



## **Aral Sarol 477 EP**

**Water miscible cutting fluid**

### **Applications:**

Aral Sarol 477 EP is a mineral oil based, chlorine and nitrate free, water miscible, universal cutting fluid for the cutting and grinding of all metals. With a selected additive combination it has a sufficient lubrication performance available for heavier machining operations.

Mixing with water gives a fine fine whitish dispersible cutting fluid emulsion, with a high emulsion stability and a long emulsion life. In addition to a high stability Aral Sarol 477 EP has a good corrosion protection ability.

Aral Sarol 477 EP is free of amines and boric acid. Present knowledge shows the creation of nitro amine is not possible. The TRGS 611 is fulfilled completely!

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:**

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

Light to medium machining operations:	4 - 7 %
Medium to heavy machining operations:	6 - 10 %
Grinding:	2 - 4%

### **Technical Data**

#### Concentrate

Colour			amber
Density at 20 °C	g/ml	DIN 51757	0,960
Viscosity at 20 °C	mm <sup>2</sup> /s	DIN 51562	130
Mineral oil content	%	DIN 51417	46

#### Emulsion

pH value at 2%		DIN 51369	9,2
EP-value (Reichert) 5%	mm <sup>2</sup>		26

#### Corrosion protection

Chip/filter paper	Korr. Grad.	DIN 51360-2	0 at 5,0%
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### **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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