

# METAL REMOVAL FLUIDS

## QUAKERCOOL® 7101 ALF METALWORKING WATER SOLUBLE COOLANT

### APPLICATION SHEET

#### BENEFITS

- » Formaldehyde free
- » Good anti-corrosion properties on all metals
- » Excellent lubrication properties
- » Maintains clean machine surfaces
- » Approved SNECMA according to the doc 455-201-0-00 Ind B.
- » Meets the AIRBUS norma ASN42302 (EADS).

#### APPLICATIONS

Water dilutable product specifically designed for machining of aeronautical materials such as aluminium. It is also suitable for machining and grinding operations on most engineering materials.

Recommended for all machining operations on steel, cast iron and aluminium alloys.

Concentration range:  
6 - 12 % depending on type of operation

Make up water hardness:  
90 - 270 ppm (9 - 27 °TH, 5 - 15 °DH)

#### FLUID MAINTENANCE

Poor or incorrect emulsion preparation may lead to instability and could considerably shorten the life of the emulsion. Prior to making any fresh fill, we highly recommend full cleaning including the use of a compatible systems cleaner of all system components which will be in contact with the emulsion. A wide range of system cleaners\* and disinfecting additives\* are available from Quaker.

\*Please consult a Quaker representative for any additional information.



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#### STORAGE/PACKAGING

Quaker Chemical can supply this quality product in drums, in containers and in bulk. Other packages can be made available by Quaker Chemical or by distributors upon request.

As with all metalworking products, QUAKERCOOL® 7101 ALF should be stored in dry conditions and protected from extreme temperatures: 4 - 35 °C is the recommended storage temperature.

QUAKERCOOL® 7101 ALF is unlikely to present any significant health or safety hazard when used as recommended by Quaker. Good standards of personal and industrial hygiene are to be maintained by the user (see Material Safety Data Sheets).

#### OPERATIONS

Turning	●
Milling	●
Drilling	●
Deep hole drilling	●
Tapping-Threading	●
Reaming	●
Broaching	●
Sawing	●
Grinding	○
Honing-Lapping	○

#### MATERIALS

Cast-iron	○
Steel	●
High alloy steel	●
Stainless steel	●
Aluminium alloys	●
Aero Aluminium alloys	●
Copper alloys	○
Titanium	●
Carbide tool	

● Main application ○ Possible application

#### PROPERTIES

PROPERTY	TYPICAL VALUE	UNIT
Appearance / Colour	Clear Amber	[-]
Viscosity	90	[mm <sup>2</sup> /s]
Density	959	[kg/m <sup>3</sup> ]
Pour point	<4	[ ° C]
Appearance diluted	White	[-]
pH diluted	9,3	[-]
Corrosion threshold	4	[% DIN 51360 T2]
Alkalinity factor (pH=5)	2,4	[ml 0,1N/%/ 25 ml]
Acid split factor	0,85	[ml/%]
Refractometer factor	1,2	[%/° Brix]

These characteristics are typical of current production and can't be used as a specification.

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Prior to using this product, consult the Material Safety Data Sheet for instructions regarding safe handling and environmental issues.

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