

EASYCUT BASE201

WATER-MISCIBLE SEMI-SYNTHETIC COOLANT FOR GRINDING AND LIGHT AND MEDIUM DUTY CNC MACHINING



Water-miscible semi-synthetic concentrate of lubricating and cooling fluid. BASE201 is designed for grinding cast iron, steels, and certain aluminum alloys. It can be also used for light duty and medium cutting operations in band saws, lathes, and milling machines. Contains mineral oil.

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 °dH 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: 460 mm²/s
- ≈Mineral oil content: 20 %
- pH of fresh 5% emulsion: 10.4*
- Corrosion protection DIN 51360/2: 4% — corrosion degree 0
- Refractometer factor: 1.6 %/°Brix.

SHELF LIFE AND STORAGE CONDITIONS

Stable for 12 months when stored at a temperature of 5 °C 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 ZH-30.
- 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. Turning and milling operations: 7-10% (steel, cast iron) / 8-12% (aluminum). Grinding: 4-6%.
- The concentration of the working emulsion is measured by a manual (LQ20T) 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. Afterwards 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.

EASYCUT BASE201 at www.cncmarket.ca



Designed in Germany

Import to Canada: CNCmarket.ca, 1144 Legacy Cir SE, Calgary, AB, Canada

The technical data are representative values. All recommendations are without obligation. We reserve the right to change the contents of this document without prior notice.