Biocides for metalworking fluids

Optimal protection for your products and plant
For over 115 years our business philosophy has had an unwavering focus: hygiene & preservation

Schülke & Mayr GmbH is a chemical and pharmaceutical company. Our products and services protect people and materials against infection and contamination.

Today, more than ever, germs cross borders. Their existence is dangerous, but not as dangerous as the underestimation of their threat to people and material. Taking precautions plays a special role – preventing contamination and infections is far easier than combating them. schülke is fighting diseases and contamination before they emerge. For this we offer innovative technologies, highly effective products and expert support services.

Our company philosophy is based on a total quality concept that not only considers the quality of our products in the sense of effective product formulas, but one that encompasses a vast array of dimensions; such as:

- workplace safety
- environmental management and
- leadership and cooperation in our quality concept

The demand for total quality at schülke creates more than economic success. This concept is responsible for a sustainable contribution to the environment and society.

To realise this total quality concept our company values focus on:

- **Partnership**
  Not only in our daily cooperation, but also in the long term, we want to be a dependable partner for our customers worldwide. With expert customer advice and an all-encompassing support service, we ensure that the interests of all parties are satisfied. This also applies to our relations with suppliers and other business partners.

- **Initiative**
  Forward thinking and taking action is a major factor of our success. We have to recognise the challenges of the future in order to be able to offer timely solutions. The desire for innovation also ensures our future competitiveness and the company’s success.

- **Reliability**
  Reliability is a prerequisite for successful cooperation as it creates trust, and trust is the basis of long-term partnerships and sustainable success.

Our goal is the continual improvement of products, processes and services in order to ensure economic success, customer satisfaction and corporate social responsibility.
Special Additives International – our expertise from preservation to multifunctional additives

- **Metalworking fluids**
  Microbiological spoilage of water-mixed metalworking fluids is one of the biggest threats for quality assurance, work and process safety in the mass production of metal parts; for example in the automotive industry. With the grotan® product line, schülke offers the metalworking industry a complete range of tailor-made biocides for all possible applications; such as preservation of metalworking fluid concentrates, post treatment of water-mixed metalworking fluids and microbiocidal system cleaners.

- **Coatings and Building Materials**
  The prevention of microbiological degradation of products containing water is one of the most important challenges now and in future. schülke provides modern types of formulated in-can preservatives to protect your products under the brand names parmetol® and grotan®. Furthermore, with distinctive dry film preservatives we keep coated surfaces free from growth of fungi and algae and help to avoid material destruction and visible disfigurement.

- **Household**
  Most cleaning products found in households today are water-based systems. These products are prone to microbiological build-up. To be safe for consumers to use, they require the protection of preserving agents. With the parmetol® and grotan® ranges, schülke offers products to preserve a wide range of household applications.

- **Personal Care**
  Our euxyl® brand provides numerous preservative blends for the cosmetic industry. These optimised combinations of active substances offer broad spectrum efficacy, keeping cosmetic products free of microbial growth.
  Our sensiva® brand includes versatile, multifunctional skin care additives for personal care products. With their unique properties, they are suitable for use in a wide range of cosmetic applications; including creams, lotions and deodorants.

- **MQM**
  We support our customers with a comprehensive concept of Microbiological Quality Management (MQM) including lab services, application advice, plant audits and training programs for employees. It is not only a matter of eliminating the risk of infections for people, but also of protecting products and equipment from contamination.
There is a number of factors to consider when choosing a suitable preservative for your product; different ingredients, pH value, material compatibility and legal approvals, to name a few. The large number of possible microorganisms, different packaging and storing conditions, and the enormous diversity of raw materials imposes demands that cannot be covered by just one microbial active used at an acceptable dosage. With the comprehensive grotan® and parmetol® product line, schülke has developed sophisticated multi component preservative systems to sufficiently protect your products.

The optimum combination of selected active substances offers sustainable preservation for all kinds of water based formulations used in metalworking fluid concentrates and other technical products.

Product benefits of grotan® and parmetol® at a glance:

- broad, balanced spectrum of efficacy against bacteria, yeast and mould
- liquid, stabilised formulations
- easy handling, safe application
- sustainable efficiency even at higher pH values and temperatures
- compliance with legal requirements, e.g. BPD, REACH, TRGS 611, etc.

