



BIOCOOL - 80 is an economical high performance, environment - friendly and long life semi-synthetic metal working fluid, suitable for all moderate machining and grinding operations on all ferrous and its alloy metals. Formulated with high performance extreme pressure additives, corrosion inhibitor package and biocides, **BIO COOL - 80** is designed to give better tool life.



Features and benefits

- Exhibits excellent hard water stability.
- Specially formulated to protect metals from corrosion.
- Free from hazardous chemistries.
- Reduces wheel loading and dressing frequency.
- Reduces machine down time.

Directions for use

BIO COOL - 80 should be diluted with water in the range of 10:1 to 60:1 depending upon the severity of the operation, work piece material and water hardness. The following practices help in achieving the full benefits of the product.

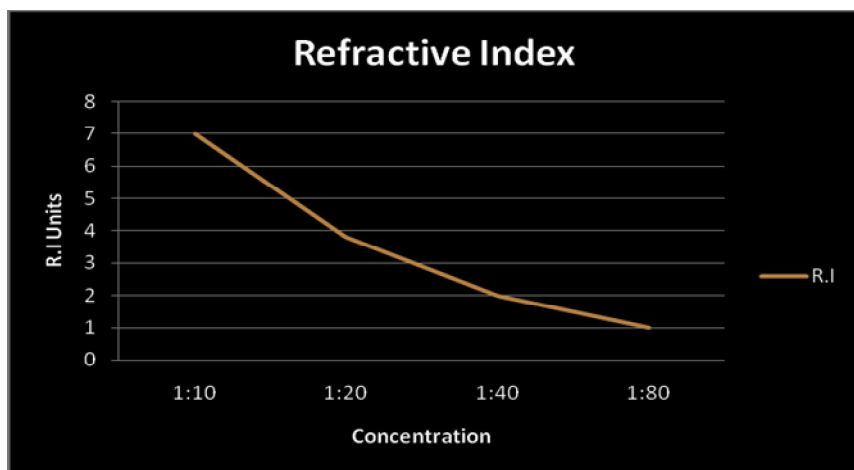
- Always add oil to water and never the other way.
- Usage of low hardness (< 100 PPM), Low chlorides (< 30 PPM) water.
- Never add product directly to the sump. Add in the emulsion form.
- Always clean the sump thoroughly before a fresh charge.

Typical properties

Attributes	Ref. Method	Specifications
Appearance	Visual	Pale yellow viscous liquid
Odor	Internal	Mild odor
Specific gravity @ 27 Deg C	ASTM D 1298	0.980 +/- 0.02
Emulsion type	Visual	Translucent
Emulsion stability test 5% in 400 ppm hard water	Internal	To pass
PH of 5% solution	Internal	9.5 – 10.5
Foam depression in secs 5% in D.M Water	IP 312/74	20 Secs
Cast iron corrosion test 3% in 200 ppm	IP 287	Less than 1%
Hand Refractometer reading (1: 20)	Internal	3.6 +/- 0.2
Oil content		35 % Maximum
HMIS Rating		
Health: 1	Reactivity: 1	Flammability: 0

Metal	Compatibility	Operation	Concentration
Ferrous	Yes	Drilling	1: 15
Aluminum	Yes	Broaching	1: 10
Brass/Copper	Yes	Grinding	1: 25
Titanium	No	Tapping	1: 10
Magnesium	No	Milling	1: 25
		Boring	1: 15

Concentration	R.I (%)
1:10	7
1:20	3.6
1:40	2
1:80	1



Pack size: Available in 20 & 205 liter drums

Note: For more details on storage and disposal please refer to material safety data sheet

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