

# Mabanol Cut Syn 65

Mineral oil-free, water-soluble metalworking fluid concentrate

## Application

Mabanol Cut Syn 65 is a water-soluble metalworking fluid concentrate for grinding of cast iron, steel and alloy steel. The product is highly versatile due to an excellent emulsifier system, modern technology and outstanding lubricity additive package. Furthermore it works well in soft as well as in hard water.

## Properties

Mabanol Cut Syn 65 offers good cooling and detergency properties. The product ensures technical stability allowing longer sump life, good cooling and detergency properties as well as increased corrosion protection. The concentrate forms extremely stable solutions in hard water.

Mabanol Cut Syn 65 contains amine, but is free from boric acid and formaldehyde separators.

## Remarks

Correct preparation of a fresh solution is ensured by slowly pouring the concentrate into water while stirring continuously. Alternatively, an automatic mixing device may be used. The recommended concentration depends on the application and the materials to be machined:

Grinding: from 4%

The concentration of the in-use solution may be checked by using a refractometer. The refractometer reading must be multiplied by the refractometer factor to arrive at the concentration. When intending to machine aluminum alloys, we suggest checking in advance the tendency of the alloy to stain. Minor variations in color and appearance are possible due to the raw materials chosen, but have no influences on the functionality of the product.

## Data

	Unit	Value
<b>Concentrate</b>		
Mineral oil	%	0
Kin. Viscosity at 20 °C	mm <sup>2</sup> /s	8
<b>Solution</b>		
pH at 5%		9,5
Corrosion protection DIN 51360/2		4% – note 0 (no corrosion)
Refractometer factor	%/Brix	2,1

## Shelf life / storage conditions

Stable for 12 months when stored at a temperature of 5 °C to 40 °C in unopened containers

The above values may vary within the commercial limits.  
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