



# OEST COLOMETA BF 40 FN

## Description

Water miscible coolant for metal cutting processes on individual machine tools as well as centralized systems. Good washing action ensures safe chip removal, perfect cooling and a clean working area and machine tools.

- semi-synthetic, fine dispersed emulsion
- very stable emulsion
- high lubricity and cutting performance

## Application

Universally applicable for grinding processes and up to severe cutting operations (turning, milling, drilling...)

Universally applicable for steels, yellow and light metals, particularly for most sensitive alloys.

### Processes

turning	milling	drilling	deep drilling	Thread forming tapping	broaching	surface & cylindrical grinding	centerless grinding	profile grinding	preferred qualified

### Materials

steels	cast iron	stainless steel	aluminium	yellow metals	titanium	Inconel	polymers & composites	carbide	preferred qualified

Developed for use in most demanding industry segments with regards to material compatibility and process safety, mainly automobile & aerospace manufacturers and their subcontractors.



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# OEST COLOMETA BF 40 FN - BENEFITS

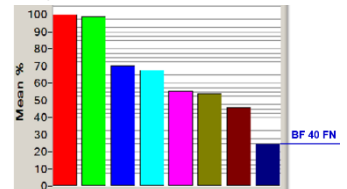
## Perfect material compatibility

approved conformities

- ☺ Aluminium
  - no intergranular attac acc. Safran PR6300, ASTM F2111: EN-AW 2618A
  - no mass loss acc. Safran PR6300 SAE ARP1755: EN-AW 2024
  - no corrosion / staining acc. AW013102: EN-AW 2007, 2024, 5083, 7082, 7075
  - no corrosion / staining acc. AW013102: EN-AC 47100, 51100
- ☺ Yellow metals
  - no corrosion / staining acc. AW013101: e-Cu, CuZn37
  - no Cu/Pb/Zn-leaching acc AW013200: CuZn39Pb3, Cu60Zn30Pb
- ☺ Titanium
  - no stress corrosion acc. Safran PR6300: Ti6242
- ☺ Steels
  - no intergranular attac acc. Safran PR6300, ASTM F2111: M 250
  - no mass loss acc. Safran PR6300: M 250
  - inhibiting power acc. PR 6300: 15CrMoV6

## High lubricity

- ☺ suitable for severe materials (titanium, stainless steel, Inconel) and operations (f.e. threading <M3 in Pb-free Aluminium)
- ☺ lowest torque and friction in Microtap-test



## Future proof formulation

- ☺ free from Boron, Formaldehyde-donors (FAD), Monoethanolamine (MEA), Methylisothiazolinone (MIT), Benzotriazole (BTA), any second. Amines (incl. DCHA)
- ☺ no critical exposure limits
- ☺ safe process, not threatend with foreseeable restrictions for use



## Suitable for demanding operating conditions

☺ for all water hardnesses

°gh	0	2-5	6-10	11-20	21-40	41-60	>60	preferred qualified
ppm	0	35-90	91-170	171-350	351-710	711-1070	>1070	

☺ for highest coolant pressure > 100 bar / 1450 psi



## OEST COLOMETA BF 40 FN - DATA

### Technical Data

Density (20°C)	0,95 g/cm <sup>3</sup>
Kinematic viscosity (20°C)	674 mm <sup>2</sup> /s
Corr. protection GG25	5% no corrosion
pH (5%)	9,2

### Mixing recommendation

Manual mixing always by pouring concentrate into water (drinking quality) while stirring.

Easy to mix by automatic mixing device COLO MIX.

#### Recommended concentration:

Minimum:	5 %
Centerless grinding:	5 - 6 %
Cutting:	5 - 15 %

#### Concentration control:

By refractometer: measurement °Brix x F<sub>refr</sub> = Vol-%  
F<sub>refr</sub> = 1, 4

### HSE

Compliant to all european regulations: REACH, CLP, TRGS 611, RoHS, etc.

NOT classified acc to EC 1272/2008

Health & Safety:

Lubricants for metalworking and -treatment may contain hazardous ingredients.  
For detailed information, see the MSDS.

Water hazard class (german regulation): 2 (hazardous)

### Transport & Storage

Storage temperature + 5 °C ... + 35°C.

Durability 12 months in closed packaging at recommended conditions.

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