

## Metalworking fluid ISO L-MAH

# SINT<sup>®</sup> 100

SINT<sup>®</sup> 100 is watersoluble synthetic metalworking fluid based on high molecular organic compounds that provide excellent anticorrosion protection, enduring high pressures and reduced friction and appropriate biostability ensures long-lasting application.

### ADVANTAGES

- Excellent lubricating and anticorrosion properties,
- It does not mix with other used oils,
- Low foaming,
- Excellent stability in hard waters,
- It rinses well the place of treatment and maintains cleanliness of grinding tools,
- Excellent quality of processing,
- Totally soluble, regardless of the hardness of the water,
- High microbiological resistance,
- Long life,
- Does not irritate or dry out the skin.

### QUALITY LEVEL

ISO 6743-7, L-MAH,  
ISO/TS 12927

### APPLICATION

SINT<sup>®</sup> 100 is synthetic concentrate that, in the form of a transparent aqueous solution, is used for rinsing, cooling and lubrication of the processed objects and tools. It shows excellent results in conditions characterized by medium resistances and conventional cutting speeds in individual reservoirs. For prolonged use, it is recommended to add solution prepared with softened water.

Type of processing	Grey iron	Low alloy steel	High alloy steel	Al and alloys	Cu and alloys
Turning	***	**	*	-	-
Milling	***	**	*	-	-
Planing	***	**	-	-	-
Drilling	***	**	*	-	-
Tapping and threading	**	*	-	-	-
Grinding	***	***	***	-	-
Processing on CNC machines	***	**	-	-	-

\*\*\* the best, \*\* acceptable, \* satisfactory, - not satisfactory

### RECOMMENDED CONCENTRATIONS FOR APPLICATION

Grinding 3%

July, 2018

Milling, drilling, turning 5 - 6%  
Tapping, reaming, cutting 8%

#### ADDITIVE CONTENT

EP	AW	Boron	Amines	Chlorine	Esters	Nitrites	DEA
-	+	+	+	-	-	-	+
Stability in hard water		20°dH (360 ppm CaCO <sub>3</sub> )					

#### TYPICAL CHARACTERISTICS

CONCENTRATE			
CHARACTERISTICS	METHOD	UNITS	VALUE
Appearance	visual	-	red liquid
Density at 20°C	EN ISO 3675	g/ml	1,106
Kinematic viscosity at 40°C	ISO 3104	mm <sup>2</sup> /s	5
SOLUTION			
CHARACTERISTICS	METHOD	UNITS	VALUE
Appearance	visual	-	transparent
pH value at 5% concentrate	ISO 4316	-	9,6
Corrosion on grey iron (chips/paper) 5%	DIN 51360/2	degree	0/0
Factor for refractometer		2	

Friction coefficient in the cutting zone:  $\mu = 1,1 - 1,2$

#### STORAGE

Store in covered area. If stored outdoors, it is necessary to place the drums in a horizontal position to prevent the accumulation of water on the surface of the drum. Do not store at elevated temperatures or in locations exposed to direct sunlight, nor at temperatures below 0°C.

All necessary instructions can be found in the product SDS. It contains the details of possible hazards, warnings and first aid measures, as well as the impact on the environment and the necessary measures for the storage and handling.

#### PACKING

Plastic containers of 20 L and tin drums of 180 kg.

Data are orientational, manufacturer reserves the right to make changes in order to improve product quality.