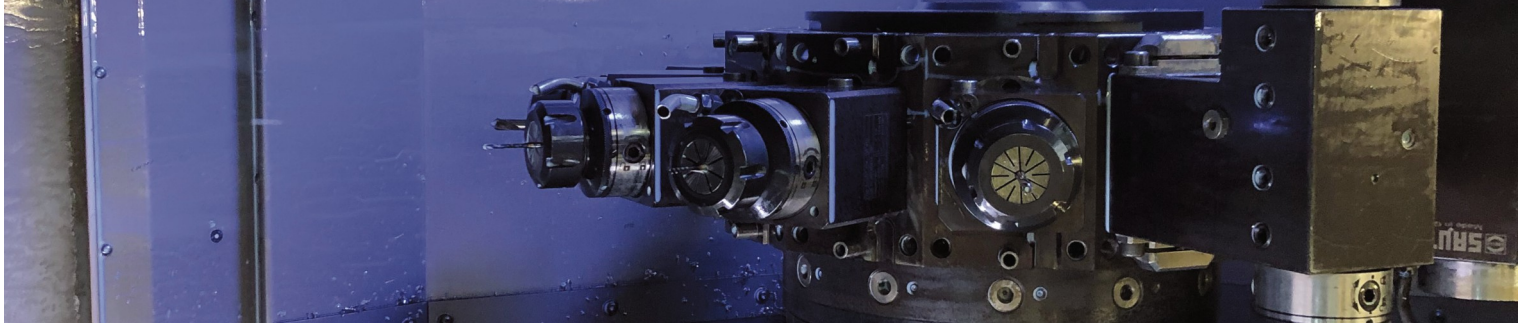


Mabanol Cut 264 BF reduces the top-up amount by 75% and enhances the lifecycle of the emulsion.\*



## Metal processing company | Bielefeld

### Initial situation

Various machining centres are used for turning, milling, drilling and thread cutting of different aluminium alloys (5000/6000/7000 group) and high-alloy steels.

Up to now, a water-miscible cooling lubricant based on phenoxyethanol has been used. The amount added is 2 - 2.5%. Due to bacterial growth, various adjusting agents such as bactericides and defoamers must be used. Despite the water softening system, the emulsion is also impaired by limescale deposits and lime soaps as well as high quantities of floating tramp oil after a short service life of only 2 months.

The objective is to prevent the precipitation of lime soaps, avoid setting agents and increase machine cleanliness.

### Recommendation

The use of Mabanol Cut 264 BF based on the new DCHA emulsifier technology is recommended. The resistance of this technology to bacterial growth promises longer emulsion service lives without

additional setting agents. Mabanol Cut 264 BF also prevents discolouration of the aluminium workpieces and ensures the longest possible tool life. On top of that, Mabanol Cut 264 BF is stable in hard water up to 60° dH and has been proven not to lead to the precipitation of lime soaps or oil.

### Advantage

By using Mabanol Cut 264 BF, significantly longer emulsion times are achieved without the need for any adjusting agents.

Furthermore, when using Mabanol Cut 264 BF, neither precipitation of lime soaps nor lime deposits can be detected in the machine rooms. The improved rinsing behaviour leads to significantly cleaner machines and drier chips and the amount of top-up can be reduced by 75% to 0.5%.

\*This proof of performance is based on the experience of a single customer. The actual results obtained may depend on the type of machine used and its maintenance, operating and environmental conditions and the lubricant previously used.

# 75%

*Reduced  
top-up  
quantity\**