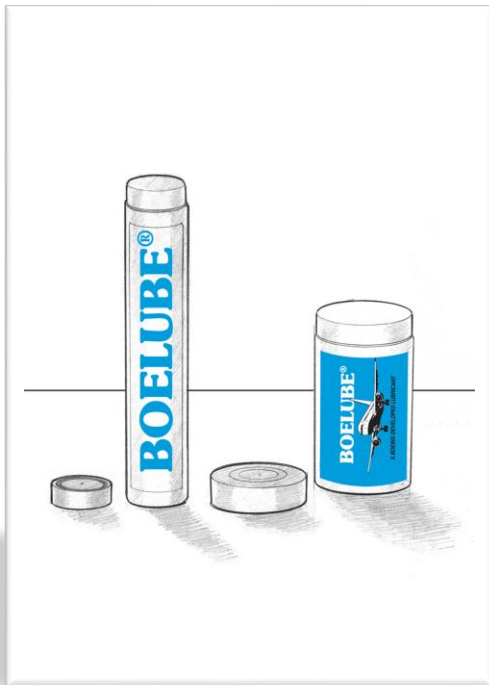


# BOELUBE®



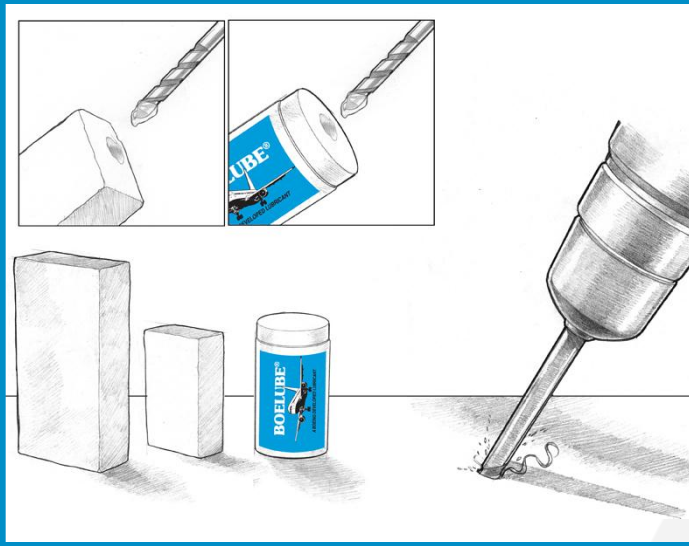
***A BOEING DEVELOPED LUBRICANT***



## **BOELUBE SOLID**

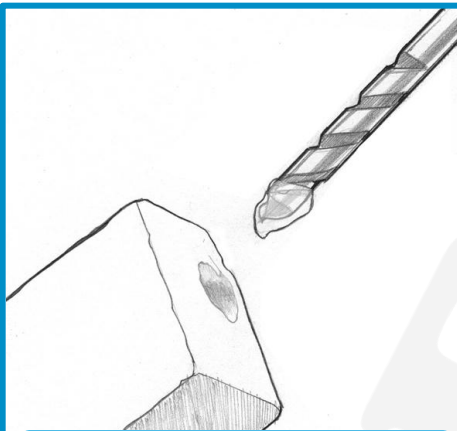
Produced under license from Boeing Management Company. **BOELUBE®** is among the trademarks owned by Boeing. These products represent a family of proprietary lubricants developed through Boeing manufacturing operations and lubricant experience.

The Orelube Corporation holds an exclusive worldwide license from Boeing Management Company to manufacture and market the **BOELUBE®** series of lubricants.



Historically, the metalworking industry has used metalworking fluids by flood application in machining operations. But because the costs associated with use, management, and disposal of flood coolants has risen over the years, in part due to increasing federal, state, and local regulations aimed at worker safety and fluid disposal, there has been a growing trend to utilize methods requiring less metalworking fluid to reduce cost, protect the environment, and improve and protect worker health, without sacrificing productivity and quality.

A metalworking lubricant should impart sufficient lubricity between the tool and the workpiece to cause a significant reduction in friction to occur. **BOELUBE®** is a technologically advanced lubricant that significantly reduces friction (one of the major elements in generating heat during the material removal process).



**BOELUBE® Solids** are extremely cost effective in single point work such as drilling and reaming.

In near dry machining the goal is high efficiency, which is achieved as a result of using a minimal quantity of lubricant. Because minimal quantities are used and consumed for the most part in the machining process, **BOELUBE® Solids** produce near dry workpieces and chips with little or no clean-up or related costs and no disposal costs.

**BOELUBE® Solids** come in a variety of shapes and sizes to accommodate ease of application in drilling, tapping, reaming, abrasive belts, deburring, grinding wheels, band, circular and hand saw blades.

Typically the **BOELUBE** solid is applied to the tool before start-up. In a block or tube form, it can hand held and a drill bit can be touched to the solid before drilling or the solid may be swiped across the surface to be drilled. Only a minimal amount is required when drilling through thin material.

