SYNTHETIC ALUMINUM MACHINING FLUID

COMPOUND	% WT.
Cola®Lube 3404CI	16.6
Triethanolamine (99%)	33.3
Water	50.0
Antifoam Additive	0.1
Total	100.0

PROCEDURE:

Mix ingredients in order listed with agitation.

TYPICAL PROPERTIES:

Appearance	Clear amber liquid

PERFORMANCE (5% in water):

Appearance	Clear liquid
pH	8.3
Cast Iron Block Test	Pass
Falex®	2500lbs / 55in-lbs
Surface Tension (dynes/cm)	24

USAGE:

Grinding	1 – 2%
Machining	5 – 8%
Heavy Machining	8 – 15%

Formula 057

Last Modified 07/27/2006

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.