UNICOOL MIKRO 40PW

GENERAL FEATURES:

Unicool Mikro 40PW is a semi-synthetic cooling agent that forms microemulsion with water. It contains anionic and nonionic surfactants, innovative corrosion inhibitors, lubrication enhancers, anti-foaming additives and forms stable microemulsions.

APPLICATION:

Unicool Mikro 40PW is intended for use in typical machining processes, such as turning or milling, as well as drilling, boring, deep hole drilling, threading, forming and grinding processes as well as in heavy-duty machining operations. It is suitable for low- and high-pressure CNC systems. It can be used in both central systems and individual machines.   Suitable for use with:
• Cast iron
• Iron alloys and stainless steel
• Aluminium alloys
• Plastics   Recommended concentrations:
Standard machining (turning, milling): light-duty machining 3%, medium-duty machining 5-6%, heavy-duty machining 7-8%.
Grinding: light-duty machining 1.5-2%, medium-duty machining 3-5%, heavy-duty machining 3-5%.
Heavy-duty machining (threading, deep hole drilling): light-duty machining 3-4%, medium-duty machining 6-8%, heavy-duty machining 9%
Stamping, forming: light-duty machining 3-4%, medium-duty machining 5-6%, heavy-duty machining 6-8%
Boring: light-duty machining 4-5%, medium-duty machining 8-10%, heavy-duty machining 10-12%.   The product must be stored in temperatures between +10oC and +30oC in its original packaging, protected against dust, sub-zero temperatures and overheating.

Physical and chemical properties:

PARAMETERS	UNIT	TYPICAL VALUES
Concentrate: Kinematic viscosity at 40^0C	mm^2/s	15,8
Density at 20^0C	g/cm^3	1,015
5% emulsion in water at 15^0N water hardness Appearance of the emulsion at 20^0C	-	Transparent to opalescent liquid
Corrosion protection on steel plates by Herbert's and Ford's method	-	H0/F0
pH	-	9,4
Stability of the emulsion after 24 hours at 50^0C	-	1A/1R/ maintained

NOTE:
Physicochemical parameters listed in the table are typical values. Real values are stated in quality control certificates attached to each product lot.