

Mabanol Cut E 98 BF

Mineral oil-based, water-emulsifiable metalworking fluid concentrate

Application

Mabanol Cut E 98 BF is a water-emulsifiable metalworking fluid concentrate suitable for general to heavy-duty machining (e.g. turning, milling, drilling, sawing and grinding) of cast iron, steel and high-alloy steels as well as aluminum. Thanks to its excellent flushing behavior, Mabanol Cut E 98 BF is optimized for machining cast iron and for use on portal milling machines.

Polar lubricity improvers allow the machining of aluminum. The product is highly versatile by virtue of its outstanding emulsifiers. Furthermore it operates well with soft as well as hard water.

Properties

Mabanol Cut E 98 BF contains amine but is free from boric acid and DCHA. The product ensures technical stability allowing longer sump life, good cooling and detergency properties as well as increased corrosion protection.

Mabanol Cut E 98 BF produces a stable emulsion in water from 5 - 30 °dH and offers stability in water of up to 80 °dH.

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 varies depending on the application and the materials which are machined:

General machining: from 5%

Heavy duty machining: from 8%

The concentration of the in-use emulsion may be verified 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 can 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 verified before use. Minor variations in color and appearance could occur depending on the selected raw materials but have no impact on the functionality of the fluid.

Data

	Unit	Value
Concentrate		
Mineral oil	%	approx. 40
Kin. Viscosity at 20 °C	mm ² /s	approx. 100
Emulsion		
pH at 5%		9,4
Corrosion protection DIN 51360/2		5% – note 0 (no staining)
Refractometer factor	%/°Brix	1,2

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 July 2023