Our biocides act rapidly and effectively, without altering the specific properties of the coolant. The protection against microbiological damage is lasting and is resistant to high temperatures and the effect of organic and inorganic substances. Our preservatives have good material compatibility and meet international legal requirements; e.g. in the countries of the European Union (EU) our products are supported under the Biocide Product Directive (BPD) and REACh.
Microorganisms – a threat to your products and plant

Water-based operations like drilling, turning, milling, sawing, grinding, etc. are used nearly everywhere in metalworking. However, the water in the coolants offers microorganisms an attractive environment to grow. Contamination and subsequent spread of bacteria, yeasts and fungi can therefore hardly be avoided. As a result of their high growth potential, microbes can multiply within a few hours from 100 to 10,000,000 organisms per ml.

The consequences of microbial contamination are unpleasant and can lead to expensive manufacturing failures. The microorganisms can alter both the composition of the coolant and the technical properties, e.g. decreasing the amount of emulsifiers leading to manufacturing and quality problems. Microorganisms excrete metabolites that decrease the pH value and cause unpleasant odours. Uninhibited growth can lead to the formation of biofilms in the system. These can grow to a thickness of several centimetres and result in blockages of pumps and filtration units.

The symptoms of contamination are diverse and unpleasant:

- decrease in pH value
- corrosion
- blockage of pipes and filters
- odour formation
- oil separation
- foam formation
- sudden occurrence of skin irritation

Biofilm formation on system cover which is a high recontamination source for fresh coolants

Extrem mould formation in contaminated system. In this case complete system sanitation with biocidal system cleaner and mechanical cleaning is crucial.

Corrosion caused by microorganisms
### Preservation of water-mixed metalworking fluids and technical emulsions

#### grotan® and parmetol® biocides

<table>
<thead>
<tr>
<th>Product</th>
<th>Recommended application and use concentration (%)</th>
<th>Actives</th>
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</thead>
<tbody>
<tr>
<td></td>
<td>Metalworking concentrate</td>
<td>Water-mixed metalworking fluids, post treatment</td>
</tr>
<tr>
<td>grotan® A 12</td>
<td>1.00 – 4.00</td>
<td>0.05 – 0.20</td>
</tr>
<tr>
<td>grotan® BA 21</td>
<td>0.40 – 2.00</td>
<td>0.02 – 0.20</td>
</tr>
<tr>
<td>grotan® BK</td>
<td>2.00 – 4.00</td>
<td>0.10 – 0.15</td>
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<tr>
<td>grotan® OK</td>
<td>2.00 – 4.00</td>
<td>0.10 – 0.15</td>
</tr>
<tr>
<td>grotan® OF</td>
<td>2.00 – 4.00</td>
<td>0.10 – 0.15</td>
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<tr>
<td>grotan® WS</td>
<td>2.00 – 4.00</td>
<td>0.10 – 0.15</td>
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<tr>
<td>grotan® TK 5</td>
<td>2.00 – 4.00</td>
<td>0.10 – 0.15</td>
</tr>
<tr>
<td>grotan® TK 6</td>
<td>2.00 – 4.00</td>
<td>0.10 – 0.15</td>
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<tr>
<td>grotan® F 10</td>
<td>0.20 – 0.50</td>
<td>0.015 – 0.03</td>
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<tr>
<td>grotan® F 15</td>
<td>1.00 – 2.00</td>
<td>0.05 – 0.10</td>
</tr>
<tr>
<td>grotan® F 30</td>
<td>0.30 – 0.60</td>
<td>0.015 – 0.04</td>
</tr>
<tr>
<td>grotan® OK plus</td>
<td>2.00 – 4.00</td>
<td>0.10 – 0.15</td>
</tr>
<tr>
<td>grotan® WS plus</td>
<td>2.00 – 4.00</td>
<td>0.10 – 0.15</td>
</tr>
<tr>
<td>grotan® forte</td>
<td>2.00 – 4.00</td>
<td>0.10 – 0.15</td>
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<tr>
<td>grotan® OD</td>
<td>–</td>
<td>0.10 – 0.15</td>
</tr>
<tr>
<td>grotan® TK 2</td>
<td>–</td>
<td>0.10 – 0.15</td>
</tr>
<tr>
<td>grotan® TK 5 plus</td>
<td>2.00 – 4.00</td>
<td>0.10 – 0.15</td>
</tr>
<tr>
<td>grotan® 14</td>
<td>–</td>
<td>0.005 – 0.035</td>
</tr>
<tr>
<td>parmetol® DF 70 N</td>
<td>–</td>
<td>0.10 – 0.15</td>
</tr>
<tr>
<td>parmetol® A 35</td>
<td>–</td>
<td>0.10 – 0.20</td>
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<tr>
<td>parmetol® K 20</td>
<td>–</td>
<td>0.10 – 0.20</td>
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<tr>
<td>parmetol® D 11</td>
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<td>0.10 – 0.20</td>
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<tr>
<td>parmetol® N 40</td>
<td>max. 1.20</td>
<td>0.10 – 0.20</td>
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<tr>
<td>grotanol® SR 1</td>
<td>–</td>
<td>–</td>
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<tr>
<td>grotanol® SR 2</td>
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<td>–</td>
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<tr>
<td>grotanol® 3025</td>
<td>–</td>
<td>–</td>
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<tr>
<td>grotanol® FF 1</td>
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**Notes:**

