

# Mabanol Cut 249 BF

Mineral oil-based, water-emulsifiable metalworking fluid concentrate

### Application

Mabanol Cut 249 BF is a water-emulsifiable fluid concentrate for grinding of cast iron, steel, alloy steel and aluminum. The product contains amine and is free of boric acid as well as formaldehyde releasing agents and thanks to its carefully selected emulsifiers, modern technology and excellent lubricity additives, the product is highly versatile. It works particularly well in both soft and hard water. Polar lubricity improvers and tight control of the in-use pH achieve optimum results when machining aluminum.

### Properties

Mabanol Cut 249 BF ensures good technical stability and offers excellent cooling and detergency properties. The product produces stable emulsions in make-up water from 10 °dH to 30 °dH; emulsion in use is stable up to 60 °dH. It can be used as a universal metalworking fluid for both freestanding and central systems.

### 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:

Grinding and general machining: from 5%

The concentration of the in-use solution can be checked by using a refractometer. The refractometer reading must be multiplied by the refractometer factor to reach the desired concentration. Based on current industry standards the product could be used for processing of most yellow metals and yellow metal alloys. However the tendency of yellow metals and yellow metal alloys to stain should be checked before use.

### Data

	Unit	Value
<b>Concentrate</b>		
Kin. Viscosity at 20 °C	mm <sup>2</sup> /s	60
Mineral oil	%	approx. 10
<b>Emulsion</b>		
pH at 5%		approx. 9,8
Corrosion protection DIN 51360/2		5% – note 0 (no corrosion)
Refractometer factor	%/Brix	1,9

### 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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