

COOLCUT™ 500 BF

Heavy-duty, boron-free
water miscible cutting lubricant

FOR ALL CUTTING,
MACHINING AND
GRINDING APPLICATIONS

WATER MISCIBLE



WALTER
Surface Technologies

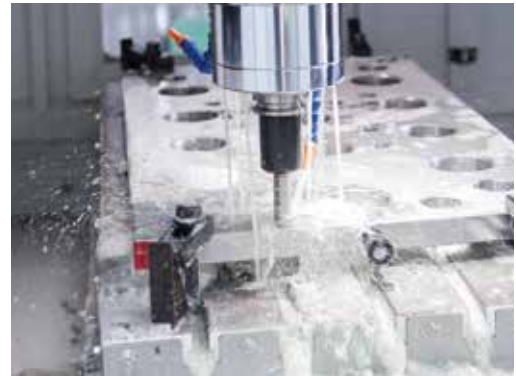
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COOLCUT™ 500 BF



Heavy-Duty, boron-free water miscible cutting lubricant

COOLCUT™ 500 BF is a water miscible coolant for metal cutting processes on individual machine tools as well as on centralized systems. Its special formulation results in high coolant stability and long coolant life. Active extreme pressure (EP) additives ensure high lubricity for severe applications while special inhibitors avoid staining even on sensitive aluminum and copper alloys. This coolant is universally applicable for severe machining processes. It is particularly suited for processes on high tensile materials like stainless steels and titanium grades.



Features

- ▷ Contains mineral oil, esters, and EP additives
- ▷ Boron and bactericides-free

Benefits

- ▷ Very stable emulsion with no boron or bactericides
- ▷ Extraordinary cutting performance for optimal tool life and surfaces
- ▷ Compatible with a variety of materials, particularly sensitive aluminum alloys
- ▷ Low foaming

Processes									
Name	Turning	Milling	Drilling	Deep drilling	Threading tapping	Broaching	Surface and cylindrical grinding	Centerless grinding	Profile grinding
COOLCUT™ 500 BF	●	●	●	●	●	●	●	●	

● Preferred ● Qualified

Materials								
Name	Steels	Cast iron	Stainless steel	Aluminum	Yellow metals	Titanium	Carbide	Glass ceramics
COOLCUT™ 500 BF	●	●	●	●	●			

Technical Data

Density (15°C) = 0,93 g/cm³
 Kinematic viscosity = 160 mm²/s (20°C)
 Corr. protection GG25 = 4% no corrosion
 pH (5%) = 9,8

Recommended concentration

Minimum: 5%
 Centerless grinding: 5 - 7%
 Cutting: 5 - 12%

Mixing recommendation

When mixing manually, always pour the concentrate into drinking quality water while stirring.

Concentration control

By refractometer: measurement °Brix x F_{refr} = Vol-%
 F_{refr} = 1,1

Tech Tip:

Use the COOLCUT™ cutting fluids proportioning system (53-L 165) for easy mixing.

Suitable for water hardness [PPM]:

0-30	40-100	110-180	190-360	370-720	730-1080
		●	●	●	●

● Preferred ● Qualified

ORDERING INFORMATION

Name	Product Number	Size
COOLCUT™ 500 BF	58-A 597	20 L
COOLCUT™ 500 BF	58-A 598	200 L
COOLCUT™ 500 BF	58-A 599	1000 L



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