- 1) Use concentration above 0.13 % requires product labelling:
  - Xi: Irritant; R 43: May cause sensitisation by skin contact.
  - 3) Use concentration above 0.01 % requires product labelling: Xi; R 43
  - 4) Use concentration above 0.1 % requires product labelling: Xi; R 43
## Preservation of water-mixed metalworking fluids and technical emulsions

### Bactericides
- grotan® A 12
- grotanol® SR 1
- parmetol® N 40
- parmetol® D 11
- parmetol® K 20
- parmetol® A 35
- grotanol® FF 1
- grotanol® 3025
- grotanol® SR 2
- parmetol® DF 70 N

### Fungicides
- grotan® 14
- grotan® TK 5 plus
- grotan® TK 2
- grotan® OD
- grotan® forte
- grotan® F 30
- grotan® TK 6
- grotan® F 10
- grotan® F 15
- grotan® OX
- grotan® BK
- grotan® OK
- grotan® W5
- grotan® OK plus
- grotan® WS plus
- grotan® BA 21

### Technical properties
- Max. manufacturing temperature (°C)
- pH-range for application
- VOC-content according to Directive 2004/42/EG (%)

### Listings and approvals of active ingredients
- Technical emulsions
- Metalworking concentrate
- Aqueous systems
- Metalworking fluid plants, production plants
- Equipment

### Technical properties
- Product Type 1
- Product Type 2
- Product Type 3
- Product Type 4
- Product Type 5
- Product Type 6
- Product Type 7
- Product Type 8
- Product Type 9
- Product Type 10
- Product Type 11
- Product Type 12
- Product Type 13
- TRGS 011
- EMCS / ELUNCS (EUropa)
- TSCA (USA)
- DSL / NDSL (Canada)
- ECL (Korea)
- PICCS (Philippines)
- AICS (Australia)
- IECS (China)

### System cleaners

### Product type
- Bactericide
- Fungicide
- Amine-free
- Formaldehyde-free

### Actives supported under BPD in product groups

### Technical properties
- Product
- Bactericide
- Fungicide
- Amine-free
- Formaldehyde-free

### In preserved aqueous products the (ethylenedioxy)dimethanol can be described also as a hydrolising product, ethane-1,2-diol and formaldehyde.

### Status as of January 2009 given in good faith with the best of our knowledge
Our principle is:
As little as possible – as much as necessary

Use biocides safely. Always read the label and product information before use.
grotan® A 12 and grotan® BA 21 – the new way to formulate formaldehyde-free

schülke has launched a new product range to provide formaldehyde-free preservation for metalworking fluids and other aqueous systems. These products have been developed in response to the ongoing formaldehyde discussions in the EU, especially in France. The new way to formulate formaldehyde-free is the perfect solution for our customers.

grotan® A 12 has an excellent synergistic effect in combination with benzisothiazolone (BIT) and is effective even in low use-concentrations. BIT itself shows poor efficacy against pseudomonas. By the combination with grotan® A 12 the efficiency against pseudomonas species and other species can be boosted by a factor of 10. grotan® A 12 is the pure active bis(3-aminopropyl) dodecylamine (BDA) concentrate. This enables formulators to produce individual blends with BIT.

grotan® BA 21 is another formaldehyde-free preservative that is formulated ready to use. It contains BIT and grotan® A 12 in an optimised ratio to benefit from the synergistic effect between them. grotan® BA 21 is free of formaldehyde, chloromethylisothiazolinone and methylisothiazolinone. The efficacy of grotan® BA 21 against pseudomonas and other species is boosted by a factor of 10 when compared to BIT only. grotan® BA 21 is also effective when used as post/tankside treatment.

The efficacy of grotan® A 12 and grotan® BA 21 may depend on the selection of surfactants in the formulation. For further support please do not hesitate to contact us.

