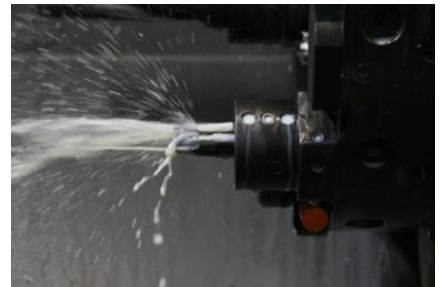


STRUB Stabillo Cut Heavy Duty V3

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



Art.-No. 33390

Description

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

STRUB Stabillo Cut Heavy Duty is free from 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	
	Refractometer reading	Effective concentration	Refractometer reading	Effective concentration	Refractometer reading	Effective concentration
Grinding	5.6% - 6.7%	5% - 6%	5.6% - 7.8%	5% - 7%	6.7% - 8.9%	6% - 8%
Medium chipping	5.6% - 6.7%	5% - 6%	6.7% - 7.8%	6% - 7%	8.9% - 10.0%	8% - 9%
Heavy chipping	7.8% - 8.9%	7% - 8%	8.9% - 11.1%	8% - 10%	11.1% - 13.4%	10% - 12%

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
- Increasing the service life of the tools
- Suitable for high spindle speeds and for high-pressure pumps

The information in this technical data sheet is based on general knowledge and possible applications. Strub + Co. AG is not liable for damage resulting from improper use of the products. The measurement and production tolerances customary in the industry apply to the characteristic data given. In general, no legal binding force 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.

Technical data

Concentrate Appearance Density at 20°C Viscosity at 20 °C Viscosity at 40 °C Emulsion Appearance 8% in tap water pH value 8% in tap water Factor refractometer reading Do not store below 7 °C or above 40 °C Do not expose containers 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.	Brownish 0.975 g/cm ³ ~ 216 mm ² /s ~ 71.3 mm ² /s milky ~ 9.4 0.9 multiply
--	--

Transport

ADR/SDR

No dangerous goods

Disposal

LVA VeVA / EAK:	Concentrate	12 01 07
	Emulsion	12 01 09

The information in this technical data sheet is based on general knowledge and possible applications. Strub + Co. AG is not liable for damage resulting from improper use of the products. The measurement and production tolerances customary in the industry apply to the characteristic data given. In general, no legal binding force 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.