

# 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.

## 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.

## 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.

## 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



# 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.



Henkel Corporation | 32100 Stephenson Highway | Madison Heights, MI 48071  
PHONE: (248) 583-9300 | FAX: (248) 583-2976 | [www.henkelna.com/](http://www.henkelna.com/)

**Trademark usage:** Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

