



AMCOL Corporation

Product Bulletin for 2025 LF CHARCOOL

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DESCRIPTION

Semi-synthetic Coolant & Lubricant

2025 LF CHARCOOL is a water-dilutable semi-synthetic coolant & lubricant concentrate used primarily in CNC machining, cold forming of profiles and welded tubes, sawing, and a variety of related forming and fabricating operations associated with these applications (i.e. milling, drilling, tapping, bending, stamping, punching, swaging, end finishing, light drawing, etc.).

2025 LF CHARCOOL is a highly versatile coolant with multi-metal capabilities. This product is recommended for use on steel, stainless steel, aluminum, brass, and others.

Metal Machining, Forming and Fabricating

ADVANTAGES

- Superior Extreme Pressure Properties, Lubrication and Cooling
- Residual Film Provides Short Term Indoor Corrosion Protection
- Low-Smoke from Welding and High Heat Conditions
- Easily Mixed and Washed with Water
- Stable in Hard Water
- Resists Bacterial & Fungal Growth
- Thin Non-Visual Residual Film
- Mild Odor Characteristics

METHOD OF APPLICATION AND CLEANING

2025 LF CHARCOOL is recommended for use in flood, drip or spray application directly onto the tooling or metal. It may be used as received or extended with up to 30 parts water to 1 part concentrate. For best results, a fluid proportioner is recommended for achieving exacting dilutions.

2025 LF CHARCOOL is removed using warm water wash or mild alkaline cleaning solutions.



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Typical Refractometer Correlation Chart

2025 LF CHARCOOL
(using 10440 Industrial Fluid Tester)

| <u>Dilution</u> | <u>Reading</u> |
|-----------------|----------------|
| 40:1 | 0.80 |
| 30:1 | 1.00 |
| 20:1 | 1.50 |
| 10:1 | 2.80 |
| 5:1 | 5.10 |
| 1:1 | 15.00 |

Typical Physical and Chemical Properties

Physical State: Liquid at 25 deg C

Odor and Appearance: Clear green liquid with a mild amine odor.

Solubility (in water): Soluble

Specific Gravity: 0.95-1.05

pH: 8.9-9.5

Viscosity: 10-30 centistokes at 25 deg C