

TECHNICAL DATA SHEET

QUAKERCOOL[®] 3618 HBFF

METALWORKING WATER SOLUBLE COOLANT BORON FREE

High performance micro-emulsion ideally suited to all operations where high surface finish quality and high lubrication is needed. Ideal for general purpose machining of most engineering materials.

Applications

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

Operations

Turning, Milling, Drilling, Deep hole drilling, Tapping-Threading, Reaming, Sawing, Grinding, Honing-Lapping, ...

Materials

Cast-iron, Steel, High alloy steel, Stainless steel, Aluminium alloys, Aero Aluminium alloys, Copper alloys, Titanium, ...

Recommendation for use

Concentration range:

6 - 10 % depending on type of operation

Make up water hardness:

90 - 350 ppm (9 - 35 °TH, 5 - 19 °DH)

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 Houghton.

Please consult a Quaker Houghton representative for any additional information.

Benefits

- Boron free
- Formaldehyde free
- Provides good cleanliness on tools/machines and detergency characteristics
- Excellent lubrication properties
- Multi applications

Health, Safety and Handling

Please consult the Safety Data Sheet (SDS) for information on storage, safe handling and disposal. The conditions or methods of handling, storage, use and disposal of the product are beyond our reasonable control - we assume no liability for any ineffectiveness of the product or any injury or damage, arising out of or in connection with these conditions.

This product has a recommended shelf life of: 6 months

Properties

PROPERTY	TYPICAL VALUE	UNIT
Appearance / Colour	Clear Light Amber	[-]
Viscosity	43	mm ² /s @ 40°C
Density	1001	kg/m ³ @ 15°C
Pour point	<0	°C
Appearance diluted	Translucent	[-]
pH diluted	9,6	[-]
Corrosion threshold	4,5	% DIN 51360 T2
Alkalinity factor (pH=5)	2,71	ml 0,1N%/ 25 ml
Acid split factor	0,31	ml/%
Refractometer factor	1,7	%/° Brix

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