

STARGRIND CO AM

SYNTHETIC GRINDING FLUID FOR
COBALT CONTAINING ALLOYS

410090/03.24

Rev. 1

DESCRIPTION & APPLICATIONS

STARGRIND CO AM is a synthetic fluid, which is miscible in water of all hardness by giving transparent solutions.

STARGRIND CO AM is a refrigerant for all flow grinding and finishing operations.

ADVANTAGES

- * -
- No Cobalt leaching
- Very easy to dissolve in water
- Translucent solution
- Highly detergent and outstanding coolant
- Easy decantation of grinding material
- Highly anticorrosive
- Does not contain secondary amines nor nitrites
- Antimist 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.

STARGRIND CO AM

USE

Storage life:

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

Concentration:

Grinding: 3-4 %

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 2 % in order to maintain a proper protection against corrosion and bacteria.

Remark:

We advise to clean polluted baths with GROTANOL SR2. GROTANOL SR2 can be used depending on the contamination of the reservoir between 1% and 4% aqueous solution. (= 1 to 4 liter GROTANOL SR2 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
Density at 15 °C	kg/l	ASTM D4052	1,095
Content of mineral oil	%	-	0
pH at 3 % in water	-	NF T 90-008	9,7
Correction factor refractometer	coefficient	-	1,92
Color	-	-	not colored

The average values are given for information only.