

Mabanol Cut 269 BF

Mineral oil-based, water-emulsifiable metalworking fluid concentrate

Application

Mabanol Cut 269 BF is a water-emulsifiable cooling lubricant concentrate developed specifically for general machining and grinding of alloyed and unalloyed steels and cast iron, based on a modern combination of additives and inhibitors.

This boric acid-free, amine-containing coolant is also suitable for light machining of aluminum and, in some cases, for non-ferrous metals. The polar lubricating components and pH adjustment during use are optimized for machining aluminum.

Properties

Mabanol Cut 269 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 8%

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.

Based on current knowledge, Mabanol Cut 269 BF is suitable for machining most aluminum alloys and common non-ferrous metal alloys. However, to be on the safe side, the aluminum alloy's tendency to stain should be checked before using the coolant concentrate.

Data

	Unit	Value
Concentrate		
Mineral oil	%	30
Kin. Viscosity at 20 °C	mm ² /s	125
Emulsion		
pH at 5%		up to 9,9 (decreases with use)
Corrosion protection DIN 51360/2		4% – note 0 (no corrosion)
Refractometer factor	%/°Brix	1,3

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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