

**BONDERITE®**

Product Overview

# Cutting Fluids for Metal Removing



**Henkel** Excellence is our Passion

# BONDERITE L-MR cutting fluids

## One Core Range – for Total Process Cost Reduction



### Core Range

Water-miscible cutting fluids	Category	Short description	Materials					Application concentration %	Topping-up concentration %	Amines	Boron	DCHA*
			Aluminium	Cast iron	Steel	Stainless steel	Non-ferrous metals					
BONDERITE L-MR 42-4	Synthetic	Lubricant for nearly all grinding operations	■	■	■	■	■	3 – 5	0.5 – 1	X	–	–
BONDERITE L-MR 71-7	Semi-Synthetic	Multi-purpose machining of cast iron alloys, steel alloys	■ ■ ■	■ ■ ■ ■	■ ■ ■ ■	■ ■ ■	■ ■ ■	5 – 8	0.5 – 1.5	X	X	–
BONDERITE L-MR 90-2	Semi-Synthetic	Multi-purpose machining of steel alloys and aluminium alloys	■ ■ ■ ■	■ ■ ■ ■	■ ■ ■ ■	■ ■ ■ ■	■ ■ ■ ■	5 – 8	0.5 – 1.5	X	–	–
BONDERITE L-MR 21972	Semi-Synthetic	Heavy machining of aluminum alloys and alloyed steel (incl. stainless steel) for a wide range of water hardness, especially for soft water	■ ■ ■ ■	■ ■ ■ ■	■ ■ ■ ■	■ ■ ■ ■	■ ■ ■ ■	5 – 8	1 – 1.5	X	–	–
BONDERITE L-MR 232160	Semi-Synthetic	Machining of non-ferrous metals, brass, aluminum and steel	■ ■ ■	■ ■ ■	■ ■ ■	■ ■ ■	■ ■ ■ ■	5 – 10	1.0 – 2.5	–	–	–
Straight cutting fluids								Visc. / 40 °C (DIN 51562)	Flash point (DIN ISO 2592)	Noack-value Wt.-% DIN 51581	Sulphur content %	
BONDERITE L-MR 225-1	Neat oil	Honing and cutting oil, based on natural vegetable oils, for medium and heavyduty machining	■ ■ ■ ■	■ ■ ■ ■	■ ■ ■ ■	■ ■ ■ ■	■ ■ ■ ■	18	> 230° C	5	10	–

■ ■ ■ ■ Especially recommended

■ ■ ■ ■ Suitable for the application with the following materials

■ General  
turning, drilling, milling, reaming,  
sawing, thread machining

■ Heavy  
broaching, deep-hole drilling,  
honing, reaming

■ Grinding

\*DCHA = Dicyclohexylamine

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