

TECHNICAL BULLETIN

COOLANT MIXING

GENERAL REMARKS AND WARNINGS

Sta-Vis STA-KOOL HAS BEEN UP GRADED as part of Como's continuing effort to provide the finest coolants to the metalworking industry. Sta-Vis STA-KOOL Coolants are specially formulated for the more demanding environments found in today's metalworking operations. Sta-Vis STA-KOOL Coolants have been enhanced to meet operator concerns over water quality, low and high temperature exposure, fluid stability, odor, and exotic metal machining; as-well-as recent regulatory changes on the state and federal level.

The new Sta-Vis STA-KOOL Coolants offer improved cooling with less smoke and reduced staining of both ferrous and nonferrous metals. They provide better finishes and closer tolerances, with fewer rejects. With their use, tool life is increased between regrinds. In heavy duty use chip welding is reduced. Even with these additional features Sta-Vis STA-KOOL Coolants continues to be economically priced.

Sta-Vis STA-KOOL 110 Coolant is a very heavy duty, water soluble cutting oil recommended for difficult welding operations on ferrous and exotic metals. It will stain some nonferrous alloys.

MANUAL MIXING INSTRUCTIONS

Always add the required amount of Sta-Vis STA-KOOL concentrate to the required amount of water. NEVER THE REVERSE. To achieve optimum emulsion stability, DO NOT add Sta-Vis STA-KOOL concentrate directly to the working solution in the machine tool. PREMIXING OF THE INITIAL CHARGE AND/OR MAKE-UP SOLUTION is suggested as follows:

1) Fill a container with an amount of water equal to THREE TIMES (3 x) the required amount of Sta-Vis STA-KOOL concentrate. 2) Slowly add the required amount of Sta-Vis STA-KOOL concentrate to the water with continuous stirring. 3) Continue stirring until the emulsion is uniform. 4) Add this premix to the total required amount of water with continuous stirring.

CAUTION

This product is not designed for use with magnesium, cadmium, lead or alloys containing substantial concentrations of these metals. Should it be used with these metals, there is a chance of product deterioration, adverse health effects and corrosion of work materials and machine parts and fixtures.