

Mabanol Cut 165 BF

Mineral oil-based, water-emulsifiable metalworking fluid concentrate

Application

Mabanol Cut 165 BF is a water-emulsifiable cooling lubricant concentrate that was developed based on a modern additive and inhibitor combination specifically for the general machining of various aluminum alloys.

The boric acid-free, amine-containing cooling lubricant is also suitable for grinding and general machining of alloyed and unalloyed steels and cast iron.

Properties

Mabanol Cut 165 BF ensures excellent technical stability and offers good cooling and detergency properties. The product produces stable emulsions in make-up water from 5 °dH to 30 °dH, emulsion in use is stable up to 60 °dH.

Remarks

Correct preparation of a fresh solution is ensured by slowly pouring the concentrate into water while stirring continuously. Alternatively, an automatic mixing device can be used. The recommended concentration depends on the application and the materials to be machined:

Grinding: from 5%

General machining: from 7%

The concentration of the in-use solution can be verified by using a refractometer. The refractometer reading must be multiplied by the refractometer factor to determine the concentration. The product can be used for processing of most aluminum alloys based on the current industry standards. However, the tendency of the alloy to stain should be verified beforehand.

Data

	Unit	Value
Concentrate		
Mineral oil	%	approx. 35
Kin. Viscosity at 20 °C	mm ² /s	approx. 285
Emulsion		
pH at 5%		9,7
Corrosion protection DIN 51360/2		5% – note 0 (no corrosion)
Refractometer factor	%/°Brix	1,0

Shelf life / storage conditions

Stable for 12 months when stored at a temperature of 5 °C to 40 °C in unopened containers

The above values may vary within the commercial limits.
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