

MOL Emcool ADD

aluminium cold forming fluid



MOL Emcool ADD is a water-miscible auxiliary material developed for sheet forming operations. It is a highly refined mineral oil containing emulsifier, corrosion inhibitor, silicone-free anti-foam additives, as well as components for improving lubrication ability. It is particularly suitable for machining aluminium. It forms a milky emulsion when mixed with water. The recommended application concentration is 2.5 - 6 % (V/V). Refractometer factor: 0,9. Its 2.5 % (V/V) emulsion combined with MOL Fortilmo ADD 20 deep drawing fluid used for wall thickness reduction technology is excellent for cleaning the tools. It is free from chlorine, does not contain nitrites, secondary amines, PCB/PCT, heavy metal or barium compounds.

Application



Low- and medium-duty forming operations of fine sheets (stamping, punching, bending, deep drawing etc.)

Deep drawing of aluminium with wall thinning

Features and benefits

Excellent lubricity

Effective friction and wear reduction, giving a long life of tool edges

Excellent surface wetting

A continuous, easily spread film layer is formed on metal surfaces, ensuring continuity of lubrication
Productive manufacturing and excellent surface quality

Effective washing and rinsing properties

Keeps tool clean, prevents adhesion and seizure of metal particles and protects tool condition long-term
Lower specific tool cost

Specifications and approvals

ISO 6743-7: L-MAB

Properties

Properties	Typical values
Appearance	russet, clear
Density at 15°C [g/cm ³]	0,903
Emulsion pH value (5% (V/V) / 12 dH°)	8,3
Emulsion foaming characteristics (5 % (V/V) / 12dH°)	
- foam volume promptly (5 % (V/V) / 12dH°) [cm ³]	35
- foam vanishing time (5% (V/V) / 12dH°) [s]	5
Emulsion stability (5% (V/V) 12 dH°)	
- oil separation (5 % (V/V) / 12 dH°)	free
- cream separation (5 % (V/V) / 12 dH°)	in traces
Anticorrosion effect (5% (V/V) / 12dH°)	
- cast iron (5 % (V/V) / 12 dH°)	negative
- copper (5 % (V/V) / 12 dH°)	negative
- aluminium (5% (V/V) / 12 dH°)	negative

The characteristics in table are typical values of the product and do not constitute a specification.

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Storage and handling instructions

Store in the original container in dry, properly ventilated area. Keep away from direct flame and other sources of ignition. Protect from direct sunlight. To preserve the original quality keep the suggested storage temperature. During transport, storage and use of the product follow the work safety instructions and environmental regulations relating to mineral oil products.

In the concentration specified for use and in case of keeping the health safety rules, the emulsions are not harmful to human health and do not cause skin affection.

For further details please read the Material Safety Data Sheet of the product.

In the original container under the recommended storage conditions: 6 months

Recommended storage temperature: +5°C - +40°C

Ordering information

Custom Tariff Number 34031980

SAP code and packaging:

13006209 MOL Emcool ADD 180KG

216.5 l steel drum (for order only)

Order booking:

Please contact your local distributor or sales partner for ordering details.