

STARCHEM

StarSol 775

Premium Soluble Oil Cutting and Grinding Fluid Concentrate

GENERAL DESCRIPTION

StarSol 775 is a BIORESISTANT, premium soluble oil for moderate-to-heavy duty metalworking applications. This product provides excellent lubricity and corrosion control in machining and grinding of carbon steels, stainless steels, alloy steels, nodular and malleable cast irons, aluminum, brass, bronze, and copper. **StarSol 775** has been specifically formulated to significantly extend fluid life without relying on sump-side additions of expensive biocides.

APPLICATION

StarSol 775 is recommended for wide variety of metalworking operations including CNC milling, turning, drilling, gun drilling, boring, reaming, tapping, broaching, threading, sawing, and reaming operations for both ferrous and non-ferrous metals. Its excellent lubricity provides high surface-quality parts and improved tool life. **StarSol 775** is a true, multi-purpose product that is ideally suited for those customers that prefer to use one metalworking fluid throughout the shop.

ADVANTAGES

- Wide application range
- Superior microbial control for long sump life in “stand-alone” machines
- Excellent lubricity and corrosion control for ferrous and non-ferrous metals
- Low foam, odor, and mist
- Reduced need for additives
- Easy recycling or disposal

StarSol 775 does not contain nitrite or phenolic biocides.

PHYSICAL PROPERTIES

Form	Clear, Amber Liquid	Specific Gravity (H₂O=1)	1.01
Boiling Point	NA	pH (concentrate)	NA
Flash Point	350°F	Typical Operating pH Range	8.8 – 9.2
Solubility in Water	100% Miscible	Refractometer Factor	1.0

AVAILABILITY

StarSol 775 is available in 5-gallon pails, 55-gallon drums, and in bulk.

RECOMMENDED STARTING DILUTIONS

Centerless, ID, OD, Surface Grinding	5.0%
Moderate Duty Machining	6.0%

Some heavy duty applications will require higher starting dilutions (7% - 10%)

MIXING INSTRUCTIONS

Always add **StarSol 775** concentrate to water. Mix concentration can be determined using a refractometer.

StarSol 775 CONCENTRATION

Concentration	4% (1:25)	5% (1:20)	6% (1:17)	7% (1:14)	10% (1:10)
Refractometer Reading	4.0	5.0	6.0	7.0	10.0

StarSol 775 is not recommended for use on magnesium or alloyed magnesium

Using premixed concentrate as makeup will improve performance and reduce usage. The specific makeup concentration selected for your situation should balance the water evaporation rate with the coolant carry-off rate. Adding makeup concentrate at 30-50% of the desired working concentration will generally maintain the proper concentration in use. The use of deionized or mineral-free water will also improve performance, prolong sump life, and reduce concentrate usage.

HEALTH & SAFETY

The most recent MSDS is available from either **STARCHEM** or your authorized **STARCHEM** Distributor.

NOTES

- Consult **STARCHEM** before using this product on any metals or applications not specifically recommended
- Do not use any metalworking fluid additives except as recommended by **STARCHEM**
- The general description, recommended uses, application data and statements in the product literature are guidelines. Because this product may be used for a variety of applications over which the manufacturer has no control, the manufacturer assumes no liability for incidental, consequential, or direct damages of any kind, regardless of causes, including negligence.

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