SAFECUT M185 NT

BORON -AND AMINE FREE MICROEMULSION

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Rev. 3

DESCRIPTION & APPLICATIONS

SAFECUT M 185 NT is an emulsifiable oil for both soft and hard water. It is a translucent microemulsion.

SAFECUT M 185 NT includes an additive package based on the latest technologies within the metalworking and with additional focus on operator safety and environmental friendliness.

SAFECUT M 185 NT does NOT contain:
- boron
- formaldehyde
- nitrite
- phenol
- secondary amines

SAFECUT M 185 NT does not foam, leaves no sticky deposits on workpiece and is ideal for use of turning and grinding operations (4-5%)

SAFECUT M 185 NT is a perfect partner for machining of:
- Yellow metals (for example: copper parts for high voltage cabins)
- Aluminium (parts made on CNC, milling, turning or for example machinery of aluminium frames like window frames)
- Steel and alloys
- Stainless steel
- Titanium (aviation parts)

SAFECUT M 185 NT is due its high oil content not suitable for cast iron. When machining cast iron there is a huge release of dust and this would -in combination with a higher oil content- generate sludge in the machine.

ADVANTAGES

- Cooling and lubricating properties providing excellent cutting performance (less tool wear).
- Leaves no stickiness / residue on finished parts.
- Suitable for soft and hard water.

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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.

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 %

Grinding: 4-5 %

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 SR 2. GROTANOL 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/m³	NFT 60101	997
pH at 5 % in water	-	NF T 90-008	9,2
Copper corrosion	-	ASTM D 130	1b
Correction factor refractometer	coefficient	-	1,1
Color	-	-	Amber

The average values are given for information only.