

## STAR METAL – CUT 140

mineral oil-based, water emulsifiable metalworking fluid concentrate

**STAR METAL – CUT 140** is a water emulsifiable metalworking fluid concentrate, specially developed for grinding and general machining of cast iron.

Due to the special design STAR METAL – CUT 140 can also be used for machining of alloy as well as plain carbon steel.

### Product profile:

- free from boron, amine containing coolant concentrate
- free from formaldehyde donators

### Product properties / advantages:

- low foaming emulsion in recommended make-up water
- produces stable emulsions in make-up water from 5 °dH to 30 °dH; emulsion in use is stable up to 60 °dH
- good corrosion protection

### Technical data:

Concentrate		Emulsion		
Kin. viscosity at 20 °C [mm <sup>2</sup> /s]	Mineral oil [%]	pH at 5 %	Corrosion protection DIN 51360/2	Refractometer factor [%/°Brix]
120	approx. 30	up to 10.1 (drops during use)	4 % - degree of staining 0 (no staining)	1.3

### Application:

grinding and 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 8 %

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.

### 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 MSDS.

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