

TOPCUT S 216 EP

SOLUBLE BIOSTABLE SYNTHETIC FLUID
FOR METALWORKING

410210/06.15

Rev. 0

DESCRIPTION & APPLICATIONS

TOPCUT S 216 EP is a synthetic fluid with extreme-pressure properties (EP), giving in water of all hardness's a translucent solution.

TOPCUT S 216 EP is a general-purpose soluble oil which is appropriate for all types of machining per removal of chips and on all types of matters.

With a view to a standardization of the products used in a workshop, it is also appropriate for grinding works.

ADVANTAGES

- Multifunctional.
- Perfect surface qualities.
- Excellent behavior of the tools thanks to properties EP.
- Consistency and wet ability providing excellent performances at high cutting speeds.
- Reinforced anti-corrosion capacity..
- Total imputrescibility (resistance to the development of bacteria and moulds) even at the time of prolonged stops of the machines.
- Good capacity of separation with respect to oils of lubrication, allowing an effective removal with a skimmer.
- Naturally antifoaming.
- Do not cause gumming.
- Harmlessness with respect to the users.
- Economic, considering the natural increase of concentrations during service (additions at very low concentration) and the longevity of the baths in service

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.

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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: 4-5 %
Severe metal working applications: 6-7 %
Grinding: 3 %

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 ³	NFT 60101	1126
pH at 3 % in water	-	NF T 90-008	9
Correction factor refractometer	coefficient	-	1,35
Color	-	-	translucent
Product number	-	-	410210

The average values are given for information only.