

# GOLDENSTONE® SYNTHOL A-HW

## Technical Data Sheet (TDS) METALWORKING FLUIDS

### Description and Application

**Goldenstone® Synthol A-HW** is water-miscible metal working fluid, which is formulated with base oils of low aromatic contents and neutralised products of boric acid, anionic and non-ionic emulsifiers as well as yellow metals corrosion inhibitors and stabilizing agents.

**Goldenstone® Synthol A-HW** is universal, water-miscible cutting fluid for all chip-removal metalworking operations and is especially recommended for preparation of working solutions with water of hardness 8-25°dH.

### Benefits

- Produces stable emulsions with excellent wetting properties in waters of different hardness up to 60°dH (1080 ppm)
- Ensures superior cutting tool cooling and detergency
- Suitable for machining of cast iron, steel and aluminium alloys
- Designed for use at wide concentration ranges from 4% to 15%

### Use and applicable operations

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

Refractive index – 1.33% per °Brix

### Specifications

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

### Typical Characteristics

Parameter	Test Method	Typical Value
Properties of the concentrate:		
- Appearance	Visual	Clear light brown fluid
- Kinematic Viscosity at 20°C, cSt	EN ISO 3104	90
- Density at 20°C, g/ml	EN ISO 3675	0.993
- Mineral oil content, %	-	35
Properties of water solutions:		
- pH (at 4 %)	ISO 4316	9.0
- pH (at 10 %)	ISO 4316	9.2
- Corrosion protection (Herbert test at 3%)	DIN 51360/I	R0/S0 - no corrosion
- Corrosion protection (chip/filter paper test at 4%)	DIN 51360/II	O/O - 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 MSDS, terms and conditions for storage and shelf life please visit:

<http://www.goldenstoneoils.com>

Fluid must be stored in closed and dry warehouses. The concentrate will stay stable if stored at temperatures from 10°C to 25°C for up to 12 months. After opening keep the container with concentrate tightly closed.

## Packages

20L, 200 kg

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