

SEMI-SYNTHETIC FOR LIGHT DRAWING & HEAVY MACHINING OF FERROUS METALS & STAINLESS STEEL

<u>COMPOUND</u>	<u>% WT.</u>
100 Pale Oil	9.0
Cola [®] Lube 3413EPL	9.0
Cola [®] Lube 3420EPL	13.6
Cola [®] Lube 3404CI	1.6
Triethanolamine (99%)	3.2
Cola [®] Cor RP	5.0
Water	<u>58.6</u>
Total	100.0

PROCEDURE:

Mix first three ingredients. Add remaining ingredients in order listed making sure each is dissolved before adding next ingredient.

TYPICAL PROPERTIES:

Appearance

Clear amber liquid

PERFORMANCE (5% in water):

Appearance

Clear liquid micro-emulsion

pH

9.5

Cast Iron Block Test

Pass

Falex[®]

2500lbs / 57in-lbs

Last Modified 07/27/2006

Formula 049

WARRANTY

Colonial Chemical guarantees that its products meet published specifications. No other warranties or guarantees are expressed or implied because the use of this material is beyond the control of Colonial Chemical.