



## **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 70105 are listed on TSCA.
- ✓ BOELUBE 70105 does not contain Silicone, Petroleum, Phenols, Nitrites, Sulfur, Chlorine, Phosphorus and Heavy Metals whether added or present in any of its ingredients.
- ✓ BOELUBE 70105 does not contain Biocide or Fungicide.

#### **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.



**ENVIRONMENTAL:**

- Biochemical Oxygen Demand (BOD<sub>5</sub>) – 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