



PRISTA® SYNTHOL EP

PRISTA OIL

■ DESCRIPTION

PRISTA® SYNTHOL EP is semi-synthetic concentrate which when mixed with water forms semi-transparent solutions. The additive package used for the formulation of the concentrate imparts very good lubricity and very good chip removal properties, minimum foaming and excellent protection both for the working tools and machined parts against corrosion and wear as well as for the working fluids against bacterial growth. Free from chlorine, nitrites, phenols and secondary amines.

■ APPLICATION

PRISTA® SYNTHOL EP is recommended for application during the heaviest machining operations such as turning, drilling, etc. of steels, cast iron, aluminium and copper alloys where except the good cooling properties, the good anti-wear properties of the cutting fluid are of vital importance for the quality of machined parts.

The recommended concentration of the oil-in-water solutions is from 4% to 5% depending on the severity of the operating conditions and the quality of the machined materials. Can be mixed with water of different hardness up to 60°dH (1080 ppm).

Refractive Index - 1.25% per °Brix.

■ TECHNICAL DESIGNATION:

ISO-L-MAH - according to ISO 6743/7

METAL WORKING FLUIDS



PRISTA® SYNTHOL EP

PRISTA OIL

■ TYPICAL CHARACTERISTICS

Nº	PARAMETER	TEST METHOD	TYPICAL VALUES
1.	Concentrate parameters - Appearance - Kinematic viscosity at 200C, cSt - Density at 20°C, g/ml - Mineral oil content, %	Visual EN ISO 3104 EN ISO 3675 -	Clear brown fluid 80 1.004 30
2.	Properties of 5% water solution: - pH - Foaming, mm/s - Cast iron corrosion - Steel corrosion - Herbert Test (cast iron chips on paper), rating	ISO 4316 BDS 14887 BDS 14912 BDS 14912 DIN 51360/II	9.4 5/0 pass pass 0/0 (no corrosion)

The concentrate is stable when stored at temperatures up to 10°C and for 9 months.