

Lubysil BCS 48 CF
Technical Data Sheet

Metal Working Soluble Cutting Oil
For Machining Operations and Grinding

- . Chlorine free
- . DEA free
- . Hexahydrotriazine free

APPLICATIONS

High quality, emulsifiable coolant for machining operations of ferrous metals and aluminium alloys. The formulation contains lubricity additives, which makes the product suitable for severe cutting operations. BCS 48 CF shows good anti-foam properties in soft water, and it is developed for high pressure cooling and lubricating systems (deep drilling, multi-cutting tools, boring and Mapal etc). The product also has the following features:

- . Good anti-corrosion control
- . Extremely high resistance to bacterial degradation
- . Cleanliness of machines and tools
- . Extremely low COD value

Recommended Concentration

- . General turning and machining 4 – 5%
- . Grinding 3 – 5%
- . Severe cutting operations 5 – 8%
- . Heavy duty machining operations with difficult materials/severity or where exceptional surface finish is required. 6 – 12%

Typical Physical Characteristics of BCS 48 CF

	Unit	Method	BCS 48 CF
Mineral Oil Content	%		30
Density 20°C	Kg/dm ³	ASTM D 1298	0.98
pH of the emulsion at 3%		DIN 51369	9.1
Min. Anti-Cor. Protection Limit (0-0)	%	DIN 51360/2	5
Refractometer			1.48
Acid Split Factor			1.53

