

# Sitala DF 400

## Water miscible metalworking fluid

### DESCRIPTION

Sitala DF 400 is a high quality, formaldehyde free metalworking fluid recommended for general machining operations on steel and aluminum alloys.

### APPLICATION

Sitala DF 400 is a semi-translucent micro-emulsion recommended for light to medium duty operations on automotive aluminum alloys (high silicon content), as well as for general machining of steel alloys.

Sitala DF 400 is recommended for use in medium to hard water conditions. Its use in very soft water conditions (<5°dH) is not advised.

### RECOMMENDATIONS FOR USE

General machining	5 - 7 %
Severe cutting operations	8 - 12 %
Grinding	4 - 5 %

### TYPICAL PHYSICAL PROPERTIES

TEST	TYPICAL VALUE	TEST METHOD
Mineral Oil content %	29	
Specific gravity @ 20 °C	0.970	ASTM D 1298
Viscosity @ 20 °C, mm <sup>2</sup> /s	170 - 210	ASTM D 445
pH of emulsion @ 5%	9.3	DIN 51396
Min. Anti-Corr. Protection limit (0-0, %)	5	DIN 51360/2
Refractometer factor	1.1	
Acid split factor	1.7	

### ADVANTAGES

- ❑ Good foam behavior
- ❑ Odorless
- ❑ Good stability – ensuring long sump life and minimising tank side additions of additives
- ❑ Good corrosion protection
- ❑ Good detergency offering low drag out, clean parts and machine tools, and a better working environment
- ❑ Low foam in medium to hard water – guaranteeing problem free working operations, and allowing high pump pressures and flow rates
- ❑ Good separation of tramp oil – oil can easily be removed to prolong fluid life
- ❑ Environmental compliance – free of formaldehyde, chlorine, secondary amines, phenol and nitrite

### STORAGE

Product should be stored under cover in clean, dry conditions and protected from frost. Recommended storage temperature is between 5°C and 35°C. Use stock in delivery rotation. A shelf life of twelve months can be anticipated.

### HEALTH AND SAFETY

Health and Safety Data Sheets are supplied to customers to comply with Section 6 of the Health and Safety at Work Act 1974, and should be closely studied prior to handling or use of the product. Copies are available from your Technical Health and Safety Officer. Various other advisory publications are available from the Health and Safety Executive and Her Majesty's Stationery Office.

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All data given in this Product Data Sheet are typical of this material. It does not however constitute a specification. We reserve the right to modify products without prior notice. All products, services and information supplied are provided upon the terms of our standard Conditions of Sale from time to time in force.

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