



# Shell Dromus BA

## Water miscible metalworking fluid

Shell Dromus BA is a general purpose soluble oil for light to moderate duty machining on a wide range of materials.

### Applications

Shell Dromus BA is high mineral oil containing soluble for easy to medium duty machining, including grinding, on a wide variety of materials including as well ferrous as non-ferrous metals.

- General machining : 6 – 8 %
- Heavy duty machining : 8 – 12%

### Performance Features and Benefits

- **High lubricity** – high mineral oil content of emulsions provides excellent tool lubrication.
- **Emulsion stability** – readily emulsifies to form stable emulsions in a wide range of water hardness.
- **Good corrosion protection** – for both machine and workpieces
- **Low foaming**
- **Wide application range** – suitable for use with a wide range of general engineering materials
- **Cost effective**

### Storage

The product should be stored inside (5-40°C) for no more than 1 year and be protected from freezing.

### Health & Safety

Please note that mixed coolants work over long periods of time, therefore chemical contamination (hydraulic oils, greases, metal solutions, paints, rust inhibitors, etc..) or bacterial contamination (from dirty hands, work pieces, industrial grade water, sundry waste, etc...) can often occur. Contamination with the above materials should be minimised or ideally eliminated. Regular monitoring of the in-use product is recommended to maintain optimum product condition and determine the end of its useful working life.

### Recommended Concentrations

The concentration varies depending on the type of machining operation, the water hardness and the required inter-operational corrosion protection. The recommended concentration for use in medium water hardness is:

### Protect the environment

Waste must be disposed of in accordance with EC Directive 91/156, 91/689 and 94/62 or in line with local legislation.

### Typical Physical Characteristics

|                                | Unit              | Method           | Shell Dromus BA |
|--------------------------------|-------------------|------------------|-----------------|
| Mineral Oil content            | %                 |                  | 80              |
| Density @ 20°C                 | kg/m <sup>3</sup> | DIN EN ISO 12185 | 885 - 892       |
| pH of the emulsion at 5% (TH0) |                   | NFT 60193        | 8.5 – 8.8       |
| Refractometer Factor           |                   |                  | 1               |

These characteristics are typical of current production. Whilst future production will conform to Shell's specification, variations in these characteristics may occur.