



**COOLANT
CONTROL** INC.

The right chemistry...

...the right solution

Product Bulletin

Durasol MA-3480

Semi-synthetic for Magnesium Machining

Description

Durasol MA-3480 is a high performance biostable semi-synthetic uniquely developed for the machining of magnesium and its alloys as well as both hard and soft aluminum alloys. This new multifunctional technology results in a very stable, bioresistant, low foaming product without residue formation in water up to 6000 ppm hardness.

Performance Benefits

- Excellent machining performance on magnesium and aluminum alloys in difficult operation such as roll form tapping, Mapal reaming, gun drilling, and deep hole boring.
- Stable emulsion up to 6000 ppm hardness
- Low foaming formula
- Biostable formula resists bacterial contamination preventing rancidity and extending coolant life.
- Excellent corrosion protection protects machine tools and parts.
- Extended sump life in central systems reduce overall costs.

Recommended Applications

Application	Concentration
Grinding	4% to 5%
Machining	5% to 7%

Typical Characteristics

Property	Typical Value
Appearance	Clear to slightly hazy amber liquid
Specific Gravity @72F	0.992
pH (5% in water)	9.5

Instructions for mixing coolant: For Grinding start with a 20:1 mix of water to coolant.
For Machining start with a 14:1 mix of water to coolant.

Always add the coolant to the water, never reverse!