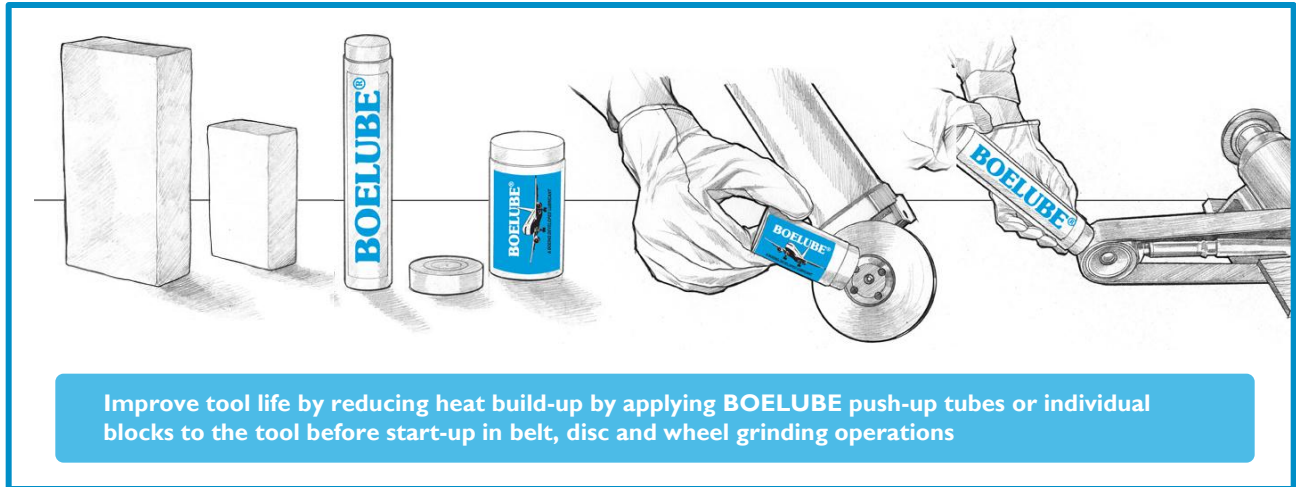
**BOELUBE® Solids** are extremely cost effective in single point work such as drilling and reaming.

Drilling is one of the most widely used machining processes to produce circular holes in metallic and nonmetallic materials. A drill is a rotary end-cutting tool, with the most common type being the twist drill. The drill, attached to either a stationary machine or hand held, is used to originate or enlarge a hole in a solid material.



A drill will have cutting edges and straight or helical grooves or flutes, which allow for movement of chips and cutting fluids/coolants. Drill wear is not proportional to the number of holes drilled, but occurs at an accelerated rate.

A reamer is a rotary cutting tool (similar to a drill) with one or more cutting elements, used to enlarge to an exact size and impart a smooth finish to, a previously drilled hole. Reaming is essentially a finishing operation; Drilling can be characterized as in a rough form, whereas reaming is the exact form.



### MAJOR BENEFITS

- **BOELUBE®** is non-corrosive, non-flammable, chemically stable and free of halogens, heavy metals, sulfur, phosphorus, silicone, petroleum or paraffin wax.
- **BOELUBE®** does not contain any ingredients considered a hazardous substance by OSHA, WHMIS, IARC, NTP and State Regulatory Lists. Refer to Material Safety Data Sheets for additional information.
- **BOELUBE®** will not promote dermatitis, provides a high degree of worker safety, and presents a safe effective method to machine various types of materials without special handling, fluid recycling or typical disposal issues.
- **BOELUBE®** can be removed from surfaces using isopropyl alcohol, denatured alcohol, MEK, or aqueous cleaner.
- **BOELUBE®** has indefinite shelf life.
- **BOELUBE®** does not need to be removed prior to heat treat.
- **BOELUBE®** is in most cases compatible with paints and sealants (though it is highly recommended that compatibility be determined before use).
- **BOELUBE®** provides superior lubrication when machining or forming the increasingly complex range of materials now being used in Aerospace, and a wide range of other manufacturing industries.

### COST SAVINGS

- Are derived through longer tool life, better surface finish, increased productivity, reduction in lubricant usage and subsequent cleaning and disposal costs, reduced environmental impact, and improved housekeeping

### ENVIRONMENTALLY NON-HAZARDOUS / WORKER FRIENDLY

- Manufactured from personal care ingredients, **BOELUBE®** is non-irritating and biodegradable

**BOELUBE® PRODUCT LIST**

Order items by Product Code numbers

<b>BOELUBE Solids</b>		<b>Quantity</b>
<b>70200 White</b>		
70200-00	14.5 oz. Cartridge	12 per Box / 24 per Case
70200-13	1.6 oz. Push Tube	50 per Box / 300 per Case
70200-14	4 oz. Block	30 per Box / 180 per Case
70200-18	2 oz. Stick	64 per Box / 192 or 384 per Case
70200-40	3.5 oz. Push Tube	32 per Box / 192 or 384 per Case
<b>BOELUBE Pastes</b>		<b>Quantity</b>
<b>70302 Blue (Soft) / 70305 Pink (Hard) / 70307 Blue (Medium)</b>		
70307-02	2 oz. Jar	150 per Box
70307-L	4 oz. Jar	30 per Box / 150 per Case
70307-05	35 lb. Pail	1 each
70307-11	5 lb. Tub	1 each / 8 per Case
70307-12	12 oz. Jar	12 per Box / 36 per Case
70307-07	120 lb. Drum	1 each
70307-09	400 lb. Drum	1 each
<b>BOELUBE Liquids</b>		<b>Quantity</b>
<b>70104 Red (100A) / 70106 Clear (100F) / 70090 Clear</b>		
70104-04	1 gal. Container	1 each / 6 per Case
70104-05	5 gal. Pail	1 each
70104-07	15 gal. Drum	1 each
70104-09	55 gal. Drum	1 each
70104-HHL	Hand Held	70 per Box / 140 per Case
70104-L	4 oz. Bottle	36 or 72 per Box / 150 per Case
70106-L	4 oz. Bottle	36 or 72 per Box / 150 per Case
70090-L	4 oz. Bottle	36 or 72 per Box / 150 per Case
<b>BOELUBE Water-Soluble Fluid</b>		<b>Quantity</b>
<b>70105</b>		
70105-04	1 gal. Container	6 per Case
70105-05	5 gal. Pail	1 each
70105-07	15 gal. Drum	1 each
70105-09	55 gal. Drum	1 each

