

# STARCUT E25 EP

CHLORINE FREE EXTREME PRESSURE EMULSIVE METAL WORKING FLUID

410116/05.15

Rev. 0

## DESCRIPTION & APPLICATIONS

STARCUT E 25 EP is a biostable, emulsive metal working fluid which is especially developed for metal working operations on ferrous metals, especially stainless steel.

## ADVANTAGES

- High EP value thanks to its sulphur additivation
- Very onctuous
- Exceptional polarity for a soluble oil
- Extremely high wetting properties which prevent the adhesion of chips on the tool
- No foaming
- Free of chlorine and nitrite
- Due to its high EP additivation, not adapted for copper alloys

## 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 E25 EP

## 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: 6 %  
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 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 <sup>3</sup>	NFT 60101	967
Viscosity of the concentrate at 40°C	mm <sup>2</sup> /s (cSt)	NFT 60100	97
pH at 5 % in water	-	NF T 90-008	8,7
Correction factor refractometer	coefficient	-	0,9
Color	-	-	Milky

*The average values are given for information only.*