

Mabanol Cut 261 BF

Mineral oil based, water emulsifiable metalworking cooling fluid concentrate

Application

Mabanol Cut 261 BF is a water emulsifiable fluid concentrate for general machining e.g. turning, milling, drilling and sawing of cast iron, steel, high-alloy steel and aluminum. The product contains amine and is free from boric acid and thanks to its specially chosen top grade emulsifier system, 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 261 BF ensures good technical stability as well as good 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 machines and central systems

Mabanol Cut 261 BF is suitable for medium to heavy-duty machining.

Remarks

Correct preparation of a fresh emulsion 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:

General machining: from 6%
Heavy machining: from 8%

The concentration of the in-use emulsion may be checked by using a refractometer. The refractometer reading must be multiplied by the refractometer factor to arrive at the concentration. Based on current knowledge the product could be used for processing of most aluminum alloys. However the tendency of the alloy to stain should be checked in advance.

Data

	Einheit	Wert
Concentrate		
Kin. viscosity at 20°C	mm ² /s	approx. 220
Mineral oil	%	approx. 45
Emulsion		
pH at 5%		up to 9,9 (drops during use)
Corrosion protection DIN 51360/2		6% – note 0 (no staining)
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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