
Material selection in cutting fluids range of influence

The following recommendations base on many years of field experience with our metalworking fluids as well as the VDI guideline 3035 (9.97) which represents state of the art in engineering.

Recommendations apply to all Blaser cutting fluids:

- water-miscible (emulsions and solutions),
- straight oils (cutting oils, forming oils)
- mineral and vegetable oil based
- chlorine free and chlorinated.

Sealing compounds

recommended :

- NBR nitrile rubber with min. 36 % nitrile (e.g."Perbunan")
- FPM fluor caoutchouc with min. 68% fluorination (e.g. "Viton")
- FFKM perfluor caoutchouc (e.g. "Kalrez")
- HNBR hydrated nitrile rubber
- AU + EU polyurethane

not recommended :

- NR natural rubber
- CR (poly)chloroprene rubber (e.g."Neoprene")
- EPDM ethylene propylene rubber

Coating materials

recommended :

- solvent-free or low level solvent two-component coatings based on:
 - epoxy resin (EP)
 - polyurethane resin (PUR)
- Pre-treatment of surfaces :
 - degreasing, pickling, abrasive blasting or phosphating

not recommended :

- single component coatings, including so called "oil resistant"

Materials for pipes, tubing and fittings

recommended :

- steel pipes
- chemically nickel-plated brass fittings
- plastic pipes and tubes

not recommended :

- galvanised steel pipes
- non-ferrous metal accoutrements