

EMULCUT 1015

WATER DILUTABLE METALWORKING FLUID

DESCRIPTION

EMULCUT 1015 is an innovative high-performance metalworking fluid developed and specialised for the machining of non-ferrous metals.

The metalworking fluid is suitable for machining steel, cast iron, stainless steel, aluminium, copper, brass and other non-ferrous metals and can be used in the following processes: grinding, turning, drilling, milling, thread cutting, deep-hole drilling and sawing.

EMULCUT 1015 is free of boron and formaldehyde and has an extremely high pH stability. The use of special corrosion prevention combinations ensures that the pH value remains stable over the long term.

We recommend using a mildly alkaline cleaner from our FEROCLEAN series to clean the machined parts.

BENEFITS

- boron and formaldehyde free
- long term stable emulsions
- high compatibility with sensitive aluminium alloys
- very low foaming tendency even with low water hardness
- high surface qualities
- excellent filterability

TECHNICAL DATA

Oil droplet dispersion	fine
Boron/FRB free	✓
TRGS-611-compliant	✓
Corrosion prevention/4 % in water with 20 °dH [356 ppm] (DIN 51360/2)	Note 0
Preparation water quality	5 – 20 °dH [89 – 370 ppm CaCO ₃]
Foam behaviour	low
Storage temperature	5 - 35 °C avoiding frost
Operating temperature	< 35 °C
Shelf life	observe the use by date on the container

PHYSICAL DATA

Appearance/20 °C	clear, light brown liquid
Density/20 °C (ASTM D 7042)	approx. 1.018 g/cm ³
Viscosity/20 °C (ASTM D 7042)	approx. 100 mm ² /s
pH value/5 % in water with 20 °dH [356 ppm]/20 °C (DIN 51369)	approx. 8.9

FACTORS FOR THE DETERMINATION OF CONCENTRATION

Acidimetric titration up to pH 4: 0.57

Acidimetric titration up to pH 7: 0.77

Refractometer: 1.6

USUAL APPLICATION CONCENTRATIONS

Turning, drilling and milling: 5 – 10 %

Grinding: 5 %

Only valid in combination with EC Safety Data Sheet

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