

# STRUB Stabillo Cut Heavy Duty V3

Biostable high-tech cutting and grinding coolant for difficult to most extreme machining



Art.-No. 32817

## **Description**

STRUB Stabillo Cut Heavy Duty is a biostable, highly additivated, water-dilutable cooling lubricant for highest performance requirements.

STRUB Stabillo Cut Heavy Duty is free of secondary amines (TRGS 611), nitrite-formaldehyde releasers, PBC, PCT, PTBB, and heavy metals.

## **Application**

For all machining and difficult grinding operations (alloys with interstage structure) where maximum lubrication performance without chlorine is required. Threading, reaming (Mapal), punching, grinding, drawing, turning, milling, sawing, deep hole drilling in stainless steel, highest alloyed and hardened steels (e.g. Bainit heat treatment).

# Mixing ratio

	Cast iron Carbon steel	Steel alloys Stainless steel	Tool steel Heat resistant steels
Grinding (from the solid = grooves)	5 - 6 %	5 - 7 %	6 - 8 %
Heavy chipping	5 - 6 %	6 - 7 %	8 - 9 %
Reaming, broaching, tapping, deep hole drilling	7 %	8 - 10 %	10 - 12 %
Repositioning (continuous dosing)		depending on concentration	

### Features and advantages

- excellent cutting performance (very good workpiece surfaces)
- very good penetration, rinsing and washing properties
- skin-friendly, as a low pH range is possible (8.9)
- low foaming tendency, even in soft water
- · increase of tool life
- suitable for high spindle speeds and for high pressure pumps

The information in this technical data sheet is based on general knowledge and application possibilities. STRUB + Co. AG is not liable for damage resulting from improper use of the products. The industry-standard measurement and production tolerances apply to the specified characteristic. Generally, no legal binding can be derived from these data. Our products are subject to continuous further development. Therefore, STRUB + Co. AG reserves the right to change all technical data in this data sheet at any time and without prior notice.

Swiss Tribology

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## **Technical data**

Appearance concentrate Density at 20°C Emulsion type 8% in tap water pH value 8% in tap water Factor Refractometer reading brownish 0.967 g/cm³ Milky ~ 9.4 0.9 (multiply)

### Do not store below 7°C or above 40°C

Do not expose the container to direct sunlight.

If the cooling lubricant has nevertheless been exposed to temperatures below 7°C or even in the freezing point range for a short time, the container should be stored at room temperature for 3 days and then the concentrate must be stirred vigorously until it is clear or homogeneous.

Transport

ADR/SDR No dangerous goods

Disposal

LVA VeVA / EAK: Concentrate 12 01 07

Emulsion 12 01 09

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