



Product Data

## Syntilo 9913

Synthetic coolant

### Description

Castrol Syntilo® 9913 is a pH-neutral synthetic cutting and grinding metalworking fluid formulated without mineral oil, boron and formaldehyde releasing agents. Syntilo 9913 is has been developed for heavy duty machining of aluminum and other aerospace alloys. Syntilo 9913 also provides excellent product stability which helps to lower the overall operational costs.

### Application

Syntilo 9913 is recommended for machining of aluminum and aerospace alloys.

Approved by Boeing and Airbus for aluminum alloys.

ü ü suggested core application ü possible application, please consult Castrol representative prior to use

	Cast Iron	Low-medium alloyed steel	High alloyed - stainless steel	Aluminum alloys	Titanium alloys	Tungsten Carbide
Grinding		ü ü	ü ü	ü ü		
Milling, Turning (general machining)		ü ü	ü ü	ü ü	ü ü	
Drilling		ü ü	ü ü	ü ü	ü	
Reaming, Tapping		ü	ü	ü	ü	
Broaching		ü ü	ü ü	ü ü		

### Advantages

- Neutral pH protects aluminum and other aerospace alloys and promotes strong operator acceptance
- Low foaming in all recommended water conditions (see details below)
- Extended fluid life can help to reduce maintenance and downtime
- Rejects tramp oil to the surface of the fluid for easy removal
- Settles chips quickly to prevent grinding wheel build-up and maintain a clean working environment
- Formulated without Boron, Formaldehyde releasing agents and nitrites which help to fulfill aspects of legislative and waste treatment requirements where applicable

## Typical Characteristics

	Test Method	Unit	Value
<b><u>Concentrate</u></b>			
Appearance	Visual		Light Yellow
Mineral oil content	Calculated	Wt%	0
<b><u>Solution</u></b>			
Appearance	Visual		Transparent
pH (5%)	DIN 51369 ASTM E70-97		7.4
Refractometer Factor	BRIX unit Multiplier		1.4

Subject to usual manufacturing tolerances.

## Recommended Concentrations

Grinding	6 - 8 %
General Machining	7 - 10 %
Drilling	8 - 11 %
Reaming	8 - 12 %
Broaching	10 - 15%

Water range                      0 - 250 ppm CaCO<sub>3</sub>

## Additional Information

	Boron	Formaldehyde releasing agent	EP-Ester	Amines
Additives			ü	ü

## Storage

To avoid product deterioration always keep the container/drum tightly sealed. Store the product in a cool, dry place away from direct sunlight. Prevent exposure to frost and avoid water ingress. For optimum product stability, it is preferable to store the product indoors between 5°C and 45 °C / 41°F and 113°F.

For more details, please refer the product safety data sheet.

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