MODERATE/HEAVY DUTY MACHINING

This formulation provides outstanding EP and rust prevention properties and is suited for use in moderate to heavy duty machining operations.

COMPOUND	% WT.
100 Pale Oil	78.0
COLA™LUBE 3418EPL	15.0
COLA™LUBE 3407CI	5.0
Triethanolamine (99%)	2.0
TOTAL	100.0

PROCEDURE:

Mix above ingredients with agitation, warm to 120°F. If solution is slightly hazy adjust with tall oil fatty acid.

TYPICAL PROPERTIES:

Appearance	Milky Emulsion

PERFORMANCE DATA (5% in water):

Appearance	Milky Emulsion
pH	8.0
Cast Iron Block Corrosion Test	Pass
Falex® (Direct Scale)	2500lbs / 55in-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 044

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.

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