

# 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.

### 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

Advice on applications not covered in this handbook may be obtained from your Shell representative.

### 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 Requirements

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

### Handling and Safety Information

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.

For information on the safe handling, storage, or use of this product, refer to its Material Safety Data Sheet at <http://www.epc.shell.com/>. If you are a Shell Distributor, please call 1+800-332-6457 for all of your service needs. All other customers please call 1+800-237-8645 for all of your service needs.

### Protect the Environment

Do not discharge into drains, soil, or water.

### Typical Physical Characteristics

	Unit	Method	SHELL SITALA® CD 400
Mineral Oil content	%		32
Kinematic Viscosity @ 20°C	cSt	ASTM D 445	400-500
Density @ 20 °C	kg/L	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 specifications, variation in these characteristics may occur.*