

BOELUBE "A Better Way"

A Space Age Lubricant developed by The Boeing Company that fights friction at the interface of the cutting edge and the workpiece. The reduction of friction at these surfaces minimizes heat generation and concurrent chip weld. Tools retain their cutting edge longer, leading to closer tolerances and prime chip yield.

Manufactured from personal care ingredients, Boelube is non-toxic, non-irritating and biodegradable.

Boelube is non-corrosive, non-flammable, chemically stable and free of halogens, heavy metals, sulfur, phosphorus, silicone, petroleum or paraffin wax.

Boelube does not contain any ingredients considered a hazardous substance by OSHA, WHMIS, IARC, NTP, and State Regulatory Lists, Refer to Material Safety Data Sheets for additional information.

Unique Chemistry

Boelube's high film strength and lubricity and unique polar properties are the keys to its ability to provide superior metalworking lubrication.

Advantages

Boelube Liquid, Paste and Solid will not support bacterial or fungal growth. Superior thermal and oxidation stability provides indefinite shelf life.

Boelube will not promote dermatitis and presents a safe effective method for operators to machine various types of materials without special handling, fluid recycling or typical disposal problems.

Easily removed with aqueous cleaner, solvent, denatured alcohol or isopropanol. Approved for nuclear exposure. Does not have to be removed prior to heat treat. In most cases Boelube is compatible with paints and sealants. Boelube can be left on the workpiece for subsequent machining or as a corrosion inhibitor.

Key Attributes

Boelube is a registered trademark of the Boeing Company. These products represent a family of proprietary lubricants developed through Boeing manufacturing operations and lubricant experience.

The Orelube Corporation holds an exclusive worldwide license from The Boeing Company to manufacture and market the Boelube series of lubricants.

Aerospace manufacturing requires close tolerances and clean environments. Boelube is widely used by manufacturers of commercial and military Aircraft and companies who supply parts and components to the Aerospace industry. Boelube is used in repair work on commercial aircraft by many of the world's largest Airlines.

Boelube is used by manufacturers in the Automotive, Electronic, Jewelry, Oilfield service and Woodworking industries.

Applications

Boelube is recommended for use on Titanium • Inconel • Aluminum • Stainless Steel • Graphite • Composites • Honeycomb • Kevlar • Wood • Ferrous and Non-ferrous metals.

Boelube Solid, Paste, Liquid and Water-Soluble products are useful in applications such as Abrasive Belts • Bending • Broaching • Cold Working • Deburring • Drilling • Drop Hammer • Forming • Grinding • Gun Drilling • Milling • Punching • Reaming • Routing • Sawing • Tapping.

Boelube Pastes and Solids are useful as assembly lubricants when inserting seals, O-rings and certain critical tolerance fasteners.

The choice of which physical form of Boelube to use will depend on the operation, material type, speed and feed rate.



Boelube Product List

Order items by Product Code numbers

Boelube Solids

70200 White / 70201 Pink

PRODUCT CODE	SIZE	QUANTITY
70200-00	14.5 Oz. Cartridge	24 per Case
70200-13	1.6 Oz. Push Tube	100 per Box / 288 per Case
70200-14	4 Oz. Block	25 per Box / 150 per Case
70200-18	2 Oz. Stick	64 per Box / 384 per Case
70200-40	3.5 Oz. Push Tube	32 per Box / 192 per Case

Boelube Pastes

70302 Blue (Soft) / 70305 Pink (Hard) / 70307 Blue (Medium)

70307-02	2 Oz. Jar	350 per Box
70307-L	4 Oz. Jar	120 per Box
70307-05	35 Lb. Pail	
70307-11	5 Lb. Tub	5 or 8 per Case
70307-12	12 Oz. Jar	12 per Box / 36 per Case
70307-07	120 Lb. Drum	
70307-09	400 Lb. Drum	

Boelube Liquids

70104 Red (100A) / 70106 Clear (100F) / Boelube 90 Clear (70090)

70104-04	1 Gal. Container	6 per Case
70104-05	5 Gal. Pail	
70104-07	15 Gal. Drum	
70104-09	55 Gal. Drum	
70090-L	4 Oz. Bottle	36 per Box

Boelube Water-Soluble Fluid

70105

70105-05	5 Gal. Pail	
70105-07	15 Gal. Drum	
70105-09	55 Gal. Drum	

BOELUBE High Efficiency, Environmentally Safe Lubrication

The application of minute amounts of Boelube, consumed in the metalworking process, will greatly improve tool life, surface finish and hole quality.

