

# EASycut BASE201

## WATER-MISCIBLE SEMI-SYNTHETIC FLUID FOR LIGHT DUTY MACHINING (INCL. BAND SAW) AND GRINDING

Mineral oil based concentrate BASE201 is designed for light duty and medium cutting operations in band saws, lathes, and milling machines and grinding cast iron, steels, and certain aluminum alloys.



### COMPOSITION FEATURES

- Does not contain boric acid
- Does not contain formaldehyde
- Contains secondary amines (DCHA)

### PRODUCT PROPERTIES AND ADVANTAGES

- Stable mixing of the emulsion with water hardness from 5° to 30° dH; During operation (accumulation of salts), an increase in water hardness up to 60°dH is allowed
- High corrosion protection characteristics
- Good washability (clean equipment)

### TECHNICAL DATA

- Kinematic viscosity of the concentrate at 20°C, mm<sup>2</sup>/s: 460
- ≈Mineral oil content, %: 20
- pH of fresh 5% emulsion: 10,4\*
- Corrosion protection DIN 51360/2 (4%): corrosion degree 0
- **Refractometer factor**, %/°Brix: **1.6**

### SHELF LIFE AND STORAGE CONDITIONS

Stable for 12 months when stored at a temperature of 5 to 40 °C in unopened containers.

### RECOMMENDATIONS AND FEATURES

- To prepare a high-quality finely dispersed emulsion, it is recommended to use the automatic mixer device.
- For manual preparation, it is recommended to slowly add the concentrate to the water (not water to the concentrate), mixing evenly.
- The recommended concentration depends on the cutting operations and the material being processed. Grinding: 4-6% | Turning and milling operations: 7-10% (steel, cast iron) / 8-12% (aluminum).
- The concentration of the working emulsion is measured by a manual or electronic refractometer. To do this, the read value is multiplied by the **refractometer factor of 1.6**.
- **EASycut BASE201** coolant can be used for processing of aluminum alloys. However, the tendency of such alloys to form spots (darkening) should be checked in advance.

\*The increased pH in the fresh emulsion may cause a temporary strong odor and temporary darkening on aluminum alloys in the first 1-3 days of operation. Afterward the pH should drop to normal values of 9-9.5.

### COMMENTS

Minor variations in color and appearance are possible due to the raw materials chosen. However, these have no influences on the functionality of the product.

All information on safe and proper handling can be found on the MSDS.

DESIGNED IN GERMANY

#### Coolant Calculator

Please use our on-line coolant calculator for top-up concentration math.



Full **EASycut** metalworking-fluids portfolio:



Import to Canada: CNCmarket.ca Inc.,  
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The technical data are representative values.  
All recommendations are without obligation.

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