

# Mabanol Cut 34

Mineral oil-based, water-emulsifiable metalworking fluid concentrate

## Application

Mabanol Cut 34 is a water-emulsifiable metalworking fluid concentrate especially for general to heavy-duty machining of cast iron, steel and alloyed steel as well as aluminum. The cooling lubricant containing boron and amine is free from formaldehyde releasers and can be used in a variety of ways thanks to a special, high-quality emulsifier system, modern technology and excellent lubricating components.

## Properties

Mabanol Cut 34 ensures excellent cooling and rinsing properties as well as very good technical stability. The concentrate forms a stable emulsion in preparation water from 5 °dH to 25 °dH and is stable in hard water up to approx. 80 °dH when in use.

Mabanol Cut 34 is used successfully in soft and hard preparation water and can be used universally on individually filled machines 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:

General machining, grinding: from 5%  
Heavy machining: from 10%

In The concentration of the in-use solution may be verified by using a refractometer. The refractometer reading must be multiplied by the refractometer factor to reach the desired concentration.

In general, the tendency to stain formation should be checked before processing aluminum. If necessary, the compatibility of the emulsion with non-ferrous metals can be increased by adding a filler.

## Data

	Unit	Value
<b>Concentrate</b>		
Mineral oil	%	approx. 28
Kin. Viscosity at 20 °C	mm <sup>2</sup> /s	130
<b>Emulsion</b>		
pH at 5%		9,3
Corrosion protection DIN 51360/2		5% – note 0 (no corrosion)
Refractometer factor	%/°Brix	1,4

## 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 January 2023