

Metalworking fluid ISO L-MAG

SINT[®] 30

SINT[®] 30 is watersoluble synthetic metalworking fluid based on organic and inorganic compounds that provide excellent anticorrosion protection, lubricating properties and reduced friction, bacteriological stability.

ADVANTAGES

- Excellent 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,
- High microbiological resistance,
- It does not irritate or dry out the skin.

QUALITY LEVEL

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

APPLICATION

SINT[®] 30 is synthetic product used in the form of an aqueous solution for rinsing and cooling the objects of processing and tools. Mixed with water, it creates a transparent solution. It is primarily intended for flat grinding and grinding operations characterized by low speeds and resistances.

| 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 5 - 6%
Turning 7 - 10%

ADDITIVE CONTENT

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

TYPICAL CHARACTERISTICS

| CONCENTRATE | | | |
|---|-------------|--------------------|---------------------|
| CHARACTERISTICS | METHOD | UNITS | VALUE |
| Appearance | visual | - | yellow green liquid |
| Density at 20°C | EN ISO 3675 | g/ml | 1,050 |
| Kinematic viscosity at 40°C | ISO 3104 | mm ² /s | 1,5 |
| SOLUTION | | | |
| CHARACTERISTICS | METHOD | UNITS | VALUE |
| Appearance | visual | - | transparent |
| pH value at 5% concentrate | ISO 4316 | - | 9,5 |
| Corrosion on grey iron (chips/paper) 6% | DIN 51360/2 | degree | 0/0 |
| Factor for refractometer | | 4 | |

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.