



Shell Adrana D 208

Water miscible metalworking fluid

Shell Adrana D 208 is a high quality, general-purpose metalworking fluid for easy to medium duty applications on ferrous metals.

chlorine, secondary amines, phenol and nitrite

Applications

Shell Adrana D 208 is recommended for easy to medium duty operations on cast iron and (low to medium alloyed) ferrous metals. It is designed to be used on CNC machine tools, due to its excellent detergency and high wetting properties. Shell Adrana D 208 is suitable for all removal and grinding operations as well on standalone machines as in central systems. Shell Adrana D 208 is employable over a broad water hardness range.

Performance Features and Benefits

- **Very high stability** – extending the fluid life
- **Good cooling properties** that provide sufficient tool life and part geometry
- **Excellent detergency** – resulting in clean parts, clean machines and assisting in creating a more pleasant working environment
- **Excellent corrosion protection** – due to presence of specific anti-corrosion inhibitors; resulting in lower reject rate and decreasing maintenance cost related to corrosion issues
- **Very low foam** – guaranteeing problem free working operations and allowing high pump pressures and flow rates
- **Good separation of tramp oil** – which as a result can easily be removed as thus supporting a long fluid life
- **Environmental compliance** – free of

Recommended Concentrations

The concentration varies depending on the type of machining operation, the water hardness and the required inter-operational corrosion protection.

- General machining : 4 – 6 %
- Severe cutting operations : 5 – 8 %
- Grinding : 3 – 5 %

Storage

The product should be stored inside (5-40°C) for no more than 1 year and be protected from freezing.

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 minimised or ideally eliminated. Regular monitoring of the in-use product is recommended to maintain optimum product condition and determine the end of its useful working life.

Protect the environment

Waste must be disposed of in accordance with local legislation.

Typical Physical Characteristics

	Unit	Method	Shell Adrana D 208
Mineral Oil content	%		22
Kinematic Viscosity @ 20°C	mm ² /s	ASTM D 445	120 - 220
Density @ 20°C	kg/m ³	ASTM D 1298	1020
pH of the emulsion at 5 %		DIN 51369	9.5
Min Anti-Cor. Protection Limit (0-0)	%	DIN 51360/2	4
Refractometer Factor			1.6
Acid Split Factor			3.1

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