

**POLYQUENCH BW-510N****Aqueous, synthetic quenchant****General properties**

POLYQUENCH BW-510N is a viscous fluid with reverse solubility. Cooling characteristics of BW-510N solutions with different concentrations are similar to an ordinary mineral and tap-water as well. The excellent cooling characteristics of BW-510N indicate that high cooling rate like water is still kept even under higher concentration at high and medium temperatures, while there is a slow cooling rate at lower temperatures.

**Typical properties**

Items	Results	Test method
Appearance, conc	Transparent	Visual
Specific gravity, 15/4 °C	1.086	ASTM D1298
Kinematic Viscosity, 40 °C, mm <sup>2</sup> /s	480	ASTM D 445

**Operating Concentration**

At spray quenching on induction hardening

- |                                |                |
|--------------------------------|----------------|
| 1. Plane carbon steel (<0.5%C) | : 5 to 20 wt%  |
| 2. Plane carbon steel (>0.5%C) | : 10 to 30 wt% |
| 3. Alloy steel (<0.4%C)        | : 5 to 20 wt%  |
| 4. Alloy steel (>0.4%C)        | : 10 to 30 wt% |

**Temperature control**

The best operating temperature of BW-510N for quenching should be between 25 and 40 °C, max 50 °C. Temperatures should never exceed 60 °C. If the temperature is above 60 °C, the solution should be cooled down to 40 °C before the next hardening of pieces.

**Term of validity**

12 months from the date of manufacture at sealed state.

**Safety information**

Refer to the our MSDS for safety information.

The information contained and the recommendations made in this data sheet are based upon data collected and believed by us to be correct. However, no guarantee or warranty of any kind, expressed or implied, is made herein with respect to the merchandise described and we assume no responsibility for the results or the use there of.