

Mabanol Cut E 99 BF

Mineral oil-based, water-emulsifiable metalworking fluid concentrate

Application

Mabanol Cut E 99 BF is a water-emulsifiable metalworking fluid concentrate that was specially developed for general machining of copper, brass, bronze and other non-ferrous metal alloys.

The boric acid-free, amine-containing cooling lubricant promises excellent cutting performance thanks to a special, high-quality emulsifier system, modern technology and excellent lubricating components. The structure of Mabanol Cut E 99 BF is also optimized for processing cast iron and technical plastics, and the polar lubricity improvers also enable the processing of most steel and aluminum alloys.

Properties

Mabanol Cut E 99 BF guarantees good cooling and corrosion protection properties and, thanks to its very good technical stability, long emulsion life. Special additives prevent copper from dissolving and ensure long-term good flushing performance.

Mabanol Cut E 99 BF produces a stable emulsion in water from 5 - 30 °dH and offers stability in water of up to 100 °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%

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	%	26
Kin. Viscosity at 20 °C	mm ² /s	approx. 103
Emulsion		
pH at 5%		9,2
Corrosion protection DIN 51360/2		5% – note 0 (no staining)
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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