

WATER MISCIBLE

# COOLCUT™ SYN 400 BF

BEST PERFORMANCE  
ON ALUMINIUM, SENSITIVE  
ALLOYS, AND YELLOW  
METALS

Boron-free fully synthetic  
water miscible coolant for  
sensitive metals



**WALTER**  
Surface Technologies

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# COOLCUT™ SYN 400 BF



**Boron-free fully synthetic water miscible coolant for sensitive metals**  
 COOLCUT™ SYN 400 BF is a water miscible coolant used in grinding and cutting operations on individual machine tools as well as on centralized systems. This coolant is designed for severe grinding and cutting operations with high lubricity demand. It is most suitable for aluminum alloys of all kinds including sensitive aerospace alloys. It is also suitable for steels, stainless steels, titanium, yellow metals and other materials.

## Features

- ▷ Mineral oil-free, fully synthetic
- ▷ Free of formaldehyde, boron and secondary amines

## Benefits

- ▷ Slightly hazy, colorless solution
- ▷ Very low foaming
- ▷ High lubricity for medium-severe and severe operations
- ▷ Extended coolant life
- ▷ Universally applicable for various materials and operations

## Processes

● Preferred ● Qualified

Name	Turning	Milling	Drilling	Deep drilling	Threading tapping	Broaching	Surface and cylindrical grinding	Centerless grinding	Profile grinding
COOLCUT™ SYN 400 BF	●	●	●	●	●	●	●	●	●

## Materials

Name	Steels	Cast iron	Stainless steel	Aluminum	Yellow metals	Titanium	Carbide	Glass ceramics
COOLCUT™ SYN 400 BF	●		●	●	●	●		●

## Technical Data

Density (15°C) = 1,07 g/cm<sup>3</sup>  
 Kinematic viscosity = 53 mm<sup>2</sup>/s (20°C)  
 Corr. protection = 5% no corrosion  
 pH (5%) = 7,9

## Mixing recommendation

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

## Recommended concentration

Minimum: 5%  
 Surface grinding: 5%  
 Profile grinding: 7 - 8%  
 Medium severe cutting: 7 - 8%  
 Severe cutting: 8-12%

## Concentration control

By refractometer: measurement °Brix x F<sub>refr</sub> = Vol-%  
 F<sub>refr</sub> = 1,6

## 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™ SYN 400 BF	58-A 407	20 L
COOLCUT™ SYN 400 BF	58-A 408	200 L



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