

## EMULCUT 100

### boron-free water-miscible metalworking fluid

EMULCUT 100 is an emulsion-type metalworking fluid, mineral oil and ester-containing. It gives whitish medium-disperse emulsions suitable for rough and fine machining on aluminium, steel and cast materials. Applicable in medium water-hardness range, EMULCUT 100 distinguishes by its excellent emulsion stability, requiring no post-preservation, generally. The high oil content and the effective additive system provide good rust preventability, stable pH flow as well as good filterability. The characteristics as follows:

- no biocide addition necessary under observance of the concentration stipulated
- excellent lubricity
- optimum machining results
- prolonged tool life
- good surface finish
- extreme coolant life
- low coolant supply due to good run-off properties
- very good anti-rust properties
- less foaming
- clean emulsions due to good filterability
- low skin irritation potential

#### Physical data:

Appearance		: yellowish concentrate
Density/20 °C	DIN 51 757	: approx. 0.926 g/cm <sup>3</sup>
Viscosity/20 °C	DIN 51 562/1	: approx. 191 mm <sup>2</sup> /s
Pourpoint	ISO 3 016	: < - 28 °C
pH value, 5 % (after 24 hrs in use)	DIN 51 369	: approx. 9.2 to 9.6
Corrosion protection test, 3 %	DIN 51 360/2	: grade 0

#### Concentrations recommended for use

turning, drilling, milling	5 to 7 %
sawing, reaming	7 to 10 %

#### Factors for concentration determination:

Refractometer	1.0
acid split method	1.3
acidimetric titration up to pH 4	0.80
acidimetric titration up to pH 7	1.04

Only valid in combination with EC-Safety-Data-Sheet.

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