

METAL REMOVAL FLUIDS

QUAKERCOOL® 7101 BFF METALWORKING WATER SOLUBLE COOLANT BORON FREE

APPLICATION SHEET

BENEFITS

- » Boron free
- » Formaldehyde free
- » Multi applications
- » Good anti-corrosion properties on all metals
- » Reduced maintenance cost
- » Maintains clean machine surfaces

APPLICATIONS

High performance micro-emulsion ideally suited to all operations where high surface finish quality and high lubrication is needed. Ideal for general purpose machining of most engineering materials

Recommended for all machining operations on steel, cast iron and aluminium alloys.

Concentration range:
8 - 12 % depending on type of operation

Make up water hardness:
170 - 340 ppm (17 - 34 °TH, 9 - 19 °DH)

FLUID MAINTENANCE

Poor or incorrect emulsion preparation may lead to instability and could considerably shorten the life of the emulsion. Prior to making any fresh fill, we highly recommend full cleaning including the use of a compatible systems cleaner of all system components which will be in contact with the emulsion. A wide range of system cleaners* and disinfecting additives* are available from Quaker.

*Please consult a Quaker representative for any additional information.



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STORAGE/PACKAGING

Quaker Chemical can supply this quality product in drums, in containers and in bulk. Other packages can be made available by Quaker Chemical or by distributors upon request.

As with all metalworking products, QUAKERCOOL® 7101 BFF should be stored in dry conditions and protected from extreme temperatures: 4 - 35 °C is the recommended storage temperature.

Good standards of personal and industrial hygiene are to be maintained by the user (see Material Safety Data Sheets).

This product has a recommended shelf life of:
6 months

OPERATIONS

Turning	●
Milling	●
Drilling	●
Deep hole drilling	●
Tapping-Threading	●
Reaming	●
Broaching	○
Sawing	○
Grinding	○
Honing-Lapping	

MATERIALS

Cast-iron	●
Steel	●
High alloy steel	●
Stainless steel	○
Aluminium alloys	●
Aero Aluminium alloys	○
Copper alloys	○
Titanium	●
Carbide tool	

● Main application ○ Possible application

PROPERTIES

PROPERTY	TYPICAL VALUE	UNIT
Appearance / Colour	Clear Yellow	[-]
Viscosity	55	[mm ² /s @ 40 °C]
Density	976	[kg/m ³ @ 15 °C]
Pour point	<0	[°C]
Appearance diluted	Translucent	[-]
pH diluted	9,7	[-]
Corrosion threshold	4	[% DIN 51360 T2]
Alkalinity factor (pH=5)	2,9	[ml 0,1N/%/ 25 ml]
Acid split factor	0,50	[ml/%]
Refractometer factor	1,3	[%/° Brix]

These characteristics are typical of current production and can't be used as a specification.

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Prior to using this product, consult the Material Safety Data Sheet for instructions regarding safe handling and environmental issues.

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