

# STRUB Stabillo Cut 1 SW

High-tech biobalanced cooling lubricant



Art.-No. 30271

## Description

Universal, water-miscible cooling lubricant of the latest generation. Suitable for all machining operations. Due to the use of a special formulation, a selective, balanced biosystem is formed during use. This protects the emulsion from a negative, microbiological influence (bacterial attack, Monday morning odor).

## Application

Universally applicable for all machining operations such as milling, turning, drilling, etc. in all materials.

## Features and advantages

- very good cutting performance
- skin-friendly, as a low pH range is possible (8.8)
- due to a selective, natural microorganism flora no toxic bactericides or fungicides have to be added
- low-foaming product for normal water hardnesses
- low consumption
- economical

## Mixing ratio

Concentration	Refractometer reading	Effective concentration
Grinding	5.6 % – 6.7 %	5.0 % – 6.0 %
Turning	6.7 % – 7.8 %	6.0 % – 7.0 %
Drilling / Milling	7.8 % – 10.0 %	7.0 % – 9.0 %
Reaming	8.9 % – 11.1 %	8.0 % – 10.0 %
Thread cutting	11.1 % – 13.4 %	10.0 % – 12.0 %
Sawing	11.1 % – 16.7 %	10.0 % – 15.0 %
Deep hole drilling	11.1 % – 16.7 %	10.0 % – 15.0 %

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## Technical data

<b>Concentrate</b> Color Density at 20 °C Viscosity at 20 °C Viscosity at 40 °C  <b>Emulsion</b> Appearance 5% in tap water pH value 5% in tap water Factor Refractometer reading  <b>Do not store below 7°C or above 40°C.</b> Do not expose containers to direct sunlight. Should the cooling lubricant nevertheless be exposed for a short time to temperatures below 7°C or even in the freezing point range, the container should be stored for 3 days at room temperature and then the concentrate must be stirred vigorously until it is clear or homogeneous.	Brownish 0.949 g/cm <sup>3</sup> ~ 150 mm <sup>2</sup> /s ~ 49 mm <sup>2</sup> /s  Opaque - milky ~ 9.6 0.9 (multiply)
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## Satisfied customers report:

<b>Machining</b>       <b>Machine Operation</b> <b>Tool life</b> <b>Other subject data</b>	<b>Steel machining 35%:</b> Steel 37, CK 45, Stainless steel 1.4305, 1.4301  <b>Aluminum machining 45%:</b> Aluminum 3.3547 (5083), Aluminum 3.3206 (6060)  <b>Casting machining 20%:</b> GG20  <b>Matec 30 HV - 20bar pump pressure</b> <b>Drilling, milling, tapping, reaming, roughing, boring</b> <b>Tool life &gt; 20</b> Flawless surfaces, despite cast machining very clean and pleasant odor. Skin friendly.
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## Transport

ADR/SDR No dangerous goods

## Disposal

LVA VeVA / EAK:

Concentrate	12 01 07
Emulsion	12 01 09

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