

SAFECUT E 209 NT

METAL WORKING SOLUBLE OIL

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Rev. 4

DESCRIPTION & APPLICATIONS

SAFECUT E 209 NT is a formaldehyde free product that has been specially developed for the processing of ferrous and non-ferrous metals. Perfectly suited for yellow metals, aluminum, steel and alloys, stainless steel and titanium. Due to the high percentage of mineral oil, SAFECUT E 209 NT is less suitable for machining on cast iron. The fine dust that is released during the processing of cast iron in combination with the oil will cause "sludge" formation.

SAFECUT E 209 NT creates a low foaming emulsion in water and can also be used in very soft water.

SAFECUT E 209 NT can be used perfectly for operations such as turning, milling, drilling, sawing and tapping.

ADVANTAGES

- Very onctuous metal working fluid developed for all metalworking processes especially on aluminium, but also for inox, titanium, etc.
- Exceptional polarity for a soluble oil.
- Extremely high wetting properties which prevent the adhesion of chips on the tool.
- No foaming.
- Free of chlorine, nitrite and active sulphur.
- Formaldehyde free.

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.

SAFECUT E 209 NT

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: 8-15 %

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 ECOCLEAN. ECOCLEAN can be used depending on the contamination of the reservoir between 1% and 4% aqueous solution. (= 1 to 4 liter ECOCLEAN to be added per 100 liters of emulsion of the bath).
Best cleaning result is obtained after 3 to 5 days.

PROPERTIES

CHARACTERISTICS	UNITS	METHODS	TYPICAL DATA
Aspect of the emulsion at 4%			White
Specific gravity at 15°C	kg/m ³	ISO 3675	931
Viscosity of the base oil at 40°C	mm ² /s (cSt)	ASTM D-445	42
pH of the concentrate	-	NF T 90-008	9,4
pH at 5 % in water	-	NF T 90-008	9,2
Correction factor refractometer	coefficient	-	1

The average values are given for information only.