PRODUCT INFORMATION

ISOCOOL 1020 BF

WATER SOLUBLE METALWORKING FLUID

DESCRIPTION

ISOCOOL 1020 BF is a latest technology, water soluble metalworking fluid.

The product can be used on steel, grey cast iron and stainless steel. It is suitable for the following machining operations: grinding, turning, drilling, milling and sawing.

ISOCOOL 1020 BF is free of mineral oil and ester. Due to highly effective anti-corrosion additives ISOCOOL 1020 BF emulsions provide long term pH stability and a long service life combined with low technical maintenance.
We recommend testing sensitive materials for compatibility (e.g. discolouring) before using ISOCOOL 1020 BF.

BENEFITS

- boron and formaldehyde free
- excellent lubrication performance
- optimized pH stability due to modern amine composition
- very good tramp oil separation capacity

TECHNICAL DATA

Oil acceptance characteristic	demulsifying
Oil droplet dispersion	solution
Boron/FAD free	✓
TRGS-611-compliant	✓
Corrosion prevention, 4 % in DI water (DIN 51360/2)	Note 0
Preparation water quality	3 - 20 °dH [54 – 370 ppm $CaCO_3$]
Foam behaviour, 5 % in DI water, 20 °C (PLM 045)	low
Storage temperature	5 - 40 °C avoiding frost
Shelf life	observe the use by date on the container

PHYSICAL DATA

Appearance/20 °C (visual)	clear yellowish to slightly red liquid*)
Density/20 °C (ASTM D 7042)	approx. 1.086 g/cm³
Viscosity/20 °C (ASTM D 7042)	approx. 162 mm²/s
pH value, 5 % in DI water, 20 °C (DIN 51369)	approx. 9.4

*) Deviating colour shades due to different storage conditions have no influence on the product quality.

FACTORS FOR CONCENTRATION DETERMINATION

Acidimetric titration up to pH 4: 0.40
Acidimetric titration up to pH 7: 0.61
Refractometer factor: 1.6

CONCENTRATIONS RECOMMENDED FOR USE

Turning, drilling, milling and sawing: 5 - 10 %
Grinding: approx. 4 %

Only valid in combination with EC Safety Data Sheet
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