

PRISTA® Emulsin MW 638

Metalworking fluids

Description and application

Prista® Emulsin MW 638 is a water-emulsifiable semisynthetic metalworking fluid formulated with high quality mineral base oils and a special additive package. It is free from boron, nitrite, chlorine and formaldehyde donors. Amine containing concentrate.

Prista® Emulsin MW 638 is an universal product. It was specially developed for grinding and general machining of cast iron, alloyed and plain carbon steel and is also suitable for light machining of many aluminum alloys, e.g. from the 2000, 5000, 6000 and 7000 group (EN 573-3/4).

Recommended working solutions with water of hardness in the range 10-30°dH.

Benefits

- Produces stable microemulsion with excellent wetting properties. The fresh emulsion is stable up to 60°dH (1080 ppm)
- Ensures superior cutting tool cooling and detergency
- It is suitable for use in both single sump machines and central systems
- Designed for use at wide concentration ranges from 5% to 8%
- Low foaming

Use and applicable operations

	Water-Miscible MWF
Cast iron	Very suitable
Steel	Suitable
Yellow metals	Not suitable
Aluminium*	Suitable
Grinding	Suitable
Cutting	Suitable
Forming	Not suitable
Additional properties: lubricity/ EP	None

*Check in advance the tendency of the alloy to stain
Correction factor – 1.6% 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 210 0.992 20
Properties of water solutions: - Appearance - pH (at 5 %)	Visual	Semi-transparent emulsion



- Corrosion protection (chip/filter paper test at 4%)	ISO 4316 DIN 51360/II	10.4 0/0 - no corrosion
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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.