



# Cola<sup>®</sup>Lube 3429

## Metalworking Lubricant and Emulsifier

**CHEMICAL NAME** Fatty Acid Alkanolamide  
**LISTINGS** US (TSCA); Canada (NDSL); Australia (AICS); Korea (ECL)

**Cola<sup>®</sup>Lube 3429** is a DEA and secondary amine-free water-soluble lubricant and emulsifier for aluminum and copper. It features moderate foaming, is easily emulsified and increases metalworking fluid affinity for metal surfaces. Cola<sup>®</sup>Lube 3429 is stable at high temperatures, provides wetting for metal surfaces and is non-staining on aluminum and copper surfaces. Cola<sup>®</sup>Lube 3429 augments formulation bioreistance and is easily waste-treatable.

### KEY PERFORMANCE ATTRIBUTES

- Excellent lubricity additive
- Emulsification
- Provides corrosion inhibition
- Enhances formulation bioreistance, enables development of biocidal-free metalworking fluid formulations
- Helps extend sump life
- Easily waste-treatable
- DEA and secondary amine-free
- Provides detergency
- Moderate foaming tendency

### APPLICATIONS

- Semisynthetic Fluids
- Microemulsion coolants
- Machining and grinding gray iron
- Machining fluids for titanium alloys

### SPECIFICATIONS

|                    |              |
|--------------------|--------------|
| Appearance @ 25°C  | Clear Liquid |
| Alkali Value       | 150          |
| Acid Value         | 41.0         |
| pH (10% aqueous)   | 9.5          |
| Color, Gardner '98 | 11 Max.      |

### PERFORMANCE TESTING

#### Shake Foam Test (1g Test Material into 50 mL DI water)

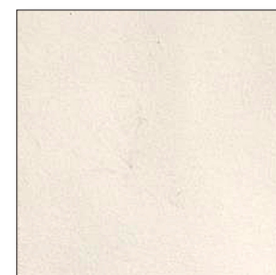
|              |               |
|--------------|---------------|
| 1 min. 15 mm | 5 min. 11 mm  |
| 3 min. 13 mm | 10 min. 10 mm |



1 Minute 5 Minutes 10 Minutes

### CAST IRON CHIP TESTING

(2.0% in DI Water)  
 Result: 0% Rust  
 (shown right)



### STORAGE AND HANDLING

Cola<sup>®</sup>Lube 3429 is shipped in 55 gal. drums, net weight 450 lbs (204.1 kg) or bulk and should be stored in closed containers. Shelf life is 12 months from date of manufacture. A Safety Data Sheet is available at [www.colonialchem.com](http://www.colonialchem.com).

## Colonial Chemical

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*Innovative Specialty Surfactants*