

Aral Sarol 335 S

Water miscible cutting fluid

Applications:

Aral Sarol 335 S is a biostabile, low mineral oil based, chlorine and nitrite free, water miscible cutting fluid for the preferred use when a minimal foaming tendency is needed in processing, in particular in areas with a minimal water harding. Aral Sarol 335 S is outstandingly suitable for grinding, but also for all machining operations on cast iron and low alloyed steel qualities.

The product is free of secondary amines. As a result, a formation of stable nitrosamines is not possible. TRGS 611 is fulfilled completely.

Mixing with water gives a whitish, fine dispersive cutting fluid emulsions, with high emulsion stability and long emulsion life. Furthermore, Aral Sarol 335 S has good corrosion protection properties, a good skin compatibility and is pleasant in odour.

Operational area:

According to our experience, the following concentration adjustments are to be made to achieve optimal processing results:

Light to medium machining operations: 4-6%

Grinding: 4-5%

Technical Data

Concentrate

Colour			amber - reddish
Density at 20 °C	g/ml	DIN 51757	0,995
Viscosity at 20 °C	mm ² /s	DIN 51562	ca. 400
Mineral oil content	%	DIN 51417	50

Emulsion

pH value at 3%		DIN 51369	9,2
Corrosion protection			
Chip/filter paper	Korr. Grad.	DIN 51360-2	0 at 4,0%

Remarks:

Product application is exclusively with water hardness up to approx. 10 °d!

The preparation of the emulsion is done with automatic mixing devices or by slowly pouring into drinking water and simultaneously thoroughly stirring.

Refractometer factor: 1,0

All data is subject to development for the product and the production process.

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