

STAR METAL – CUT 260

mineral oil based, water emulsifiable metalworking cooling fluid concentrate

STAR METAL – CUT 260 is a water emulsifiable fluid concentrate for general machining e.g. turning, milling, drilling and sawing of cast iron, steel, high-alloy steel and aluminum.

Thanks to its specially chosen top grade emulsifier system, modern technology and excellent lubricity additives, the product is highly versatile. STAR METAL – CUT 260 works particularly well in both soft and hard water.

Product profile:

- free from boron, amine containing
- polar lubricity improvers and tight control of the in-use pH achieve optimum results when machining aluminum

Properties / advantages:

- good technical stability
- produces stable emulsions in make-up water from 10 °dH to 30 °dH; emulsion in use is stable up to 60 °dH
- good cooling and detergency properties
- a universal metalworking fluid for both freestanding machines and central systems

Technical Data:

Concentrate		Emulsion		
Kin. viscosity at 20 °C [mm ² /s]	Mineral oil [%]	pH at 5 %	Corrosion protection DIN 51360/2	Refractometerfactor [%/°Brix]
approx. 220	approx. 45	approx. 9.7 (drops during use)	6 % - degree of staining 0 (no staining)	1.0

Application:

medium to heavy-duty 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:

Machining of cast iron, steel and aluminum: from 6 %
Medium to heavy-duty 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.

Based on current knowledge STAR METAL – CUT 260 could be used for processing of most aluminum alloys. However the tendency of the alloy to stain should be checked in advance.

Where necessary, the compatibility of the emulsion with yellow metals may be improved by the addition of DELTA MS 0620.

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 colour, odour 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 or in the instructions for use.