

PRISTA® Emulsin MW 634

Metalworking fluids

Description and application

Prista® Emulsin MW 634 is a water emulsifiable semisynthetic metalworking fluid concentrate that was specially developed for machining of aluminium. Its special additives and inhibitors enable the machining of conventional aluminum alloys such as e.g. 2024, 6061, 6082, 7075. Product is also suitable for the machining of titanium and yellow metals. The product is free from boron, nitrite, chlorine and formaldehyde donors. Amine containing concentrate.

Prista® Emulsin MW 634 was specially developed for grinding and general machining of alloyed and plain carbon steel and cast iron. The product is recommended for preparing working solutions with water of hardness from 5-30°dH.

Benefits

- Produces stable microemulsion with excellent wetting and EP properties. The fresh emulsion is stable up to 150°dH water hardness.
- Excellent cooling and detergency properties
- Good corrosion protection
- Very good technical stability giving long sump life
- Low foaming
- Recommended concentration:
 - › Grinding- from 5%
 - › General machining from 8%

Use and applicable operations

	Water-Miscible MWF
Aluminum	Very suitable
Yellow metals	Suitable
Titanium	Suitable
Steel	Suitable
Cast iron	Suitable
Grinding	Suitable
Cutting	Suitable
Forming	Suitable
Additional properties: lubricity	Yes

Correction factor – 1.3% per °Brix

Specifications

	Water-Miscible MWF
ISO 6743/7	ISO-L-MAE

Typical characteristics

Parameter	Test Method	Typical Value
Properties of the concentrate: - Appearance - Kinematic Viscosity at 20°C, cSt - Density at 20°C, g/ml - Mineral oil content, %	Visual EN ISO 3104 EN ISO 3675 -	Clear brown fluid 200 0.990 30
Properties of water solutions: - Appearance - pH (at 5 %) - Corrosion protection (chip/filter paper test at 5%)	Visual ISO 4316 DIN 51360/II	Semi-transparent emulsion 9.7 0/0 - no corrosion

Important note: typical data values do not constitute a specification but are an indication based on current production and can be affected by allowable production tolerances. The right to make modifications is reserved.



Health, safety and handling

Based on current available information, this product is not expected to produce adverse effects on health when used for the intended application.

For more information about product's MSDS, terms and conditions for storage and shelf life please visit www.prista-oil.com

Minor variations in color, odor, and appearance may occur due to the selected raw materials; however, they do not affect product performance. Store the fluid in closed, dry warehouses. The concentrate remains stable for up to 12 months when stored at 5°C to 40°C. After opening, keep the concentrate container tightly closed.