

STARCHEM

StarSol 775AL

Premium Soluble Oil Cutting Fluid Concentrate

GENERAL DESCRIPTION

StarSol 775AL is a BIORESISTANT, premium soluble oil for heavy-duty metalworking applications. This product contains an effective combination of high quality mineral and vegetable oils, and extreme pressure lubricants that provide excellent surface finish and improved tool life on tough-to-machine, high-silicon aluminum alloys. **StarSol 775AL** has been specifically formulated to significantly extend fluid life without relying on sump-side additions of expensive biocides.

APPLICATION

StarSol 775AL is recommended for wide variety of metalworking operations including CNC milling, turning, drilling, boring, tapping and reaming of aluminum alloys. This product can be used in “stand-alone” machines and central systems. **StarSol 775AL** exhibits low foam characteristics in soft water and high-pressure applications.

ADVANTAGES

- Wide application range
- Superior microbial control for long sump life
- Excellent lubricity
- Low foam and odor
- Reduced need for additives

StarSol 775AL does not contain nitrite, dicyclohexylamine or phenolic biocides.

PHYSICAL PROPERTIES

Form	Clear, Amber Liquid	Specific Gravity (H₂O=1)	0.96
Boiling Point	NA	pH (concentrate)	NA
Flash Point	350°F	Typical Operating pH Range	8.8 – 9.1
Solubility in Water	100% Miscible	Refractometer Factor	1.0

AVAILABILITY

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

RECOMMENDED STARTING DILUTIONS

Milling, Drilling, Turning	5% - 7%
Boring, Tapping, Reaming	8% - 12%

Extremely heavy duty applications may require higher concentrations.

MIXING INSTRUCTIONS

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

StarSol 775AL CONCENTRATION

Concentration	4% (1:25)	5% (1:20)	6% (1:17)	7% (1:14)	8% (1:13)	9% (1:11)	10% (1:10)
Refractometer Reading	4.0	5.0	6.0	7.0	8.0	9.0	10.0

StarSol 775AL is not recommended for use on 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.

This product is to be used within six months of its manufacture date as indicated by the lot number on the container label.

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.

CIMCOOL® FLUID TECHNOLOGY

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