

LOW SURFACE TENSION METALWORKING FLUID FOR CUTTING AND GRINDING

<u>COMPOUND</u>	<u>% WT.</u>	
	<u>Formula 1</u>	<u>Formula 2</u>
COLA™ LUBE 3404 CI		5.0
COLA™ LUBE 3406 CI	10.0	5.0
Triethanolamine (99%)	20.0	20.0
Water	70.0	70.0
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TOTAL	100.0	100.0

PERFORMANCE DATA (5% IN WATER)

	<u>Formula 1</u>	<u>Formula 2</u>
Appearance	Clear Liquid	Clear Liquid
pH	8.7	8.7
Surface Tension (dynes/cm)	42	35
Cast Iron Block Corrosion Test:	Slight Rust	Pass
Falex (Direct Scale)	2000lb/50in. lb	2500lb/55in. lb

The formulation above demonstrates the effectiveness of COLA™ LUBE 3404 CI. Like many other metalworking formulations, the addition of COLA™ LUBE 3404 CI can enhance performance by lowering the surface tension of the formulation. Rust prevention and EP properties saw a marked improvement with the addition of COLA™ LUBE 3404 CI. The improvement of EP and rust prevention properties improve cutting, grinding, and metalworking efficiency at the same time as they improve tool life.

Formula 026

Last Modified 07/9/2005

WARRANTY

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