

TECHNICAL DATA SHEET

QUAKERCOOL[®] 3540 BFF

METALWORKING WATER SOLUBLE COOLANT BORON FREE

Water dilutable semi-synthetic fluid, with a medium mineral oil content, suitable for machining and grinding operations on most engineering materials.

This technology combines the cleanliness and detergency of a synthetic product with the unique properties of oil containing emulsions.

Applications

Recommended for general machining and grinding operations on steel and cast iron.

Operations

Turning, Milling, Drilling, Tapping-Threading, Reaming, Grinding, ...

Materials

Cast-iron, Steel, High alloy steel, Stainless steel, Titanium, ...

Recommendation for use

Concentration range:

4 - 6 % depending on type of operation

Make up water hardness:

140 - 340 ppm (14 - 34 °TH, 7 - 19 °DH)

Poor or incorrect emulsion preparation may lead to instability and could considerably shorten the life of the emulsion. Prior to making any fresh fill, we highly recommend full cleaning including the use of a compatible systems cleaner of all system components which will be in contact with the emulsion. A wide range of system cleaners* and disinfecting additives* are available from Quaker Houghton.

Please consult a Quaker Houghton representative for any additional information.

Benefits

- Boron free
- Formaldehyde free
- Provides good cleanliness on tools/machines and detergency characteristics
- Good fines handling during grinding operations
- Good bio-resistance

Health, Safety and Handling

Please consult the Safety Data Sheet (SDS) for information on storage, safe handling and disposal. The conditions or methods of handling, storage, use and disposal of the product are beyond our reasonable control - we assume no liability for any ineffectiveness of the product or any injury or damage, arising out of or in connection with these conditions.

This product has a recommended shelf life of: 6 months

Properties

PROPERTY	TYPICAL VALUE	UNIT
Appearance / Colour	Clear Light Yellow	[-]
Viscosity	32	mm ² /s @ 40°C
Density	991	kg/m ³ @ 15°C
Pour point	<0	°C
Appearance diluted	Translucent	[-]
pH diluted	9,85	[-]
Corrosion threshold	2,5	% DIN 51360 T2
Alkalinity factor (pH=5)	5,15	ml 0,1N%/ 25 ml
Acid split factor	0,44	ml/%
Refractometer factor	1,43	%/° Brix

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