

TECHNICAL DATA SHEET

Calform SF10

Tube rolling coolant

DESCRIPTION

Callington Calform SF10 oil is a chlorine and boron free, Tube rolling coolant. Its high mineral oil content and unique additive package provides excellent lubrication and corrosion protection properties, forming a milky type emulsion, it provides consistent performance in a wide range of water types.

APPLICATION

Callington Calform SF10 is suitable for use in small to large sump tank for tube rolling mill. Also can use in general machine shops, where general machining operations, on a range of materials, requires a stable product, offering versatility at a reasonable cost.

Callington Calform SF10 is particularly recommended for tube rolling mill where rust protection and sump-life are the key concern. It is non staining to aluminium alloys

Recommended water range is 50ppm- 400ppm hardness as CaCO₃

BENEFITS

Contain premium corrosion protection additive so can protect rust for some period without coating with rust protection products.

Stable, low scum performance in hard water environments, providing cleaner working condition and lower top up rate.

Low foam performance in soft water conditions, eliminating use of antifoams and reducing maintenance costs.

Effective biocide system, to prevent bacterial degradation, and extend coolant life.

Boron free for environmental compliance and reduced residue characteristics.

Chlorine, phenol and nitrite free, meeting local legislation, waste treatment and environmental requirements.

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RECOMMENDED DILUTIONS

Material	Low-medium alloy steel	High alloy steel	Aluminium alloys
Operation			
Tube rolling	3-5%	3-5%	3-5%
Turning	4-5%	5%	5%
Milling			
Boring			
Drilling			
Tapping	7%	8-10%	7%
Threading			

TYPICAL DATA (note: data is typical and does not constitute a specification).

Concentrate	Test Method	Typical Result
Appearance	Visual	Clear amber liquid
Density	DIN 51757/ASTM D1298	0.88
Solution	Test Method	Typical Result
Appearance	Visual	Milky white emulsion
pH5%	DIN 51361/ASTM E70-97	9.5
Refractometer Factor		1.1

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