

Technical Data Sheet

Zubora 65 S Extra

Product description

- semi-synthetic, water-miscible high performance cooling lubricant
- free of boron
- on the basis of mineral oil
- with high content of polar additives
- long-term stable
- excellent corrosion protection
- free of formaldehyde separators

Due to the use of primary amines there is no risk of formation of nitrosamines according to the current state of knowledge.

Furthermore, **Zubora 65 S Extra** is inhibited against the formation of nitrosamines, i.e. that even if there are any secondary amines and nitrites (e. g. through foreign carry-over) no stable N-nitrosamines can be formed. Therefore, when exceeding the limit value for nitrite according to TRGS 611 a partial or complete change of the emulsion is not necessary.

Characteristics

Colour / DIN ISO 2049:	1.0
Density/15°C / DIN EN ISO 12185:	1010 kg/m ³
Viscosity/20°C / ASTM D 7042 :	70 mm ² /s
pH-value (5 % in H ₂ O) / DIN 51 369:	9.5
Cast iron chips test (1:20) / DIN 51 360/T2:	Corrosion degree 0
Mineral oil content:	5 %
Water hazard class, concentrate:	1
Correction factor for determination of the concentration - refractometer:	1.7

Application

Due to selected highly effective additives **Zubora 65 S Extra** is suitable for cutting processes of most difficult demand. Furthermore, it is excellently suitable for grinding.

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1 / 2

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The product can be used for machining steel, cast iron and aluminium. Due to a special formulation **Zubora 65 S Extra** is particularly long-term stable.

The innovative additive package effects a longer tool life and enables the working with high cutting speeds. Thus, a high process security can be guaranteed even for very difficult working operations. This advantage guarantees high flexibility for different cutting processes mainly in central systems and working centres.

The necessary working concentration depends on the difficulty of the operation and the material.

The recommended water hardness range of the preparation water is between 4 to 12° dH.

Working concentration

grinding	approx. 5 %
drilling/milling etc.	approx. 5 %
reaming/sawing etc.	approx. 10 %

Storage

Recommended storage temperature: +5 °C up to max. +40 °C.

Miscellaneous

This product is dermatologically tested. An Epicutan-test confirms the good skin compatibility. We will send you the test certificate on request.

Zubora cooling lubricants and our guide and slide way oils **Divinol T 3 EP ISO 32 / Divinol T 6 EP ISO 68 / Divinol T 8 EP ISO 100 / Divinol T 12 EP ISO 220** are optimally compatible with each other. The combined use shows excellent de-emulsification properties, i.e. mixtures of emulsions and slide way oils separate quickly. Black stains can be excluded to a great extent.

If there are increased demands on **corrosion protection**, e. g. for external transport, we recommend our anti-corrosion agents containing hydrocarbons (**Multicor dewatering fluids**). They are optimally adapted to our water-miscible cooling lubricants.

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2 / 2