

STABILIS 9230

METALWORKING FLUID FOR HEAVY DUTY MACHINING

Boron free mineral emulsion

DESCRIPTION

STABILIS 9230 is a high performance water soluble metalworking fluid concentrate developed for severe and very severe machining operations. The product is recommended for machining of Alloy Steel, Cast Iron, Copper Alloys, Aerospace aluminium alloys as well as Nickel, TiAl and Titanium. The product is approved **SAFRAN Pr-6300** for Aluminum, TiAl, and Titanium parts machining and compliant with **BOEING BAC 5008** specifications for aluminum, steel, titanium.

APPLICATIONS

STABILIS 9230 is a multi metal water based cutting oil recommended for high performance machining operations. It is recommended for the machining of ferrous and non-ferrous alloys as well as copper alloys. The product is suitable for working at high pressure upto 70 bar.

STABILIS 9230 is free from Formaldehyde release biocides. The advanced additive package ensures stable pH, good lubrication properties, for long time operations. The product is recommended for machining of aerospace aluminum alloys, nickel, TiAl and titanium. It is advisable to check the compatibility of the alloy before use.

ADVANTAGES

- SAFRAN PR6300 approval on aluminum, TiAl and titanium
- Excellent lubricating and cooling properties, improves surface finish
- Excellent emulsion biostability
- Reduction of tools wear
- High pressure compatible (up to 70 bars)
- Good release of tramp oils

TECHNICAL INFORMATION

TECHNICAL CHARACTERISTICS	UNITS	METHOD	STABILIS 9230
Color	-		Yellow
Density	-	ASTM D4052	0.980
pH	-	NFT 60.193	9.2 at 5 %
Break Point Corrosion	%	IP 287	2
Refractometer Factor	-		1.0
Water Hardness range	ppm		100-500

These characteristics are given only for information and can be updated over time.

RECOMMENDED CONCENTRATIONS OF USE

- General machining of aluminium: 6-8 %
- Tapping/ Threading: 6-12 %
- Reaming/ Sawing: 8-15 %
- Machining of nickel and titanium alloys: 6-12 %
- General machining of steel: 4-6 %
- Difficult machining of steel: 6-10 %

HEALTH AND SAFETY

- Bactericide, isothiazolinone, formaldehydes & formaldehydes releasers free
- Nitrites, MIPA and DEA free, without chlorinated and phosphorous additives
- Operator friendly: good dermatological behavior and easy to use

The refractometer reading must be multiplied by the refractometer factor to arrive at the real concentration.

STABILIS 9230 can be used for machining of most aluminium and copper alloys. However, we recommend to check the tendency of the alloy to stain before use.

INSTRUCTIONS

Before first fill, thoroughly clean the installation with an antiseptic such as **Contram CB3**. Drain and rinse the system with water.

If no volumetric mixing system is available, slowly pour **STABILIS 9230** into water while stirring continuously to achieve a correct preparation of the emulsion.

To ensure the best quality of emulsion and maximize the fluid efficiency, consult the **Good Practices Handbook - Metalworking Soluble Fluids**.

Storage Conditions :

The product should be stored between 5°C and 40°C for best performance. The product should be stored away from direct sunlight and in a cool, covered and dry area.

SERVICES AND EQUIPMENT

In addition to its product ranges, MotulTech can provide tools and services for the maintenance and monitoring of your lubricants. Please contact your technical sales representative for more information.

Information disclosed in this technical data sheet is based on MOTUL's experience and know-how in the development and manufacture of lubricants and other chemical products according to the current state of knowledge.

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