

METAL REMOVAL FLUIDS

QUAKERCOOL® 7330 BFF METALWORKING WATER SOLUBLE COOLANT BORON FREE

APPLICATION SHEET

BENEFITS

- » Formaldehyde, boron and secondary amine free
- » Wide range of water hardness
- » Very high emulsion stability even at high hardness
- » Good bio-resistance
- » Good tramp oil rejection
- » Provides good cleanliness on tools/machines and detergency characteristics

APPLICATIONS

Water dilutable semi-synthetic fluid, with a medium mineral oil content, suitable for machining and grinding operations on most engineering materials. This technology combines the cleanliness and detergency of a synthetic product with the unique properties of oil containing emulsions.

Recommended for general machining and grinding operations on steel and cast iron.

Concentration range:
5 - 8 % depending on type of operation

Make up water hardness:
90 - 500 ppm (9 - 50 °TH, 5 - 28 °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® 7330 BFF should be stored in dry conditions and protected from extreme temperatures: 4 - 35 °C is the recommended storage temperature.

QUAKERCOOL® 7330 BFF is unlikely to present any significant health or safety hazard when used as recommended by Quaker. Good standards of personal and industrial hygiene are to be maintained by the user (see Material Safety Data Sheets).

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 Light Amber	[-]
Viscosity	41	[mm ² /s @ 40 °C]
Density	1020	[kg/m ³ @ 15 °C]
Pour point	<4	[°C]
Appearance diluted	Translucent	[-]
pH diluted	9,6	[-]
Corrosion threshold	3,5	[% DIN 51360 T2]
Alkalinity factor (pH=5)	3,2	[ml 0,1N/%/ 25 ml]
Acid split factor	0,30	[ml/%]
Refractometer factor	1,7	[%/° 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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