

Adrana E 3205

Water miscible metalworking fluid

DESCRIPTION

Adrana E 3205 is a water miscible metalworking fluid for general machining applications on cast iron.

Adrana E 3205 contains secondary amines.

APPLICATION

Adrana E 3205 is, a micro-emulsion, recommended for general machining operations on cast-iron for both single sump machines and central systems.

Adrana E 3205 is especially recommended for grinding operations on cast-iron and ferrous metals.

RECOMMENDATIONS FOR USE

General machining	4 - 6%
Severe cutting operations	6 - 8 %
Grinding	4 – 5 %

TYPICAL PHYSICAL PROPERTIES

TEST	TYPICAL VALUE	TEST METHOD
Mineral Oil content %	10	
Specific gravity @ 20 °C	1.020	ASTM D 1298
pH of emulsion @ 5%	9,2	DIN 51396
Min. Anti-Corr. Protection limit (o - o, %)	4	DIN 51360/2
Refractometer factor	2.9	
Acid split factor	5.5	

ADVANTAGES

- ❑ Excellent detergency for clean parts and machine tools
- ❑ High stability – reducing fluid maintenance cost and providing extended fluid life
- ❑ Good corrosion protection – ensuring low reject rate and maintenance cost related to corrosion issues
- ❑ Good foam control – guaranteeing problem free working operations when high pressure and good air release properties are needed.
- ❑ Good cooling properties that provide sufficient tool life and part geometry

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.

05/11

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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