

MOL Makromil 100 Special

environmentally compatible pressing fluid for brass strips



MOL Makromil 100 Special is a boron-free water-miscible cutting fluid having high mineral oil content. The product contains refined mineral oils, emulsifier, corrosion inhibitor, as well as components that modify the friction. The use of mixing equipment is recommended for preparing emulsions. The concentrate is always added to the water during agitated mixing. The concentration of the prepared emulsion should be checked using a calibrated refractometer. Refractometer factor: 1,0. Cleanliness of the system is a determining factor in terms of the operating life of the emulsion, so the use of MOL Netsol SC system cleaner is recommended before every change. The resistance to micro organisms can be ensured by maintaining a minimum emulsion concentration of 4-5 % (V/V).

Machining	Application concentration
Brass strip pressing	3-4
Machining	4-6

Application



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

Extrusion, chip forming machining of aluminium sheets

Chip forming and chipless machining of steel, alloys, light and yellow metals

Features and benefits

Good surface wetting properties

Excellent corrosion protection

Low foaming tendency

Effective temporary corrosion protection

Mild odour

Effective washing and rinsing properties

Ready miscibility with water

Free of boron, nitrites and secondary amines

Stability against microbial infection

Efficient wear reduction, long service life of tool edges and reduced specific tool cost

No staining on copper workpieces

Forms a continuous lubricating film, giving a balanced cooling effect and lubricity
Reduced environmental impact

Reduced manufacturing and surface treatment costs

More comfortable working environments

Clean machining equipment, tool and workpiece

Simple emulsion preparation

Beneficial in terms of workplace health requirements

Long lubricant drain period, pleasant working environment and cost efficiency with regular fluid control and maintenance

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Specifications and approvals

EMAG
ISO 6743-7: L-MAA

Properties

Properties	Typical values
Emulsion pH value (5% (V/V) / 12 dH°)	8,0
Emulsion foaming characteristics (5 % (V/V) / 12dH°)	
- foam volume promptly (5 % (V/V) / 12dH°) [cm3]	40
- foam vanishing time (5% (V/V) / 12dH°) [s]	7
Emulsion stability (5% (V/V) 12 dH°)	
- oil separation (5 % (V/V) / 12 dH°)	free
- cream separation (5 % (V/V) / 12 dH°) [cm3]	3
Anticorrosion effect (2% (V/V) / 12dH°)	
- cast iron (2 % (V/V) / 12 dH°)	negative
Anticorrosion effect (5% (V/V) / 12dH°)	
- copper (5 % (V/V) / 12 dH°)	negative
- aluminium (5% (V/V) / 12 dH°)	negative
Appearance of emulsion (5% (V/V) / 12dH°)	milky

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

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: 12 months

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

Ordering information

Custom Tariff Number 27101991

SAP code and packaging:

13006438	MOL Makromil 100 Special 50KG	60 l steel drum
13006437	MOL Makromil 100 Special 180KG	216.5 l steel drum

Order booking:

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