

Metalworking fluid ISO L-MAH

SINT[®] 200

SINT[®] 200 is watersoluble synthetic metalworking fluid based on high molecular organic compounds that provide excellent anticorrosion protection, enduring extreme 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 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[®] 200 is synthetic concentrate that, in the form of a transparent aqueous solution, is used for cooling and lubrication of the processed objects and tools. It shows excellent results in conditions characterized by medium and high resistances and increased cutting speeds in machines with individual reservoirs and it can also be used in central systems. 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

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Grinding	2,5%
Milling, drilling, turning	4 - 5%
Tapping, reaming, cutting	6%

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	-	red liquid
Density at 20°C	EN ISO 3675	g/ml	1,104
Kinematic viscosity at 40°C	ISO 3104	mm ² /s	6
SOLUTIONS			
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		2,0	

Friction coefficient in the cutting zone: $\mu = 0,95 - 1,0$

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.