



Art.Nr. 11610-01

B-Cool MC 610

Description

B-Cool 610 is an amine-based, water-miscible and chlorine-free metalworking fluid with a low mineral oil content. The product's distinguishing features are its universality, machine cleanliness, high cutting performance, as well as low-foaming properties in soft water.

Range of application

B-Cool MC 610 is applicable for machining of cast iron, steel, stainless steel, aluminum, pure copper and copper base alloys.

Product properties

The color of the emulsion does not change when casting and copper are being machined →

Tolerant to lead leaching →

Good material compatibility →

Very good rinsing behavior →

Benefits

Clean machines

Residue-free machining of materials containing lead

No stain formation on copper and aluminum alloys

No residue formation and low consumption

Physical-chemical data

Concentrate

Solution

| | | |
|-----------------------------|-----------------------|---------|
| Color/appearance | Light yellow, clear | Whitish |
| Mineral oil content | 15 % | |
| Density at 20°C | 1.0 g/cm ³ | |
| Viscosity at 40°C | 57 mm ² /s | |
| Flash point | >130°C | |
| pH-value (fresh emulsion) | | 9.3–9.5 |
| pH-value (after 2 – 3 days) | | 8.8–9.1 |
| Refractometer factor | | 1.4 |

Note

The product does not contain*:

chlorine**, heavy metals, boron, silicone, nitrosamines, glycol ethers.

*The substances listed here are not part of the formula, but trace amounts of these substances may be present.

**Without active use of chlorinated EP additives

Recommended antifoam: Additive A34, Art. No. 29108

Restriction: The percentage of copper alloy machining should not exceed 30% per machine, especially for leaded brass/bronze.

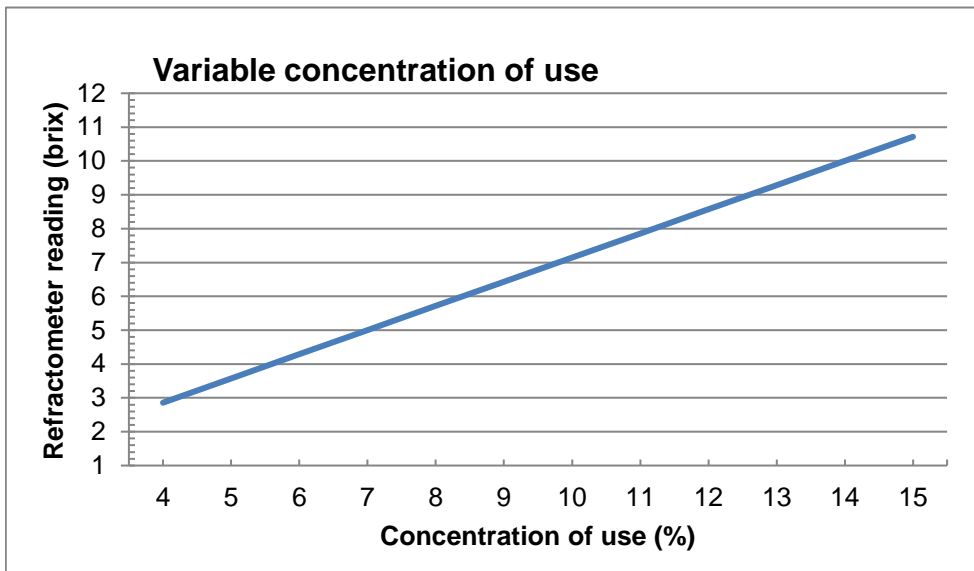
Concentration of use

Variable concentration from 4–15%
(Refractometer reading: 2.8 – 10.7)

Best results machining applications 7–15%
(Refractometer reading: 5 – 10.7)

Max. water hardness: 20°dH / 356 ppm

This product has a very low top-up rate. However, in any case, at least 0.5% of concentrate must be added.



Information contained in this data sheet is based upon the properties and applications of use as known to us. However, generally no legal liability may be deducted from such information.
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