

EMULCUT 1015 E

WATER DILUTABLE METALWORKING FLUID

DESCRIPTION

EMULCUT 1015 E is an innovative ester-based metalworking fluid developed and specialised for machining aluminium.

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

EMULCUT 1015 E is boron- and formaldehyde-free and extremely pH-stable. Thanks to the use of special corrosion prevention combinations 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 stability
- High compatibility with sensitive aluminium alloys
- Very low foaming tendency even with low water hardness
- High surface quality
- Good filterability

TECHNICAL DATA

Dispersity	fine
Boron/FAD-free	✓
TRGS-611-compliant	✓
Corrosion protection/4 % DIN water	Score 0
Preparation water quality	5 – 20 ° dH
Foaming tendency	very low
Operating temperature	< 35 ° C
Storage temperature	5 – 35 °C, frost should be avoided
Consumption period	note the use-by date on the container

PHYSICAL DATA

Appearance/20°C	clear, yellow to light brown liquid
Density/20 °C (ASTM D 7042)	1.006 g/cm ³
Viscosity/20 °C (ASTM D 7042)	approx. 370 mm ² /s
pH/5 % in DI-water/20°C	approx. 9.6
pH-value after 24 – 72 h	9.4

FACTORS FOR THE DETERMINATION OF CONCENTRATION

Acidimetric titration up to pH 4: 0.50*

Acidimetric titration up to pH 7: 0.65*

Refractometer Factor: 1.3

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

USUAL APPLICATION CONCENTRATIONS

Turning, drilling, milling: 5 – 10 %

Grinding: 5 %

Only valid in combination with EC Safety Data Sheet

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