



Shell Sitala CD 400

Water extendible metalworking fluid

Shell Sitala CD 400 is a chlorinated metalworking fluid recommended for all types of machining operations of ferrous metals and aluminum alloys.

Applications

Shell Sitala CD 400 is an excellent, problem-free, general purpose product to be recommended for all types of machining operations of cast iron, steel, and aluminium alloys.

Performance Features and Benefits

- **High lubricity** – assuring prolonged tool life, increased surface finish and lower reject rate
- **Good foaming behavior**
- **Good biostability** - encouraging longer service life
- **Good corrosion protection**
- **Good detergency** - offering low drag out, clean work pieces and machine tools, and a better working environment

Recommended Concentrations

The concentration varies depending on the type of machining operation, the water hardness, and the required corrosion protection. The recommended concentrations for use in medium water hardness are:

- General machining : 4 – 6 %
- Severe cutting operations : 7 – 12 %
- Grinding : 4 – 6 %

Storage

The product should be stored inside (41-104°F) for no more than one year. Freezing should be avoided.

Health & Safety

Please note that mixed coolants work over long periods of time, therefore chemical contamination (hydraulic oils, greases, metal solutions, paints, rust inhibitors, etc.) or bacterial contamination (from dirty hands, work pieces, industrial grade water, sundry waste, etc.) can often occur. Contamination with the above materials should be minimized/eliminated. Regular monitoring of the in-use product is recommended to maintain optimum product condition and for determination of its useful working life.

Protect the environment

Waste must be disposed of in accordance with EC Directive 91/156, 91/689 and 94/62 or in line with local legislation.

Typical Physical Characteristics

	Unit	Method	Shell Sitala CD 400	
Product Codes			Drum	5072604
			Pail	5073383
Mineral Oil content	%		32	
Kinematic Viscosity @ 20°C	mm ² /s	ASTM D 445	400-500	
Density @ 20°C	g/mL	ASTM D 1298	0.995	
pH of the emulsion at 3%		DIN 51369	9.25	
Min Anti-Cor. Protection Limit (0-0)	%	DIN 51360/2	4.0	
Refractometer Factor			1.2	
Acid Split Factor			1.5	

These characteristics are typical of current production. While future production will conform to Shell's specification, variations in these characteristics may occur.