HANGSTERFER'S

Research, Development & Manufacturing of Metalworking Lubricants

Cobalt Grinder®

Synthetic Coolant Concentrate

GENERAL DESCRIPTION

- No Cobalt Leaching
- Excellent filterability
- Non Foaming
- Excellent cleanability

- Dye free
- Low odor
- Mild to operators
- Low pH at in-use dilution

Hangsterfer's Cobalt Grinder is a pure synthetic coolant deigned for the grinding of carbide. Cobalt leaching is a concern when grinding carbide materials with water based coolants, and the Cobalt Grinder addresses these issues. Designed with the ability to inhibit cobalt leaching, this product allows for the use of water when grinding carbide materials. Filterability is excellent as is work piece visibility. The Cobalt grinder may be cleaned with any aqueous or solvent-based parts cleaning system.

MATERIALS Primary Secondary Aluminum Alloys Low Carbon Steel Bass & Bronze Precious Metals Nickel Alloys Powdered Metals Copper Alloys Plastics & Composites Stainless Steel Tool Steel & High Speed Steel Ductile Iron **Refractory Metals** Carbide **Titanium & Ceramics** Cast Iron Glass High Carbon Steel

Application	Concentration				
General Grinding	Ratio Concentrate: Water	%	Refractometer Reading		
	1:20	5%	1.11		

Primary	Secondary		
Grinding of carbide-based materials where water based synthetic coolant is preferred.	May be used as a general-purpose synthetic grinding coolant if needed.		
Surface,Edge,ID,OD, * We have a full line of specialty oils designed for grinding carbide also*	Surface,ID-OD,etc.		

INSTRUCTIONS

Always premix coolant before adding to the machine sump. When mixing coolant by hand it is important to always add the concentrate to the water and then agitate. For best results a Hangsterfer's recommended proportioning unit should be used. To maintain recommended concentration, make-up should be added at one-half the desired concentration. To maintain 5%: first charge the machine at 5%, then as needed add make-up at 2.5%. Never add straight water or concentrate directly to machine.

Hangsterfer's Laboratories, Inc. 175 Ogden Road Mantua, New Jersey 08051 United States of America www.hangsterfers.com tel: 856-468-0216 fax: 856-468-0200 toll free North America: 800-433-LUBE

WASTE TREATEMENT

All Hangsterfer's soluble oils are designed for easy waste treatment. By separating the water phase from the oil and various contaminants, which accumulate through normal machining, you can reduce your waste disposal by 80%-90%. Hangsterfer's recommends Ultra Filtration or Chemical Treatment for removal of fats, oils, greases and heavy metals prior to disposal of the water phase. Following approval by your local authorities, your wastewater stream may be sewered and waste oils removed for recycling or disposal.

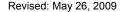
MAINTENANCE

Cobalt Grinder is a biostable coolant, designed to control the growth of bacteria. Regular maintenance is required for maximum performance. Concentration should be monitored regularly with a calibrated refractometer. The refractometer reading needs to be multiplied by 4.5 in order to determine the actual concentration (e.g. 1 on refrac. =4.5 %). Tramp oils should be removed from the coolant surface regularly to prevent unwanted bacterial growth. Keep the coolant system free of cleaners, solvents and other contaminants. Please note that the Cobalt Grinder will run clear at design levels of 5%. If it drops below design levels, it will start to turn pink, indicating the presence of cobalt in the solution. Always maintain correct concentrations.

Product	Cobalt Grinder	Concentration Dilution Table			
Form	Liquid				
Color	Golden				
Odor	Mild				
Specific Gravity	1.04	%	Ratio	Refractometer	
Viscosity: SUS @ 100°F	14.1	5	20:1	1.10	
cSt @ 40°C	3.1	10	10:1	2.20	
Flash Point, COC, °F/°C	Not_Flammable				
Fire Point, COC, °F/°C	Not_Applicable				
Pour Point, °F/°C	NA				
Solubility in Water	100%				
Boiling Point, °F/°C	199/93				
Vapor Pressure, mm Hg @ 25°	12.20 psi				
pH @ 5%	9.5				
Chlorine	0	Refractive Index Multiplier = 4.5			

SHIPPING UNITS

Cobalt Grinder is available in 5 gallon, 55 gallon and Intermediate Bulk Containers (275 or 330 gallons). All products are distributed worldwide.



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