

TECHNICAL DATA SHEET



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Millcool BFF

Millcool BFF is a high-performance, semi-synthetic water-soluble fluid specifically designed for the machining of tough ferrous and non-ferrous alloys. This medium oil content coolant uses a unique combination of chlorine-free lubricity additives to deliver superb machining performance. Millcool BFF is a low-foaming product and performs well in through-spindle and high coolant volume delivery applications, giving extended service life in the most difficult conditions.

Features & Benefits

- Chlorine-free lubricity additives combine with a medium oil content to deliver a superb surface finish and long tool life on tough ferrous and non-ferrous alloys
- Copes with through-spindle and high-volume coolant delivery without foaming, keeping visibility and cutting performance consistent under pressure
- Formulated to hold up over extended service life even in the most demanding conditions, keeping fluid top-ups and maintenance to a minimum
- Free from secondary amines, boron and formaldehyde, supporting a cleaner hazard data sheet and straightforward audit sign-off

Application

Millcool BFF is ideal for CNC machining centres and multi-spindle lathes running multi-metal machining programmes. Its low-foaming formulation and full compatibility with through-spindle coolant delivery make it well suited to high-pressure, high-volume central coolant systems.

Material Suitability:

- Ferrous Alloys
- Aluminium Alloys
- Yellow Metals

Machining Operations & Recommended Dilution Rate:

Operation	Recommended Dilution Rate
Turning, Milling & Drilling	4-6%
Tapping & Threading	5-7%
Reaming & Deep Hole Drilling	7-10%

Typical Characteristics

Emulsion appearance	Semi-translucent
pH at 5% in distilled water	9.8
IP 287 Corrosion break point	2.0%
Refractometer correction factor	1.4
Water hardness limit	25-250ppm