# **POLYBIO 535**





### METAL WORKING FLUID \_ WATER SOLUBLE OIL

#### PRESENTATION

**POLYBIO 535** is water soluble oil. Code ISO-L-MAA

#### **APPLICATIONS**

- All kind of machining operations on cast iron, steel, stainless steel, and aluminum.
- Grinding operations.

#### **ADVANTAGES**

- Performance: POLYBIO 535 is designed for medium duty machining operations.
- Filtration: minimum 25 µm. Filters of natural polyesters or polypropylene. The specific design limits filter consumption. This excellent filtration capacity allows preserving a very clean coolant, and the performances in time.

- **PRODUCT BENEFITS**
- ✓ For soft water & hard water
- Good rust protection on cast iron& steel
- High mineral oil content
- > Friendly usage: Odorless
- Rust protection: Excellent rust protection on sensitive ferrous materials like cast iron and steel.
- Foaming: High resistance to foaming :
  ⇒ No foaming in soft water
  ⇒ No "mechanical" foaming at high pressure
- > **Degreasing:** compatible with alkaline cleaners

CHARACTERISTIC	S	Units	POLYBIO 535
<u>In it's pure state:</u>	Appearance	/	Liquid
	Color	/	Dark blonde
	Specific gravity at 15°C	g / cm³	≈ 0.960
	Kinematic viscosity at 40°C	mm²/s	≈ 124
	Temperature of storage	°C	5 to 40°C, keep away from freezing
	Shelf Life		1 year under original packaging
<u>Diluted ratio 1:20 (5 %):</u>	Appearance	/	Opalescent
	Color (when in use)	/	White
	pH	/	≈ 9.2
	Refractometric coefficient	/	≈ 1
	Actual concentration	F	Reading taken x Coefficient
Concentration in use:	Steel machining	,	1:25 (4%) to 1:20 (5%)
	steel, stainless steel machining	1	1:20 (5%) to 1:10 (10%)
The	Aluminum machining	'	1:20 (5%) to 1:10 (10%)
	Grinding	,	1:25 (4%)
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<u>Behavior:</u>	Steel corrosion	1	Minimum 1:33 (3%)
	Copper corrosion	1	0-0
Aluminum corrosion, 2000 series			
Foaming at 1:20, soft water 100 ppm (mg CaCO3/I)_10°TH_5.6°dH			300-300-5-0-240
Foaming at 1:20, hard water 1000 ppn	1 (mg CaCO3/I)_100°1H_56°dH		300-180-0-1-250

Above details are issued from a production average; they are not specifications

## HEALTH AND SAFETY

See MSDS (Material Safety Data Sheets)



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