Un Cool 44 BFF

Un Cool 44 BFF is a water miscible EP metalworking fluid based on mineral oil, free of amines and boric acid. A product of outstanding machining capability teamed with optimum protection for man.

Application

Un Cool 44 BFF is a special EP-coolant to be used for machining operations of aluminium and particularly suitable for aluminium alloys sensitive to staining, as well as for steel and cast materials. The EP additives make it the ideal choice for machining operationsof critical components like titanium alloys or non-cutting forming operations of galvanized parts.

Properties

- no staining on critical aluminium alloys
- excellent lubricating and cutting effects
- whitish, very finely dispersed emulsions
- high stability, low drag out losses
- good sump life
- good skin tolerance due to low ph values (8.2 – 8.8)
- preconserved

Technical Data

Concentrate		Emulsion	
Viscosity 20 °C (mm^2/s)	Content of mineral oil %	pH-value fresh preparation 5 %	Corrosions-protection (DIN 51360/1)
approx. 160	approx. 44	9.1	2 % R0-S0

Remarks

To prepare operating emulsion slowly add the coolant concentrate to drinking quality water assuring thorough mixing. Mixing can also be done by means of an automatic mixer.

Recommended mixing ratios:

Machining of aluminium, steel and cast:	from 4 %
Machining of titanium alloys	from 8 %
Non cutting forming operations	from 5 %

The concentration of the operating emulsion can be determined by means of a pocket refractometer. The °Brix value multiplied by the refractometer value equals the concentration in %. Sometimes reading of scale is more difficult with older emulsions because of the more coarse dispersity.

For the application please observe the valid VDI guidelines 3035, 3397 sheets 1 - 3. Protect against frost, heat and direct sunlight. Recommended storage and transport temperature: 5 - 40 °C.

Refractometer factor

1.0

Un Cool 44 BFF is free of chlororganic substances, nitrite and secondary amines. It contains natural raw materials. Therefore, slight degradations of colour and appearance are possible, however, quality and function of the product are not affected at all.

Subject to modification of the technical data. Please refer to the material safety data sheet for additional information or contact our application engineers.

Edition

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