



Cola®Lube 3406

Metalworking Lubrication Additive

CHEMICAL NAME Phosphate Ester
LISTINGS US (TSCA); Canada (DSL); Australia (AICS); Philippines (PICCS); Korea (ECL); China (IECSC); New Zealand (NZIoC)

Cola®Lube 3406 is a very low-foaming aromatic phosphate ester designed for synthetic metalworking fluids, especially grinding fluids. It provides good corrosion inhibition, lubricity and wetting properties. Neutralization with alkanolamines is required before use.

- Very low-foaming
- Useful in aqueous alkaline systems where zero foam is required
- Does not contain nitrites, chromates or azole chemistries

SPECIFICATIONS

Appearance @ 25°C	Clear to Slightly Hazy Liquid
Acid Value, pH 5.5	96 – 107
Acid Value	140 - 160
Moisture, %	1.0 Max.
Color, Gardner '98	3 Max.
Specific Gravity	1.15 – 1.25

PERFORMANCE TESTING RESULTS

Cast Iron Chip Test Pass
1% active solution in 20,000 hardness water (test results below)



Test performed using single VWR filter paper, 415 (28320-020)

PERFORMANCE TESTING RESULTS

Shake Foam Test

(1 g Test Material into 50 mL DI water)

Immediate	80 mm
1 min.	0 mm
3 min.	0 mm
5 min.	0 mm
10 min.	0 mm



Immediate 1 Minute 3 Minutes 5 Minutes 10 Minutes

STORAGE AND HANDLING

Cola®Lube 3406 should be stored in closed containers. Shelf life is 24 months from date of manufacture. Cola®Lube 3406 is shipped in poly 55-gal drums, net weight 450 lbs (204.1 kg) and in bulk. Safety Data Sheet is available at www.colonialchem.com.

Colonial Chemical

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