

MAK SHEROL E

Premium fully synthetic grinding fluid

MAK Sherol E is a premium quality fully synthetic water based soluble grinding fluid with special additive to provide superior surface finish and excellent cooling.

Applications:

MAK Sherol E is primarily designed for grinding of ferrous metals and its alloys. This high performance soluble fluid has excellent emulsion stability with hard water.

Recommended Use	Cast Iron	Alloy Steel	Carbon Steel	Al. Alloy	Yellow Metals
Grinding	√√	√√	√√	--	--
General Machining	--	--	--	--	--
Drilling	--	--	--	--	--

√√ Main applications

Performance/ Benefits:

Excellent Cooling – has a very high heat transfer capability. It provides excellent cooling of the grinding wheel and the work piece. Extends wheel life.

Very Good Rust Protection – for both tools and work pieces.

High Grinding Accuracy – maintains surface geometry and ensures high surface finish.

High Rate of Chip Removal – readily removes chips and keeps the machine clean. Maintains good visibility.

Environment Friendly – formulation is free of chlorine, phenol and nitrites.

Concentration:

The type of machining, the hardness of water and the corrosion protection required decide the concentration. It is typically used at 1:50 fluid content.

Specification:

- IS 11186:1985 (Reaffirmed 2013)

Typical Physico-Chemical Data: MAK Sherol E

Characteristics	Method	Value
Colour, Oil	Visual	Blue
Appearance, Oil	Visual	Clear
Colour, Emulsion	Visual	Blue
Sp. Gr. @ 15.6°C	ASTM D 1298	1.23
Copper Corrosion, 100°C, 3 hrs.	ASTM D130	1a
Emulsion Test, 50:1 ratio in distilled water	IS 1448 P:68	0/0-0 (No oil, no cream)
Thermal Stability Test	IS 1448 P:100	Passes
pH, at 2% in distilled water	--	9.5

Additive:

EP	Phenol	Sulphur	Amines	Chlorine	Nitrites
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Storage & Handling:

The product should be stored inside. Keep it properly sealed to avoid contamination. Avoid freezing. Shelf life is 2 yrs. under protected storage conditions.

Health & Safety:

It is unlikely to be hazardous when properly used in recommended applications. Contamination of the coolant from other oils, greases, chemicals, dirty water etc. can occur during the use. It should be avoided. Regular monitoring of the in-use product is recommended.