

STARCUT E 20

BIOSTABLE EMULSIFIABLE METALWORKING FLUID

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Rev. 1

DESCRIPTION & APPLICATIONS

STARCUT E 20 is a fine machining emulsion, it is biologically stable, odourless and very easy to use.

STARCUT E 20 allows iron, steel, aluminium (automotive) and copper machining applications.

ADVANTAGES

- STARCUT E 20 does not contain chlorine, nitrites or glycol.
- Excellent tool life and part finish
- Excellent stability
- Very good machine hygiene
- Can be used on individual items as well as on centralised installations
- Very good anti foam properties.

ENVIRONMENT, HEALTH & SAFETY

Please consult also the Safety Data Sheet about how to manipulate and to stock the product as well as to learn about the first aid measurements in case of accident.

Elimination after use must be made in conformity with the local rules in force about used soluble oils disposal. When needed, Safety Data Sheet can be obtained upon request.

STARCUT E 20

USE

Storage life:

Maximum 12 months from the date of fabrication.
Protect against frost and not warmer than 40°C.

Concentration:

General metal working applications: 5 %
Severe metal working applications: 8-10 %

Preparation of the emulsion:

Always pour the concentrate into the water and mix gently (NEVER reverse the mixture). We can propose automatic mixers to produce a consistent emulsion.

Emulsion management:

Remove the free oil, metal chips or other contaminants from the surface of the emulsion bath. Measure the concentration periodically with a refractometer. Make sure the concentration does never drop under 2 % in order to maintain a proper protection against corrosion and bacteria.

Remark:

We advise to clean polluted baths with GROGANOL SR 2. GROGANOL SR 2 can be used depending on the contamination of the reservoir between 0.25% and 0.75% aqueous solution. (= 0.25 to 0.75 liter Grotanol SR 2 to be added per 100 liters of emulsion of the bath).
Best cleaning result is obtained after 6 to 24 hours.

PROPERTIES

CHARACTERISTICS	UNITS	METHODS	TYPICAL DATA
Specific gravity at 15°C	kg/m ³	NFT 60101	959
Kinematic viscosity at 40°C	mm ² /s (cSt)	NFT 60100	44,5
Flash point	°C	NFT 60118	> 100
pH of the concentrate	-	NF T 90-008	9,6
pH at 5 % in water	-	NF T 90-008	9,5
Correction factor refractometer	coefficient	-	1,2
Color	-	-	Yellow

The average values are given for information only.