

BONDERITE L-MR B 637 MACHINING LUBRICANT



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Product Description

BONDERITE L-MR B 637 is a bio-resistant, semi-synthetic fluid designed for machining and grinding of ferrous and aluminum alloys. Its combination of lubricity additives and cooling ability allow it to work in all machining and grinding applications. This product has been designed where lubricity, bio-resistance, cleanliness and cooling are critical in aluminum, cast iron or steel applications.

Applications

Designed for use in with all varying water qualities (DI to 1200ppm calcium) or process requirements that make foam difficult to control. An excellent semi-synthetic lubricant designed for low-foam and increased lubricity. Excellent for heavy duty ferrous or 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	Clear to hazy, amber fluid
Appearance @ 5%	Clear to Hazy,
Recommended Conc.	5 – 10%
pH of Emulsion (typical)	9.2-9.6
Density	7.9 lbs / gallon
Refractometer Factor	1.59
GM Approved	GM LS2 Pass
GROB Mach Approved	Slideway Oil Pass
Biosan Bact Challenge	Bio/Myco Pass
Chlorine	None
Boron	None



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 637 solutions are easily checked using a standardized refractometer (see manufacturers operating instructions). Multiply the refractometer reading by 1.59 to obtain product concentration.

Titration Procedure (pH method)

Place 15 ml sample of Bonderite L-MR B 637 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 0.506.

Other Information

Shipping conditions should be between 40 - 100°F (5 - 40°C), frost free, and should be stored in a location where it can be protected from freezing.

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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