

# 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

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