

# Mabanol Cut Syn 98

Mineral oil-free, water-soluble metalworking fluid concentrate

## Application

Mabanol Cut Syn 98 is a water-soluble metalworking fluid concentrate for grinding of cast iron as well as steel and alloy steel. The product is highly versatile due to modern technology and outstanding lubricity additive package. Furthermore it works well in soft as well as in hard water.

## Properties

Mabanol Cut Syn 98 offers good cooling and rinsing properties. The product ensures technical stability as well as increased corrosion protection. It can be used universally on individually filled machines and central systems. Mabanol Cut Syn 98 contains amine and boric acid, but is free from 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 of:

Steel and high-alloy steel	from 3%
Cast iron	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.

Minor variations in colour 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	20
<b>Solution</b>		
pH at 4%		9,1
Corrosion protection DIN 51360/2		4% – note 0 (no corrosion)
Refractometer factor	%/Brix	1,7

## 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.  
Updated in June 2020