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SAP-No.: 540151000

02/13

Technical Information

hebrochemie



Impulse für Mensch und Umwelt

■ hebro[®]lub 665 BF

Product

hebro[®]lub 665 BF is a modern, universal, mineral oil containing high performance cooling lubricant with a good corrosion protection, free of boron.

Characteristics

hebro[®]lub 665 BF is a free of boron cooling lubricant based on high-quality raw materials and combines therefore a high long term stability with a good corrosion protection and at the same time a very good kind of flow as well as wetting and flushing power.

The special formulation ensures a foam-inhibited operation at low water hardness and very well emulsion stability at high water hardness and provides high process safety.

hebro[®]lub 665 BF is all-purpose and can also be used for different treatments like turning, milling, drilling, sawing and polishing.

A semitransparent, fine-particle cooling lubricant with high long term stability, good corrosion protection, outstanding kind of flow as well as wetting and flushing power.

hebro[®]lub 665 BF is especially suitable for the treatment of steel and aluminium alloys, is also used for the treatment of stainless steel, cast iron and especially non-ferrous metal.

hebro[®]lub 665 BF in its composition corresponds to the state-of-the-art and therefore also to TRGS 611 as well as latest requirements to the labour protection.

Application area

hebro[®]lub 665 BF is used all over there, where a high long term stability, a very good corrosion protection and an excellent kind of flow as well as wetting and flushing power is necessary.

hebro[®]lub 665 BF is used in all machine tools, which are suitable for mineral oil containing cooling lubricants.

hebro[®]lub 665 BF is all-purpose and used in a multitude of materials and machining methods.



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DIN EN ISO 9001, DIN EN ISO 14001
and OHSAS 18001
Certificate No. DE 12/81839325



NLF/ ILO-OSH 2001
Reg. Nr. RCI / 07-009-16-07

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Dosage

For application a ready for use emulsion is prepared from the **hebro**[®]lub 665 BF concentrate. Depending on material and treatment a application concentration of 4 % is chosen.

We recommend the mixing via modern cooling mixers (e. g. Dosatron), alternatively the emulsion can be occurred conventional through slow sealing in provided drinking water stirring thoroughly.

The received emulsion should be added directly into the machine to avoid long intermediate storage times.



Note: The Dosatron-pump produces no constant emulsion concentration due to construction. The mean value over a certain running period of the pump is equal.

A check-up of concentration should be carried out in regular intervals. A few drops of the emulsion are applied on the hand refractometer and the value (%Brix) is read. This value is multiplied with the product specific factor (Rf). For **hebro**[®]lub 665 BF the refractometer value is $Rf = 1.0$



hebro[®]lub 665 BF (weight %) = measurand (%Brix) x 1.0

Technical data

Density at 20°C (DIN51757): 0.91 g/cm³
 pH-value: 5% in water: 9.3
 Application concentration: ex 4%

Determination of concentration via refractometer: factor 1.0



Note

Care measures match with the process increase considerable the durability of the emulsion. For this we will happily advise you.

