

**TECHNICAL DATA SHEET**

# ***Soluble lubri-coolant fluids*** ***Performa***

***boron- and biocide free***

## **Main features**

The Performa Due mineral lubri-coolants, without boron and biocides, are prepared to improve the impact on the environment, to protect the operators' health and to guarantee high performance during cutting works.

### **The lubri-coolants have the following characteristics:**

- boron free
- biocide and diethanolamine free
- chlorine free (Due CF)
- resistant to bacterial degradation without producing unpleasant smells, even if they are triazine bacteria free
- good skin tolerability

### **Performa Due lubri-coolants diluted in water at the concentrations of use allow for:**

- recycling in single or centralised machine tool tanks
- an excellent lubricating property that guarantees a significant reduction in friction, ensuring excellent surface finishing of worked parts and longer durability of the tools
- the constant stability in water of medium hardness
- foam not to form with medium mild water
- a low degree of significant alkalinity so as not to stain the aluminium and light alloys
- an increase in machine tool performance
- a significant reduction in chemical risk
- to have higher protection against oxidation on both finished parts and machine tools
- a cost reduction in oil disposal

## **Field of application**

### **Performa Due lubri-coolants are specific for:**

- replacing oils containing boron, amines and biocides
- drawing operations on all metals, even with boring machines or precision boring machines on aluminium and/or its alloys
- arduous removal operations on alloyed steels
- AVP working

### **The peculiar formulations of Performa Due mineral lubri-coolants are free from:**

- boron and amine compounds
- diethanolamine and nitrosamines
- formaldehyde and its donors
- nitrites and their donors
- E.P. additives containing sulphur - phosphorus - zinc
- Polychlorinated biphenyl and Terphenyl
- ZnDTP

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Main characteristics of multi-purpose preparations

Product	Appearance	Mineral oil content	EP additives content	Lubricant additives content	Initial water hardness	Refractometric correction	Recyclability
Performa Due	Milky green	High	Medium	Medium	10-35	1	High
Performa Due A	Milky green	Medium	High	Low	10-30	1	High
Performa Due CF	Milky green	Medium	Absent	High	10-35	1.05	High

Product	Appearance	Mineral oil content	EP additives content	Lubricant additives content	Initial water hardness	Refractometric correction	Recyclability
Performa Due Due	Milky white	High	Medium	Medium	10-35	1	High

Application guide

	Cast iron		Steel C		Stainless Steel		Steel Pb		Aluminium Si		Aluminium MgCu		Copper alloys	
	T	R	T	R	T	R	T	R	T	R	T	R	T	R
<b>Minerals</b>														
Performa Due	5-8 ■■■		5-8 ■■■		5-8 ■■■		5-8 ■■■		5-8 ■■■		5-8 ■■■			
Performa Due A	5-8 ■■■		5-8 ■■■		5-8 ■■■		5-8 ■■■		5-8 ■■■		5-8 ■■■			
Performa Due CF	5-8 ■■■		5-8 ■■■	3-5 ■	7-10 ■	3-5 ■	5-8 ■■■		6-10 ■■■	3-5 ■	6-10 ■			

**Key**

T Turning  
R Grinding

■■■ Highly suitable  
■■ Suitable  
■ Not very suitable

The number expresses the refractometric percentage concentration of use