

# METAL REMOVAL FLUIDS

## QUAKERCOOL® 7200 HBFF METALWORKING WATER SOLUBLE COOLANT BORON FREE

### APPLICATION SHEET

#### BENEFITS

- » Formaldehyde free
- » Boron free
- » Guaranteed surface finish especially on aluminium alloys
- » Increase tool life
- » Good bio-resistance
- » Excellent wetting and onctuousity abilities giving high cutting performances

#### APPLICATIONS

High performance micro-emulsion ideally suited to all operations where high surface finish quality and high lubrication is needed. Ideal for general purpose machining of most engineering materials

Recommended for difficult metalworking operations on cast iron, steel and aluminium

Concentration range:  
6 - 12 % depending on type of operation

Make up water hardness:  
140 - 450 ppm (14 - 45 °TH, 7 - 25 °DH)

#### FLUID MAINTENANCE

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.

\*Please consult a Quaker representative for any additional information.



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#### STORAGE/PACKAGING

Quaker Chemical can supply this quality product in drums, in containers and in bulk. Other packages can be made available by Quaker Chemical or by distributors upon request.

As with all metalworking products, QUAKERCOOL® 7200 HBFF should be stored in dry conditions and protected from extreme temperatures: 4 - 35 °C is the recommended storage temperature.

QUAKERCOOL® 7200 HBFF is unlikely to present any significant health or safety hazard when used as recommended by Quaker. Good standards of personal and industrial hygiene are to be maintained by the user (see Material Safety Data Sheets).

#### OPERATIONS

Turning	●
Milling	●
Drilling	●
Deep hole drilling	●
Tapping-Threading	●
Reaming	●
Broaching	○
Sawing	●
Grinding	○
Honing-Lapping	○

#### MATERIALS

Cast-iron	○
Steel	●
High alloy steel	●
Stainless steel	●
Aluminium alloys	●
Aero Aluminium alloys	○
Copper alloys	○
Titanium	●
Carbide tool	

● Main application ○ Possible application

#### PROPERTIES

PROPERTY	TYPICAL VALUE	UNIT
Appearance / Colour	Clear Yellow	[-]
Viscosity	77	[mm <sup>2</sup> /s @ 40 °C]
Density	947	[kg/m <sup>3</sup> @ 15 °C]
Pour point	<4	[° C]
Appearance diluted	White	[-]
pH diluted	9,8	[-]
Corrosion threshold	4	[% DIN 51360 T2]
Alkalinity factor (pH=5)	2,8	[ml 0,1N/%/ 25 ml]
Acid split factor	0,88	[ml/%]
Refractometer factor	1,0	[%/° Brix]

These characteristics are typical of current production and can't be used as a specification.

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Prior to using this product, consult the Material Safety Data Sheet for instructions regarding safe handling and environmental issues.

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