Benefits of grotan® A 12:
- pure active (BDA) concentrate
- suitable for formulators to produce individual formaldehyde-free blends with BIT
- achieves the same benefits and efficacy as grotan® BA 21 when combined with an optimised ratio of BIT

Benefits of grotan® BA 21:
- optimised ready-to-use biocide
- synergistic combination of BIT and grotan® A 12
- broad, balanced spectrum of effect against bacteria, yeasts and moulds
- enhanced efficacy especially against pseudomonas species
- free of chloromethylisothiazolinone, formaldehyde, formaldehyde donors and other aldehydes
- effective even in very low use-concentrations
Plant Hygiene Support

mikrocount®
– the convenient hygiene monitoring system

In addition to production hygiene measures, quality assurance concepts require routine hygiene monitoring during the production process and documentation of the results. Two dip slides, mikrocount® combi and mikrocount® TPC provide every operation with individual means of rapid and reliable hygiene controls. These dip slides can be used for testing raw materials, for in-process controls during the production process and for quality control of finished products. In addition mikrocount® TPC dip slides are provided with a hinge to simplify surface hygiene controlling.

mikrocount® dip slides enable simple sampling and evaluation of the results even by personnel without any microbiological training.

**product benefits of mikrocount® combi:**
- fast, safe and easy
- control of raw materials, intermediate and finished products
- separate evaluation of bacteria, yeast and moulds on different agar surface

**product benefits of mikrocount® TPC:**
- fast, safe and easy
- control of raw materials, intermediate and finished products
- control of surfaces, e.g. production line and packing materials
- agar neutralises disinfectants and preservatives
- total plate count agar
- validated by independent laboratories
- fulfill requirements for cosmetic GMP

**mikrocount® dip slides product benefits:**
- compact enough to use almost anywhere
- easy temperature adjustment
- designed for use with mikrocount® combi or mikrocount® TPC
- agar neutralises disinfectants and preservatives
- total plate count agar
- validated by independent laboratories
- fulfill requirements for cosmetic GMP

**mikrocount® TPC product benefits:**
- control of surfaces, e.g. production line and packing materials
- agar neutralises disinfectants and preservatives
- total plate count agar
- validated by independent laboratories
- fulfill requirements for cosmetic GMP

**cultura®
– the versatile small incubator**

The cultura® incubator is compact and versatile enough for almost any laboratory or manufacturing setting. The built in tray has room to hold up to 18 mikrocount® combi or mikrocount® TPC dip slide samples. A transparent door allows for viewing of the contents without removing samples from the incubator.

The adjustable temperature is pre-set by the manufacturer to maintain 30 °C an optimum temperature for incubating mikrocount® dip slides. Results for bacteria are available after 24 to 48 hours. The detection of yeast and moulds takes slightly longer (72 hours).

**product benefits:**
- compact enough to use almost anywhere
- easy temperature adjustment
- designed for use with mikrocount® combi or mikrocount® TPC

**More than a century of competence in preservation and hygiene...**
grotanol® SR 2
– the reliable system cleaner

Ensuring reliable product quality also requires a regular cleaning and microbiological sanitation of the production plant. grotanol® SR 2 is a mildly alkaline system cleaner (pH 10) which provides a good immediate effect at a low use concentration in combination with mechanical cleaning.

**product benefits:**
- excellent cleaning effect
- broad, balanced spectrum of effect against bacteria, yeast and moulds
- fast acting
- extremely low use concentration
- excellent material compatibility
- low foaming

**use / use concentrations:**
- production plants, circulating systems and equipment: 2.5 – 7.5 g/kg (0.25 – 0.75 %) in aqueous solutions

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**grotanol® 3025**
– the formaldehyde-free sanitiser

grotanol® 3025 is a low-foaming, formaldehyde-free sanitising concentrate based on aldehyde compounds. grotanol® 3025 has a balanced spectrum of effect against bacteria and fungi. grotanol® 3025 is intended for use in the cosmetic industry for microbiological sanitising of surfaces, plant and apparatus. Use-solutions of grotanol® 3025 can be stored for several months.

**product benefits:**
- formaldehyde-free
- broad spectrum of effect
- low-foaming, therefore also suitable for plant sanitisation of pumped circulating systems
- can be rinsed off without leaving residue (if rinsing is necessary)
- neutral pH value
- extensively tested material compatibility
- miscible with alkaline, anionic and non-ionic cleaning agents when diluted for use

**use / use concentrations:**
- production plants, circulating systems and equipment: 5 – 15 g/kg (0.5 – 1.5 %) in aqueous solutions

Use biocides safely. Always read the label and product information before use.
Our recommendations regarding our products are based on in-depth scientific testing in our Research Department; they are given in good faith, but no liability can be derived from them. It is the responsibility of the final product manufacturer to assure that claims made for the final product are in conformance with all applicable local laws. In other respect our Conditions of Sale and Supply apply.

This product information is not automatically updated.