



# Orelube®

**technical  
information**

## BOELUBE® 70104 HIGH EFFICIENCY MACHINING LUBRICANT

BOELUBE® 70104 is non-toxic, non-irritating, environmentally safe synthetic lubricant manufactured from personal care ingredients that is effective for machining many types of materials. BOELUBE® 70104 will provide superior lubricity leading to better finish and longer tool life.

The special BOELUBE® chemistry yields a high polar lubricating film, which greatly reduces friction minimizing heat generation and subsequently the need to remove heat. BOELUBE® is most effective when applied sparingly.

BOELUBE® is a registered trademark of The Boeing Company. The Orelube Corporation holds an exclusive worldwide license from The Boeing Company to manufacture and market the Boelube® series of lubricants.

BOELUBE® 70104 is non-corrosive, non-flammable, chemically stable, and free of Halogens, Silicone, Petroleum, Paraffin Wax, Sulfur, Phosphorus and Heavy Metals whether added or present in any of its ingredients.



BOELUBE® 70104 is compatible with Aluminum, Titanium, Graphite, Composites, Honeycomb, Inconel, Kevlar, Wood, Ferrous and Non-ferrous Metals.

BOELUBE® 70104 is recommended for Drilling, Deburring, Broaching, Forming, Grinding, Milling, Routing, Reaming, Gun Drilling, Oil Hole Tools, Sawing, Punching and Tapping.

BOELUBE® 70104 is designed for all Mist, Spray, One Shot and Thru-the-Tool applications, and is ideal for applications where Cold-Cut® or Positive-Lube units are utilized.

Ideally applied at a rate of  $\frac{3}{4}$  ounce or less per hour of machining time leaving little or no clean up and no disposal costs. Applicators apply a precise amount of BOELUBE® Liquid to the interface of the cutting tool and work piece to reduce heat generation. BOELUBE®, in combination with Air, keeps tools cool and removes chips.

The application of BOELUBE® lubricant in machining operations will speed production, improve surface finish, and produce close tolerance parts. The resulting chips are dry, not tacky and can be reclaimed without further processing. BOELUBE® is totally consumed by chip coating, part coating or some combination, therefore the collecting, treating and disposal required of flood coolant is eliminated.

The direct and indirect cost savings achieved with the proper use of BOELUBE® coupled with its other unique and desirable properties, illustrates how BOELUBE® can be used to replace conventional lubricants.