



# XPD M4021



## Chlorine-free synthetic cutting fluid for machining and grinding

### APPLICATIONS

- **XPD M4021** is recommended for machining and grinding steel and its alloys as well as non-ferrous metals.
- **XPD M4021** is also intended for machining a variety of plastics materials and for machining and polishing special optical glasses.

- Recommended proportions:\*
- machining: 4 – 6 %
- grinding: 3 – 4 %

\* The best concentration has to be tested.

### SPECIFICATION

- Free of chlorine, boron, amines and nitrosamine-forming agents.
- Excellent protection against corrosion of machined parts and machines.
- Outstandingly stable in use.
- Very low foaming.
- Very good settling of grinding sludge and very good separation of lubricating oils.
- Natural resistance to bacterial growth.
- Satisfies the German TRGS 611 legislation (technical rules governing the handling of hazardous substances).

| TYPICAL CHARACTERISTICS   | METHODS     | UNITS              | XPD M4021 |
|---------------------------|-------------|--------------------|-----------|
| Appearance                | -           | -                  | clear     |
| Density at 15 °C          | DIN 51 575  | kg/m <sup>3</sup>  | 1431      |
| Viscosity at 20 °C        | DIN 51 562  | mm <sup>2</sup> /s | 33,8      |
| Viscosity at 40 °C        | DIN 51 562  | mm <sup>2</sup> /s | 13,9      |
| Mineraloil                | -           | %                  | 0         |
| pH-level (5%)             | DIN 51369   | -                  | 9,2       |
| Corrosion (F-Späne) >= 2% | DIN 51360/2 | -                  | 0         |
| <b>Refractive index</b>   | -           | -                  | 1,35      |

(Es handelt sich um Kennwerte, die im handelsüblichen Rahmen schwanken können.)

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