

TECHNICAL DATA SHEET

QUAKERCOOL[®] 3560 HBFF

METALWORKING WATER SOLUBLE COOLANT SEMI-SYNTHETIC TYPE

Mineral oil free machining and grinding fluid suitable for machining operations on most engineering materials.

This technology combines the cleanliness and detergency of a synthetic product with the unique properties of semi synthetics.

Applications

Recommended for general machining and grinding operations on steel and cast iron.

Operations

Turning, Milling, Drilling, Tapping-Threading, Reaming, Grinding, ...

Materials

Cast-iron, Steel, High alloy steel, Stainless steel, Titanium, ...

Recommendation for use

Concentration range:

4 - 6 % depending on type of operation

Make up water hardness:

0 - 340 ppm (0 - 34 °TH, 0 - 19 °DH)

Poor or incorrect emulsion preparation may lead to instability and could considerably shorten the life of the emulsion. Prior to making any fresh fill, we highly recommend full cleaning including the use of a compatible systems cleaner of all system components which will be in contact with the emulsion. A wide range of system cleaners* and disinfecting additives* are available from Quaker Houghton.

Please consult a Quaker Houghton representative for any additional information.

Benefits

- Boron free
- Formaldehyde free
- Provides good cleanliness on tools/machines and detergency characteristics
- Mineral oil free
- Good fines handling during grinding operations

Health, Safety and Handling

Please consult the Safety Data Sheet (SDS) for information on storage, safe handling and disposal. The conditions or methods of handling, storage, use and disposal of the product are beyond our reasonable control - we assume no liability for any ineffectiveness of the product or any injury or damage, arising out of or in connection with these conditions.

This product has a recommended shelf life of: 6 months

Properties

PROPERTY	TYPICAL VALUE	UNIT
Appearance / Colour	Clear Light Yellow	[-]
Viscosity	24	mm ² /s @ 40°C
Density	1010	kg/m ³ @ 15°C
Pour point	<0	°C
Appearance diluted	Transparent	[-]
pH diluted	9,85	[-]
Corrosion threshold	2,5	% DIN 51360 T2
Alkalinity factor (pH=5)	5,47	ml 0,1N/%/ 25 ml
Acid split factor	0,26	ml/%
Refractometer factor	1,8	%/° Brix

All reasonable care has been taken to ensure this publication is accurate upon issue. Such information may be affected by changes subsequent to issue. This Technical Data Sheet is to be used solely for this product. Prior to any use, consult the Safety Data Sheet (SDS) for information on hazard risks and product use parameters. All liability and all warranties express or implied are hereby excluded as to product performance results, the accuracy of these data including any warranty of merchantability or fitness for any purpose. [043298]

