

Technical Data Sheet

MV.4

MV.4 is a water-soluble coolant free of mineral oil for glass grinding operations.

Application

MV.4 is used for milling, boring, grinding, also deep grinding operations, at optical, technical and medical glasses. Best suitable for cut grinding, edge grinding, fancy grinding and crystal lead grinding.

Properties

- high lubricating effect, therefore reduced cutting temperature, better advance and improved surface
- colourless, transparent solutions of long service life
- very low foaming, good air separation capacity
- excellent care of tool machine, good corrosion protection
- excellent cooling and heat discharge
- good transportation of glass particles
- very good skin tolerance
- water hazardous class 1
- CSB - value (1 %): approx. 8.500 mg O₂/ltr.

Technical Data

Concentrate	Solution (3 % of NW 20)		
	pH-value	UT foam [sec.]	Surface tension [mN/m]
Viscosity 20 °C [mm ² /s]			
approx. 6	9,2	< 30	approx. 56

Remarks

To prepare operating solution slowly add the coolant concentrate to drinking quality water assuring thorough mixing. Mixing can also be done by means of an automatic mixer.

Mixture ratios:

Grinding	2 - 4 %
Milling	3 - 5 %

The concentration of operating solutions can easily be checked by means of a refractometer. The °Brix value multiplied by the refractometer value equals the concentration in %.

Refractometer factor

3,0

CS Unitec metal working fluids are free of chlororganic substances, nitrite and secondary amines. They contain natural raw materials. Therefore, slight degradations of colour and appearance are possible, however, quality and function of the product are not affected at all.

Subject to technical modifications.

For more information please call our application engineers.

Edition

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