

STAR METAL – CUT 120

mineral oil-based, water emulsifiable metalworking fluid concentrate

STAR METAL – CUT 120 is a water emulsifiable metalworking fluid concentrate that was specially developed for machining of aluminum. Its special additives and inhibitors enable the machining of conventional aluminum alloys such as e.g. 2024, 6061, 6082, 7075 and also proportionate yellow metal.

STAR METAL – CUT 120 can also be used for grinding and general machining of alloy as well as plain carbon steel and cast iron.

Product profile:

- free from boron, amine containing coolant concentrate
- free from formaldehyde releasing bactericides
- polar lubricity improves allow machining of aluminum

Product properties / advantages:

- stable emulsions in make-up water from 5 °dH to 30 °dH; fresh emulsion is stable up to 150 °dH
- low foaming emulsion in recommended make-up water
- excellent cooling and detergency properties
- very good technical stability giving long sump life
- good corrosion protection

Typical technical data:

Concentrate		Emulsion		
Kin. viscosity at 20 °C [mm ² /s]	Mineral oil [%]	pH at 5 %	Corrosion protection DIN 51360/2	Refractometer factor [%/°Brix]
200	30	9.7	5 % - degree of staining 0 (no staining)	1.3

Application:

grinding
general machining

Remarks:

Correct preparation of a fresh emulsion is ensured by slowly pouring the concentrate into water while stirring continuously. Alternatively, an automatic mixing device may be used.

The recommended concentration depends on the application and the materials to be machined:

Grinding: from 5 %
General machining: from 7 %

The concentration of the in-use emulsion may be checked using a refractometer. The refractometer reading must be multiplied by the refractometer factor to arrive at the concentration.

Based on current knowledge ZETA ME 24634 could be used for processing of most aluminum alloys. However, the tendency of the alloy to stain should be checked in advance.

Shelf life / storage conditions:

stable for 12 months when stored at a temperature of 5 °C to 40 °C in unopened containers

Comments:

Minor variations in color, odor and appearance are possible due to the raw materials chosen. However, these have no influence on the functionality of the product.

All information on safe and proper handling can be found on the SDS.

For further product information, please contact our sales representative or technical support.