



OEST COLOMETA BF 48 PN

Description

Water miscible coolant for metal cutting processes on individual machine tools as well as centralized systems. Special formulation results in high coolant stability and long coolant life. Active EP-additives ensure long tool life and often allow a reduction of concentration.

- contains mineral oil + esters + EP-additives
- free from Boron, bactericides, MEA, DCHA, BTA
- opaque emulsion with good washing action

Application

Universally applicable for severe machining processes. Preferably for hard-to-machine materials like high tensile & stainless steels, titanium grades, and also mixed materials including aluminium and yellow metals.

Processes

turning	milling	drilling	deep drilling	threading tapping	broaching	surface & cylindrical grinding	centerless grinding	profile grinding

preferred
 qualified

Materials

steels	cast iron	stainless steel	aluminium	yellow metals	Titanium, Nickel	carbide	glass ceramics

preferred
 qualified

Benefits

- ☺ very stable emulsion although free from boron & bactericides
- ☺ not skin irritating
- ☺ extraordinary cutting performance – enhanced tool life
- ☺ low-foaming



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Technical Data

Density (15°C)	0,96 g/cm ³
Kinematic viscosity	176 mm ² /s (20°C)
Corr.protection GG25	5% no corrosion
pH (5%)	9,6

Mixing recommendation

Manual mixing always by pouring concentrate into water (drinking quality) while stirring.

Easy to mix by automatic mixing device COLO MIX.

Recommended concentration:








Minimum:	5 %
Centerless grinding:	5 - 7 %
Cutting:	5 – 15 %



Concentration control:

By refractometer: measurement °Brix x F_{refr} = Vol-%
F_{refr} = 1,1

Suitable for water hardness [°dH]:

0	2-5	6-10	11-20	21-40	41-60	preferred 
						qualified 

HSE

Health & Safety:

Lubricants for metal working and -treatment may contain hazardous ingredients. For detailed information see the MSDS.

Water hazard class (german regulation): 2 (hazardous)

Transport & Storage

Storage temperature + 5 °C ... + 35°C.

Durability 12 months in closed packaging at recommended conditions.

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