

BORTEX ALM-730 BFF

ALUMINUM MACHINING FLUID

PRODUCT DESCRIPTION

BORTEX ALM-730 BFF is a versatile mineral oil-based metalworking fluid that forms a stable and milky emulsion with water.

BORTEX ALM-730 BFF is formulated with a balanced additive content consisting of high-quality mineral base oils, strong emulsifiers and chemicals to protect against corrosion, foam and microorganisms.

BORTEX ALM-730 BFF does not contain any nitrite or phenolic compounds and is free of chlorine, boron and formaldehyde.

BORTEX ALM-730 BFF does not contain any easily nitrosable amines according to TRGS 611.

APPLICATION / USAGE

BORTEX ALM-730 BFF was specifically developed for use in machining aluminum alloys. It provides high performance and excellent surface quality for machining special Al alloys (2000 and 7000 series Al alloys) used in the aerospace and defense industries. It can also be used for processing steel and iron.

Recommended concentration:

Machining of ALU 6 - 7%

Machining of steel 5 - 10%

The concentration ranges mentioned above apply if water with a total hardness of 90 – 356 ppm is used in the emulsion.

ADVANTAGES / BENEFITS

- High emulsion stability
- Thanks to its special additives, it offers a effective corrosion protection during operation and short-term storage
- Low tendency to foam even in high pressure systems
- No discoloration
- Excellent lubricating properties
- Leaves no residue and therefore holds tools and machine clean
- No skin irritation due to adjusted pH value
- Does not contain nitrite, phenol, chlorine, boron and/or Formaldehyde-releasing compounds

STORAGE

Protect from direct sunlight and rain. Store in the original closed drums and in covered areas. Storage temperature must be between +5 and +40°C.

"The above information is derived from our quality checks. Given values are typical of current production. While future production will conform to our specification, variations in these characteristics may occur. Quality Control Analysis Report for to learn properties of the product that is supplied can give. It does not relieve the purchaser from examining product upon delivery and gives no assurance of the product for any particular purpose. Due to continual product research and development, the information contained herein is subject to change without notification."

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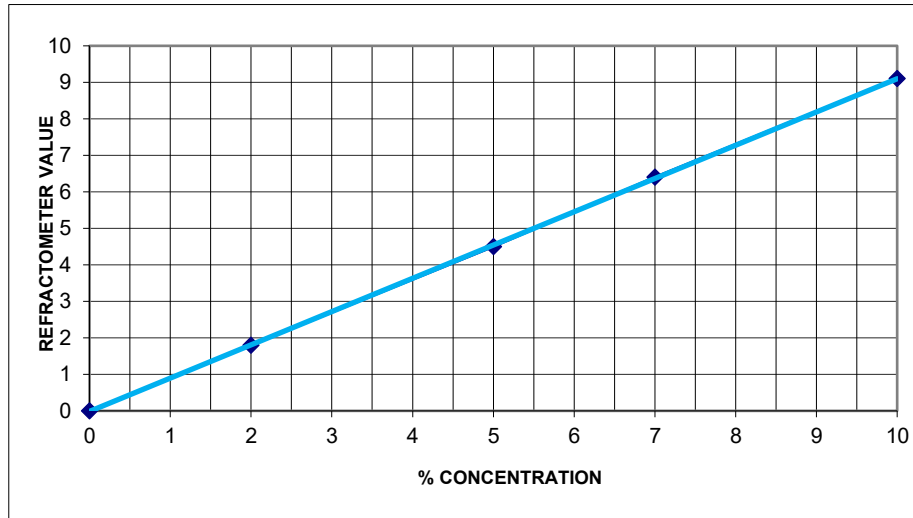
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TECHNICAL PROPERTIES	TEST VALUES	TEST METHOD
Appearance	Yellow, Clear	-
Emulsion Appearance (%5)	Translucent	-
Density (20°C, g/mL)	0,960	ASTM D 1298
pH (%5)	9,00	ASTM D 1287
Corrosion Test (10 °dH , %5, 2h)	0-0	DIN 51360/2
Refractometer Factor	1,1	Hand Refractometer

Concentration Control:

% Concentration	Refractometer Value
2	1,8
5	4,5
7	6,4
10	9,1



The data provided for the % concentration control is prepared according to the data obtained for the freshly prepared emulsion. As the utilization time of the emulsion and the undesired oil/contamination amount in the system increases, deviations from the data stated above should be taken into account.

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