

TECHNICAL DATA SHEET

STARGRIND 50

CHLORINE FREE GRINDING FLUID
WITH ANTI-MIST PROPERTIES410089/11.07
Rev. 4

DESCRIPTION

STARGRIND 50 is a clear synthetic fluid that can be mixed with soft and hard water. The mixed solution is transparent.

STARGRIND 50 is formulated to meet the most recent safety and health regulations (free of DEA and nitrites).

APPLICATIONS

STARGRIND 50 is suited for general grinding work but also for finishing tempered steel and cast iron.

STARGRIND 50 is also used in tool grinding applications and can be used with diamond discs.

STARGRIND 50 is the ideal choice for grinding rolling mills and surface grinding forged steel.

ADVANTAGES

- **Immediately soluble in all proportions**
- **translucent**, even in hard water
- excellent **coolant properties**
- excellent lubricant and wearresistant properties
- reinforced **anti-corrosion** properties
- **insensitive for bacterial growth**
- excellent resistance to the formation of **foam**
- metal chips easily deposit
- very good antimist properties
- free of **diethanolamine** (DEA) and nitrites, no formation of cancerogenic nitrosamines.

ENVIRONMENT, HEALTH & SAFETY

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

STARGRIND 50

INSTRUCTIONS FOR USE

Storage life:

- 6 months from date of fabrication.
- store frost proof (and not warmer than 40 °C)

Concentration:

Recommendation: 3 to 4 %.

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 3% in order to maintain a proper protection against corrosion and bacteria.

PROPERTIES

CHARACTERISTICS	UNITS	METHODS	AVERAGE VALUES
Percentage mineral oil	%		0
Density at 15°C	kg/m ³	ASTM D 1298	1070
pH of the solution at 3%		DIN 51369	9.8
Refractometer			1.25

The average values are given for information purposes.