

Art. No. 11735-02

Synergy 735

Description

Synergy 735 is a water-miscible, oil free, full-synthetic metalworking fluid. It is characterized by its excellent aluminium compatibility and easy cleanability, so that it meets the highest demands on surface quality and cleanliness.

Range of application

Synergy 735 is applicable for machining of aluminium, titanium alloys, steel, stainless steel, copper alloys and CFRP.

Product properties

Neutral pH	→
Outstanding rinsing behaviour and easy cleanability	→
Crystal clear	→
Low foaming	→
Excellent filterability down to 1 micron	→
Free of bactericides, neutral pH	→

Benefits

Spotless surfaces even with sensitive aluminium alloys
Suitable for precision cleaning
Clear view of the machining process
Ideal for high-pressure systems
High surface quality and process reliability
Good human and skin compatibility

Physical-chemical data

Concentrate

Colour	colourless
Mineral oil content	0 %
Density at 20°C	1.06 g/cm ³
Viscosity at 40°C	53 mm ² /s
pH value (fresh solution)	7.5 – 8.1
pH value (used solution)	7.5 – 8.2
Refractometer factor	1.4

Solution

transparent

Note

The product does not contain:

Mineral oil, chlorine*, heavy metals, boron, secondary amines, silicone, bactericide, Isothiazolinone, Formaldehyde, nitrosamines, glycol ether, sulphur.

*Without active addition of chlorinated EP additives.

The substances listed here are not part of the formula, but trace amounts of these substances may be present.

Do not produce parts after adding the alkaline system cleaner to Synergy 735. The high pH reduces the lubricity.

Never add alkaline system cleaner or pH booster to Synergy 735. A high pH will reduce the lubricity.

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Concentration of use

Typically used at: 6 – 10% (refractometer reading: 4.3 – 7.1)

Variable concentrations from: 6 – 15% (refractometer reading: 4.3 – 10.7)

Instruction for use

Product designed for use with demineralized water (DI-water, <50 µSiemens [µS]) only.

The use of calcium acetate to control foaming is prohibited. If foam should appear contrary to expectations, we recommend the following antifoam products:

Recommended antifoam: Additive A33, Art. No. 29106-02

