euromarc®

ELITE

WATER SOLUBLE CUTTING FLUID 272

Bio-stable multi-purpose EMULSIFIABLE metal working fluid.

ELITE 272 is a bio-stable EP II multi-purpose environmentally friendly metal working fluid. It is free from nitrite, nonyl- phenol, boron and heavy metals. It is a concentrate that when added to water forms a stable milky emulsion. It contains emulsifiers, biocide corrosion inhibitors and lubricity improvers.

Biocide aids in the preservation of ELITE 272 as it has a broad activity spectrum against bacteria, moulds and yeasts that cause deteriation of water-based metal working fluids.

To produce an homogeneous emulsion Elite 272 should always be added slowly to water with agitation.

DO NOT add water to the oil.

Performance Benefits

- Excellent corrosion protection
- Good hard water stability
- Excellent emulsion stability
- Excellent foam control under soft water conditions.
- Compatible with non-ferrous metals

Applications

- ELITE 272 is recommended for various machining operations such as cutting, drilling, grinding, milling, reaming, tapping, etc. It can be used for both ferrous and non-ferrous metals.

Machining

- For general machining requirements, a concentration of 1 part ELITE 272 added to 20 parts of water (5%) will give good results on free machining requirements.
- A concentration stronger than 1 part oil / 10 parts water (10%) is seldom necessary as performance is not significantly improved beyond this level, while detrimental effects such as foaming can be created.

Grinding

- When used as a grinding fluid, ELITE 272 should not be used at a weaker concentration than 1 part oil / 50 parts water (2%). Weaker concentrations can significantly reduce the protection against corrosion. Conversely, stronger concentrations may result in clogging of grinding wheels and glazing of the work piece.

Sizes

- 5L
- 20L

General Recommendations

Process		Parts Water:Oil
Machining	Mild Steel and Brass	20:1
	Medium Steels	15:1
	Aluminium	15:1
Grinding		50:1
Rolling (suggested as a starting point)		10:1

NOTE: *Values stated herein are typical and do not represent a specification.*