



Syntilo CR 68

Synthetic coolant

Description

Castrol Syntilo® CR 68 is a mineral oil and formaldehyde releasing agent free synthetic metalworking fluid formulated especially for the grinding of cemented tungsten carbide. It contains an additive package that provides good corrosion protection to machine tools and parts. The fluid also provides excellent product stability which helps to lower the overall operational costs.

Syntilo CR 68 is suitable for large central systems and single sump machines.

Application

Syntilo CR 68 is developed for surface, cylindrical, double disk and centreless grinding especially of tungsten carbide.

ü ü suggested core application ü possible application, please consult Castrol representative prior to use

	Cast Iron	Low-medium alloyed steel	High alloyed - stainless steel	Aluminium alloy	Titanium alloy	Tungsten Carbide
Grinding	ü	ü	ü			ü ü
Milling, Turning (general machining)	ü	ü				
Drilling						
Reaming, Tapping						
Broaching						

Advantages

- Helps to minimize cobalt build-up which can lead to health hazards and tool/part failures
- Can improve surface finish of components through reduced cobalt dissolution from the tungsten carbide binder mat
- Low foam in recommended water conditions (see details below)
- Extended fluid life can help to reduce maintenance and downtime
- Good anti-corrosion properties to protect machine tools and parts
- Rejects tramp oil to the surface of the fluid for easy removal
- Settles chips quickly to prevent grinding wheel build-up and maintain a clean working environment
- Formaldehyde releasing agent and nitrite free which help you to fulfil aspects of legislative requirements and waste treatment requirements where applicable

Typical Characteristics

	Test Method	Unit	Value
<u>Concentrate</u>			
Appearance	Visual		Yellow
Specific Gravity @ 15.6°C	ASTM D4052	g/cm ³	1.040
<u>Solution</u>			
Appearance	Visual		Transparent
pH (5%)	CN-TM-069	Typical value	9.2
Refractometer Factor		BRIX unit multiplier	3.0

Subject to usual manufacturing tolerances.

Recommended Concentrations

Grinding: 3-5%

Water range: 50-400 ppm CaCO₃

Storage

To avoid product deterioration always keep the container/drum tightly sealed. Store the product in a cool, dry place away from direct sunlight. Prevent exposure to frost and avoid water ingress. For optimum product stability, it is preferable to store the product indoors between 5°C and 45 °C / 41°F and 113°F.

For more details, please refer the product safety data sheet.

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