

# STARCHEM

## StarBright 485LF

### *Semisynthetic Cutting and Grinding Fluid Concentrate*

#### GENERAL DESCRIPTION

**StarBright 485LF** is a low-foaming, BIORESISTANT semisynthetic, cutting and grinding fluid for moderate to heavy duty metalworking applications. This product has been specifically formulated to significantly extend fluid life without relying on sump-side additions of expensive additives. **StarBright 485LF** contains a unique and effective combination of high quality mineral and vegetable oils, and extreme pressure lubricants to provide excellent lubricating properties in both ferrous and non-ferrous applications.

#### APPLICATION

**StarBright 485LF** is recommended for a wide variety of moderate to heavy duty metalworking operations including CNC milling, turning, drilling, boring, tapping, threading, and grinding. It is compatible with a wide range of materials including most aluminum alloys, steels, cast irons, and copper alloys. **StarBright 485LF** is a true, multi-purpose product that is ideally suited for those customers that prefer to use one metalworking fluid throughout the shop. It can be used in “stand-alone” machines and central systems.

#### ADVANTAGES

- Superior rancidity control for long sump life
- Excellent lubricity and corrosion control for ferrous and non-ferrous metals
- Low odor and mist
- Extremely clean
- Easy recycling or disposal

**StarBright 485LF** does not contain nitrite, sulfur, dicyclohexylamine or phenolic biocides.

#### PHYSICAL PROPERTIES

<b>Form</b>	Clear Liquid	<b>Specific Gravity (H<sub>2</sub>O=1)</b>	1.02
<b>Boiling Point</b>	212°F	<b>pH (concentrate)</b>	9.4
<b>Flash Point (COC)</b>	NA	<b>Typical Operating pH Range</b>	8.8 – 9.0
<b>Solubility in Water</b>	100% Miscible	<b>Refractometer Factor</b>	1.5

#### AVAILABILITY

**StarBright 485LF** is available in 5-gallon pails, 55-gallon drums, and in bulk.

**RECOMMENDED STARTING DILUTIONS**

Milling, Drilling, Turning	5% - 8%
Tapping, Reaming, Sawing	8% - 12%
Centerless, ID, OD, Surface Grinding	5% - 7%

**MIXING INSTRUCTIONS**

Always add **StarBright 485LF** concentrate to water. Mix concentration can be determined using a refractometer.

**StarBright 485LF CONCENTRATION**

<b>Concentration</b>	<b>4%</b> <b>(1:25)</b>	<b>5%</b> <b>(1:20)</b>	<b>6%</b> <b>(1:17)</b>	<b>7%</b> <b>(1:14)</b>	<b>8%</b> <b>(1:13)</b>	<b>9%</b> <b>(1:11)</b>	<b>10%</b> <b>(1:10)</b>
<b>Refractometer Reading</b>	2.7	3.3	4.0	4.7	5.3	6.0	6.7

**StarBright 485LF** 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.

This product is to be used within six months of the manufacture date 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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