The resulting chips are dry, not tacky and can be reclaimed without further processing.

Reduces Friction

Boelube's high strength polar lubricating film on the tool reduces friction, thus minimizing heat generation and subsequently the need to remove heat.



Less is Better

The psychology of "if a little is good, more is better" should be reversed when using Boelube, as it is most effective when applied sparingly.

Improves Tool Life

Boelube provides superior lubricity when machining materials such as aluminum, titanium and inconel, resulting in a higher quality finish while extending tool life by 200% or more.

Cost Savings

Are derived through longer tool life, increased productivity, reduced lubricant usage, lower shop maintenance costs, and clean chips, parts and machinery. Boelube is the most effective and least expensive lubricant for most metalworking operations.

Boelube Pastes

Boelube Paste is available in three forms – Soft (Blue), Medium (Blue) and Hard (Pink).

Boelube Pastes are extremely cost effective in single point work such as Tapping, Drilling or Reaming.

A small amount of Boelube Paste applied to the tool is all that is required to obtain a high quality finish and increased tool life with little or no clean-up required. Brush it on or dip tool in paste.

Boelube Pastes are ideal for Forming and Bending as well as in Drop Hammer, Thread Cutting and Spin Forming applications. They provide closer tolerance parts and extended diaphragm and die life.



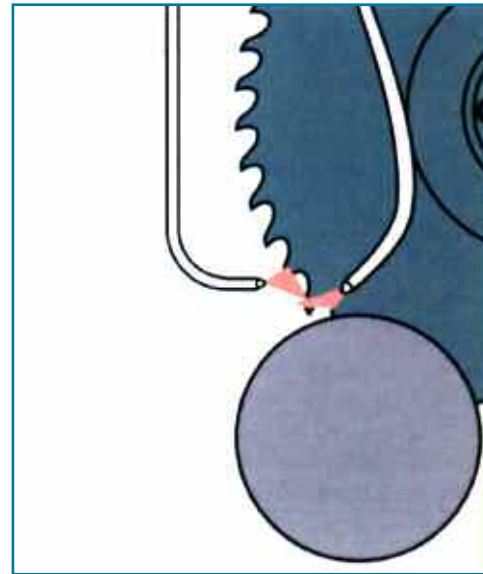
Boelube Solids

Come in a variety of shapes and sizes to accommodate ease of application.

Boelube Solids produce a high quality finish in many applications such as Drilling • Tapping • Reaming • Abrasive Belts • Files • Deburring Tools • Grinding Wheels • Awls • Chisels • Band, Circular and Hand Saw Blades.

Improve tool life by reducing heat build-up in belt, disc and wheel grinding operations. Apply the push-up tube to the tool before start-up.

Individual Boelube Blocks are ideal for grinding operations as well. Apply to belts or discs prior to start-up.



Boelube Liquids

For all Mist, Spray, Fine Droplet, One-Shot and Thru-the-Tool applications such as Drilling • Tapping • Reaming • Grinding • Milling • Routing • Punching • Forming • Deburring • Broaching • Gun Drilling.

Ideally applied at a rate of 3/4 of an ounce or less per hour of machining time leaving little or no clean up or related costs.

Applicators apply a precise amount of Boelube Liquid to the cutting edge of the tool to reduce heat generation. Boelube, in combination with air, keeps tools cool and removes chips.

Spray or One-Shot applications leave a minimal amount of Boelube Liquid that can be left on the workpiece for subsequent machining or as a corrosion inhibitor.

Boelube 90 will remain in a fully liquid state at temperatures as low as -20°F.

Boelube Water-Soluble Fluid

Is a non-toxic synthetic micro-emulsion lubricant that when diluted with water, will form a clear white emulsion that is effective for machining many types of materials, leading to better finish and longer tool life.

Boelube Water-Soluble fluid provides effective cooling and cleanliness enabling open, free grinding.

Parts and machinery are protected from rust and corrosion. Machine tool operators will appreciate its mild alkalinity.

Boelube Water-Soluble fluid has low foaming characteristics, and will not leave a tacky residue on machinery or machined parts.

Recommended Dilutions:

General Machining	15:1 - 20:1
Reaming, Tapping	10:1 - 20:1
Broaching	10:1 - 15:1
Grinding	15:1 - 25:1



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THE ORELUBE CORPORATION



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A Family of Proprietary
Lubricants Developed
Through Boeing Manufacturing
Operations and Lubricant
Experience

