



HOUGHTON™

PRODUCT DATA

Dromus BA (Exp)

Water miscible metalworking fluid

Applications

Dromus BA (Exp) is high mineral oil containing soluble oil for easy to medium duty machining, including grinding, on a wide variety of materials including ferrous and non-ferrous metals. Dromus BA (Exp) has also been found to give good performance in ferrous tube rolling applications.

Performance Features and Benefits

- High lubricity – high mineral oil content of emulsions provides excellent tool lubrication.
- Emulsion stability – readily emulsifies to form stable emulsions in a wide range of water hardness.
- Good corrosion protection – for both machine and workpieces even at low concentrations of 3 %.
- Low foaming
- Wide application range – suitable for use with a wide range of general engineering materials
- Cost effective
- Bioresistance – the formulation contains biocide(s) which promote a longer sump life.

Recommended Concentrations

The concentration varies depending on the type of machining operation, the water hardness and the required inter-operational corrosion protection. The recommended concentration for use in medium water hardness is:

- General machining : 5 – 8 %
- Heavy duty machining : 8 – 12%

Storage

The product should be stored inside (5-40°C) for no more than 1 year and be protected from freezing.

Fluid Partnerships Making a World of Difference

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Health & Safety

Please note that mixed coolants work over long periods of time, therefore chemical contamination (hydraulic oils, greases, metal solutions, paints, rust inhibitors, etc..) or bacterial contamination (from dirty hands, work pieces, industrial grade water, sundry waste, etc..) can often occur. Contamination with the above materials should be minimised or ideally eliminated. Regular monitoring of the in-use product is recommended to maintain optimum product condition and determine the end of its useful working life.

Protect the environment

Waste must be disposed of in accordance with EC Directive 91/156, 91/689 and 94/62 or in line with local legislation.

Typical Physical Characteristics

	Unit	Method	Dromus BA (Exp)
Mineral Oil content	%		80
Density @ 30°C	kg/m ³	DIN EN ISO 12185	886
pH of the emulsion at 5%		NFT 60193	8.5 – 8.8
Refractometer Factor			1

These characteristics are typical of current production. Whilst future production will conform to Houghton's specification, variations in these characteristics may occur.

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