BONDERITE®

Technical Product Bulletin

BONDERITE L-MR B-236
MACHINING LUBRICANT
(KNOWN AS MULTAN B-236)

Issued 1/15/2016

Product Description
BONDERITE L-MR B-236 is a bio-resistant, medium oil content, semi-synthetic fluid designed for machining and grinding of ferrous and most aluminum alloys. Its combination of lubricity additives and cooling ability allow it to work in light to moderate machining and grinding applications. This product has been designed where lubricity, bio-resistance, cleanliness and cooling are critical in cast iron or steel applications.

Benefits
- High lubricity making this product versatile in most machining and grinding applications.
- Bio-resistant technology which eliminates the need for tank-side additives and Monday morning odors.
- Excellent tramp oil rejection for easy removal and increased solution longevity.
- Less product consumption due to the superb wetting and emulsion properties.

Applications
Designed for use in areas where soft to moderate water quality (10 - 300 ppm hardness) or process requirements make foam difficult to control. Excellent for medium duty ferrous or light duty nonferrous machining.

Characteristics

Property	Typical Value
Appearance of Concentrate	Hazy, amber fluid
Appearance @ 5%	Translucent white fluid
Recommended Conc.	5 – 10%
pH of Emulsion (typical)	9.2 – 9.4
Density	8.3 lbs / gallon
Chlorine	None
Boron	Yes
Refractometer Factor	1.56
Biosan Bacteria Challenge (Biosan SOP# 14-1)	Pass

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Operating and Control Procedures

Recommended Use Concentrations

Operation	Concentration
Grinding	6% to 7%
General Machining	6% to 8%
Heavy Machining	8% to 10%

Refractometer Procedure

Bonderite L-MR B-236 solutions are easily checked using a standardized refractometer (see manufacturers operating instructions). Multiply the refractometer reading by 1.56 to obtain product concentration.

Titration Procedure (pH method)

Place 15 ml sample of Bonderite L-MR B-236 into a 200 ml beaker flask. Add deionized water to the 100 ml mark. Titrate with 0.1N Hydrochloric Acid (Titrating Solution 61) until a pH of 3.6 is achieved. To determine the concentration, multiply the milliliters of HCL consumed, by 0.515.

Other Information

Protect from freezing during transit and storage.

Please refer to Safety Data Sheet for detailed health and safety information.

For more detail on this product or Henkel's capabilities contact your local account representative or Customer Service via the phone number below.

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