



The Orelube Corporation

Specialty Industrial Lubricants Since 1958

**Technical
Information**

BOELUBE 70105 SYNTHETIC WATER SOLUBLE MACHINING FLUID

BOELUBE® 70105 is synthetic clear microemulsion providing the superior lubricity of BOELUBE® that when diluted with water, will form a white emulsion that is effective for machining many types of materials. BOELUBE® 70105 will provide excellent lubrication properties leading to better finish and longer tool life.

BOELUBE® 70105 provides effective cooling and cleanliness enabling open, free grinding. Parts and machinery are protected from rust and corrosion, and machine tool operators will appreciate its mild alkalinity.

BOELUBE® 70105 Water Soluble Fluid has low foaming characteristics, and will not leave a tacky residue on machinery or machined parts. Parts are easily cleaned with cold water.



APPLICATION	RECOMMENDED DILUTION
Drilling	15:1 to 20:1
Reaming - Tapping	10:1 to 20:1
Milling	10:1 to 15:1
Grinding	15:1 to 25:1

BLENDING INSTRUCTIONS:

Reservoir must be free of all residues from prior coolants.

Fill tank with proper amount of BOELUBE® 70105.

Add water and mix thoroughly.

The Orelube Corporation certifies that all the ingredients in BOELUBE® are listed on TSCA, and that BOELUBE® does not contain Silicone, Petroleum, Phenols, Nitrites, Sulfur, Chlorine, Phosphorus and Heavy Metals whether added or present in any of its ingredients.

DISPOSAL OF USED MIXES:

Skim the floating tramp oil.

Neutralize to pH 7.0 by adding hydrochloric or citric acid.

Add a small amount of acid at a time, and check your progress by using pH indicator paper.

When you reach pH 7.0, check the requirements of your local sanitary district for the proper disposal of watery waste effluent.

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ENVIRONMENTAL:

- Biochemical Oxygen Demand (BOD₅) – 325,000 mg/g
- Chemical Oxygen Demand (COD) – 796,000 mg/Kg

TYPICAL PROPERTIES	
pH (Neat)	9.4
pH (5%)	8.4
Copper Corrosion, 3 hrs. @ 100 C	1a
Cast Iron Chip Test, @ 1 hr. @ 3 hrs. @ 6 hrs. @ 24 hrs.	No rust No rust No rust No rust
Corrosion Test (5%), 48 hrs. Al Cu Fe	No color change No color change No color change
Foam Test (10%)	10-0-0

Concentration %	REFRACTOMETER Reading
5.0	2.3
8.0	3.9
10.0	4.9
12.0	5.9
15.0	7.2

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