

Technical Information

■ hebro[®]lub 605 BF

Product

hebro[®]lub 605 BF is a modern, universal, mineral oil containing high performance cooling lubricant with outstanding lubricating performance, free of boron.

Characteristics

hebro[®]lub 605 BF is a free of boron cooling lubricant based on high-quality raw materials and combines therefore a high long term stability and a good corrosion protection with an excellent kind of flow as well as excellent lubricating performance.

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 605 BF is due to special lubricating additives particularly suitable for heavy chipping operations like deep-hole drilling and thread cutting, can also be used for different treatments like turning, milling, drilling and sawing.

A semitransparent, fine-particle cooling lubricant with high long term stability, good corrosion protection and outstanding lubricating performance!

hebro[®]lub 605 BF is especially suitable for the treatment of steel, stainless steel and aluminium, is also used for the treatment of cast iron metal in mixed operation.

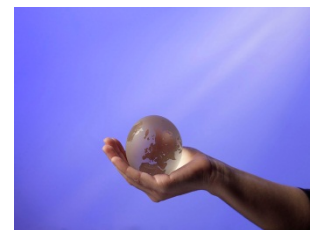
hebro[®]lub 605 BF in its composition corresponds to the state-of-the-art and therefore also to TRGS 611 as well as latest requirements to the labour protection.

Application area

hebro[®]lub 605 BF is used all over there, where a high long term stability, a good corrosion protection and an excellent kind of flow as well as an outstanding lubrication performance is necessary.

hebro[®]lub 605 BF is used in all machine tools, which are suitable for mineral oil containing cooling lubricants.

hebro[®]lub 605 BF is all-purpose and used in a multitude of materials and machining methods.



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Dosage

For application a ready for use emulsion is prepared from the **hebro**[®]lub 605 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 605 BF the refractometer value is $Rf = 0.9$



hebro[®]lub 605 BF (weight %) = measurand (%Brix) x 0.9

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Density at 20°C (DIN51757):	0.93 g/cm ³
pH-value: 5% in water:	9.3
Application concentration:	ex 4%

Determination of concentration via refractometer: factor 0.9



Note

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

