

# Mabanol Cut 245 BF

Mineral oil-based, water emulsifiable metalworking fluid concentrate

## Application

Mabanol Cut 245 BF is a water emulsifiable metalworking fluid concentrate for light machining and grinding of cast iron, steel, high-alloy steel and aluminium. It contains amine but is free of boric acid. The product is highly versatile due to an excellent emulsifier system, modern technology and outstanding lubricity additive package. Furthermore it works well in soft as well as in hard water.

## Properties

Mabanol Cut 245 BF offers good cooling and detergency properties. The concentrate forms a stable emulsion in water from 10 °dH to 30 °dH and is extremely stable in hard water. The emulsion ensures low foaming in recommended make-up water.

## Remarks

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

Machining of cast iron,  
steel and aluminium: from 5%  
Light machining: from 8%

The concentration of the in-use solution may be checked by using a refractometer. The refractometer reading must be multiplied by the refractometer factor to arrive at the concentration. When intending to machine aluminium alloys, we suggest checking in advance the tendency of the alloy to stain. Minor variations in colour and appearance are possible due to the raw materials that were chosen but have no effect on the functionality of the product.

## Data

	Unit	Value
<b>Concentrate</b>		
Mineral oil	%	20
Kin. Viscosity at 20 °C	mm <sup>2</sup> /s	119
<b>Emulsion</b>		
pH at 5%		up to 9,9 (drops during use)
Corrosion protection DIN 51360/2		5% – note 0 (no corrosion)
Refractometer factor	%/Brix	1,5

## 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.  
Updated in November 2018