

# Aral Sarol 474 EP

## Water miscible cutting fluid

### Applications:

Aral Sarol 474 EP is a mineral oil based, chlorine and nitrate free, water miscible, universal cutting fluid for the cutting and grinding of metal. With a selected additive combination, this product has a sufficient lubrication performance available for heavy-duty machining operations.

Aral Sarol 474 EP contains no bactericide and is free of amines and boric acid. Present knowledge shows the creation of stable nitro amines is not possible. The TRGS 611 is fulfilled completely.

Mixture with water gives a fine whitish dispersible cutting fluid emulsion, with a high emulsion stability and a long emulsion life. In addition Aral Sarol 474 EP has a good corrosion protection ability and an excellent skin compatibility.

Aral has successfully submitted this product to the strict requirements of the high-quality standard DIN EN ISO 9001. This certification gives you an additional safety assurance with this products quality and the service that can be expected from Aral.

### Operational area:

Aral Sarol 474 EP is especially suited for the machining of aluminum and nonferrous alloys and steel.

According to our experience the following concentration adjustments are to be made to achieve an optimal working output:

Light to medium machining : 5 - 6 %

Medium to heavy machining: 6 - 10 %

Grinding: 4 - 5 %

### Technical Data

#### Concentrate

Colour			Brown
Density at 20 °C	g/ml	DIN 51757	0,95
Viscosity at 20 °C	mm <sup>2</sup> /s	DIN 51562	120
Mineral oil content	%	DIN 51417	49

#### Emulsion

pH value at 3%		DIN 51369	9,0
EP-value (Reichert) 5%	mm <sup>2</sup>		22

#### Corrosion protection

Herbert test		DIN 51360-1	S0 R0 at 3,0%
Chip/filter paper	Korr. Grad.	DIN 51360-2	0 at 4,0%

### Remarks:

Preparation of the solution occurs by pouring into drinking water, and thoroughly stirring by hand or with the aid of automatic mixing device.

Refractometer factor: 1,0

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

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