PRODUCT INFORMATION

ISOGRIND A 1000

WATER SOLUBLE METALWORKING FLUID FOR CARBIDE MACHINING

PETROFER
industrial oils and chemicals

DESCRIPTION

ISOGRIND A 1000 is a water soluble, boron and formaldehyde free grinding product, which has been specially developed for carbide grinding

The metalworking fluid is suitable for machining non-ferrous metals and can be used in grinding processes.

BENEFITS

- free of boron and formaldehyde
- excellent corrosion prevention
- optimized pH-stability due to modern amine composition
- very good tramp oil rejection
- free of mineral oil and ester oil

ISOGRIND A 1000 solutions achieve good pH stability over a long period of time and long service life due to the corrosion prevention components contained. The product prevents cobalt leaching, thus it enables excellent grinding performance.

For optimum performance it is recommended to make up the ISOGRIND A 1000 solutions with a suitable mixing tool, e.g. a venturi mixer.

Materials that tend to discolour should be tested for compatibility before use.

TECHNICAL DATA

Oil acceptance characteristic	demulsifying
Oil droplet dispersion	solution
Boron/FAD free	✓
TRGS-611-compliant	✓
Corrosion prevention, 3 % in DI water (DIN 51360/2)	Note 0
Preparation water quality	5 – 10 °dH [90 – 180 ppm $CaCO_3$]
Foam behaviour, 5 % in 10 °dH water, 20 °C (PLM 134)	low
Storage temperature	5 - 40 °C avoiding frost
Operating temperature	< 40 °C
Shelf life	observe the use by date on the container

PHYSICAL DATA

Appearance	light yellow to reddish liquid*
Density/20 °C (ASTM D 7042)	approx. 1.123 g/cm³
Viscosity/20 °C (ASTM D 7042)	approx. 72 mm²/s
pH-value, 3 % in 10 °dH water, 20 °C (DIN 51369)	approx. 9.4

*Concentrate colour may change in storage.

FACTORS FOR CONCENTRATION DETERMINATION

Acidimetric titration up to pH 4: 0.31*
Acidimetric titration up to pH 7: 0.42
Refractometer factor: 1.3

*) Method used: Titration of a 10 ml sample with 0.1 n hydrochloric acid up to pH 4

CONCENTRATIONS RECOMMENDED FOR USE

Grinding: 4 - 6 %

Only valid in combination with EC Safety Data Sheet
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