

# MET-L-COOL

Cut Machining Costs. Power Profits.

## BIOCOOL AS2

### Technical Data Sheet

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**Biocool AS2** is economical and environment- friendly, long life water-soluble oil, suitable for all moderate machining and grinding operations on all ferrous and non-ferrous metals except titanium and magnesium. Formulated with refined naphthenic base oil, natural emulsifiers, corrosion inhibitor package and biocides.



### Features and benefits:

- Good aroma and user friendly.
- Reduces wheel loading and dressing frequency
- Reduces machine down time.
- Reduces disposal and labour costs
- Good sump life

### Directions for use:

**Biocool AS-2** should be diluted with water in the range of 10:1 to 60:1 depending upon the severity of the operation, work piece material and water hardness. The following practices helps in achieving the full benefits of the product.

- Always add oil to water and never the other way.
- Usage of low hardness (< 100 PPM), Low chlorides (< 30 PPM) water.
- Never add product directly to the sump. Add in the emulsion Form.
- Always clean the sump thoroughly before a fresh charge.

### Material Compatibility:

- Recommended for ferrous alloys, Aluminum alloys and copper alloys.

## Typical properties:

Attributes	Ref. Method	Specifications
Appearance*	Visual	Yellow to slight amber liquid
Odor	Olfactory	Mild odor
Specific gravity @ 27 °C	ASTM D 1298	0.98±0.02
Emulsion type	Visual	Thin white emulsion
Emulsion stability test 5% in 400 ppm hard water	Internal	No oil separation & cream particles
pH of 5% solution	Internal	9.0 – 10.0
Foam depression in secs 5% in D.M Water	IP 312/74	20 secs max
Refractometer factor	Internal	1.00
Oil content	Internal	48 % min.

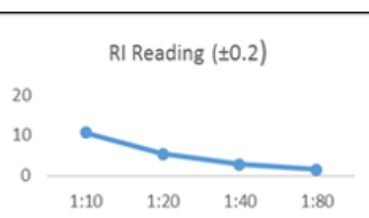
- Technical data details should be considered representative or typical values only and should not be used for specification purposes.

**Note\*:** Changes in the appearance of the product have no detrimental effect on the Quality /Performance of the product.

Metal	Compatibility
Ferrous	Yes
Aluminum	Yes
Brass/Copper	Yes
Magnesium	No
Titanium	No

Operation	Concentration	Concentration	RI Reading (±0.2)
Drilling	01:15	01:10	10.3
Broaching	01:10	01:20	5.2
Tapping	01:10	01:40	2.6
Milling	01:25	1:80	1.2



Note: It is strongly recommended that, initial coolant charging should be done at higher concentrations for optimum coolant performance.

**Packaging Details:** Available in 20 & 205-liter drums.

**Storage Recommendations:** Coolant tends to freeze at low temperatures. If frozen warm up completely and stir thoroughly before use. Inside storage is recommended and it should be stored out of direct sunlight in temperatures between 5°C-40°C. To avoid the cross contamination, always close the barrel/pail properly after usage.

**Shelf Life:** 12 Months

**Safety Recommendations:** For information on safety and disposal details, refer to safety data sheet.

**Disclaimer:** Information contained in this data sheet is based upon the properties and applications of use known to us. However, generally no legal liability may be deducted from such information.



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