

MACHINING FLUID

COLA™ LUBE 3410CI provides lubricity and EP properties in this machining fluid. This formulation was designed for machining carbon steel, brass, bronze, copper and stainless steel.

<u>COMPOUND</u>	<u>% WT.</u>
Naphthenic Oil (100SUS/100)	72.0
COLA™ LUBE 3410CI	5.0
COLA™ LUBE 3418EPL	20.0
Triethanolamine (99%) (TEA)	<u>3.0</u>
TOTAL	100.0

PROCEDURE:

Combine ingredients with agitation.

PERFORMANCE DATA (5% in water):

Appearance	Clear Liquid
pH	8.5
Surface Tension	42
Cast Iron Block Corrosion Test	Pass
Falex® (Direct Scale)	2750lbs / 47in-lbs

USE DILUTION:

Grinding	1 – 2% in water
Light Machining	3 – 5% in water
Moderate Machining	5 – 7% in water
Heavy Machining	8 – 10% in water

Formula 047

Last Modified 07/14/2005

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.