle agitation maintained until all the oil has been added and a uniform emulsion obtained. Use lower concentration for top-up to achieve recommended mix-ratios.

### Typical Physical Characteristics

Appearance	Amber Fluid
Emulsion Type	Dense white
Density @ 15°C kg/l	0.92
pH at 5% Concentration	8.9
Corrosion Breakpoint (IP 287)	20/1

These characteristics are typical of current production. Whilst future production will conform to Shell's specification, variations in these characteristics may occur.

### Storage

The product should be stored under cover. Avoid extremes of temperature and protect from frost. Packages should be kept sealed when not in use.

Where storage of packages in the open cannot be avoided they should be kept on their side, preferably on a stillage frame or other support to keep them off the ground, to avoid the collection of water around the outlet holes which might subsequently contaminate the contents when the packages are opened.

### System Cleaner

It is recommended that a Shell System Cleaner is used to purge the machine tool coolant system prior to filling with a fresh emulsion.

### Health & Safety

Shell Dromus B is unlikely to present any significant health or safety hazard when properly used in the recommended application, and good standards of industrial and personal hygiene are maintained.

After skin contact, wash immediately with soap and water.

For further guidance on Product Health & Safety refer to the appropriate Shell Product Safety Data Sheet.

### Protect the environment

Do not discharge into drains, soil or water.