

PASTE LUBRICANTS

LIQUID LUBRICANTS

SOLID LUBRICANTS

BOELUBE PASTES

Multi Use Pastes

High Performance MQL Lubricants



BOELUBE®



A BOEING DEVELOPED LUBRICANT

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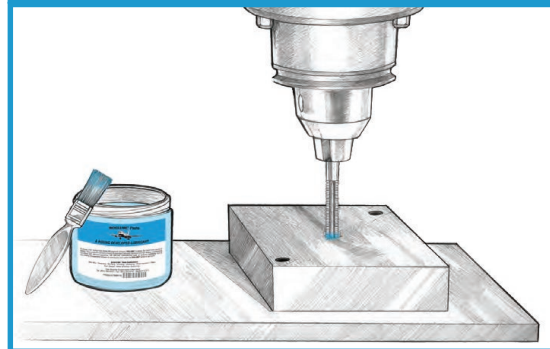
BOELUBE® Paste is dermal non-irritant, biodegradable synthetic lubricant for **minimum quantity lubrication (MQL)** application.

BOELUBE® LUBRICANTS FOR NEAR DRY MACHINING ■■■

One of the earlier uses of near dry machining was in aircraft manufacturing. Freon® gas was used in three distinct areas of the riveting process – drilling, rivet insertion, and rivet-head milling. Because of the undesirable effects of Freon® gas on the ozone layer, Boeing manufacturing research and development engineers introduced an alternative method using BOELUBE® lubricant compositions to efficiently lubricate and cool tools by preventing heat buildup, while greatly reducing the reworking after drilling that had been necessary with Freon® because of exit burrs, oversized holes, and a rough finish on the inside surface of the holes.

BOELUBE® lubricants were used in drilling, reaming, and coldworking of fastener holes in aircraft wing skins; installation of wedge-head lock bolts; lubrication of hand drills; and on machinery that automatically drill rivet holes and install rivets on large sections of airplanes. It was shown that the application of minimal quantities of BOELUBE® lubricant could reduce friction, speed production, increase tool life, and improve surface finish and hole quality in a number of machining operations.

BOELUBE® Pastes are extremely cost effective in single point work such as drilling, reaming and tapping. A minimal amount of paste applied to the tool is all that is required to improve surface finish, yield closer tolerances and extend tool life. Brush it on or dip tool in paste.



TYPICAL PROPERTIES ■■■

70302

- Soft Paste
- Blue
- Insoluble in Water
- Melt Range: 90-110F (32-43C)

70305

- Hard Paste
- Pink
- Insoluble in Water
- Melt Range: 90-110F (32-43C)

70307

- Medium Paste
- Blue
- Insoluble in Water
- Melt Range: 90-110F (32-43C)

PRODUCT BENEFITS ■■■

70302

- High Lubricity
- 100% active
- Long shelf life
- Minimal lubricant usage

70305

- High Lubricity
- 100% active
- Long shelf life
- Minimal lubricant usage

70307

- High Lubricity
- 100% active
- Long shelf life
- Minimal lubricant usage



MATERIALS ■■■

	70302	70305	70307
Alloy	✓	✓	✓
Aluminum	✓	✓	✓
CFRP	✓	✓	✓
Composite	✓	✓	✓
Copper	✓	✓	✓
Glass fiber	✓	✓	✓
Kevlar	✓	✓	✓
Stainless steel	✓	✓	✓
Titanium	✓	✓	✓
Wood	✓	✓	✓

Certifications

BOEING

BAC Boeing Process Specification
5008 • 5054 • 5063 • 5492 • 5540
5578 • 5657 • 5768

BOMBARDIER

BAMS 569-001 Rev B Lubricants/
Coolants

ISO 9001:2015

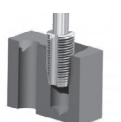
ISO Quality Management System
Certification

Applications

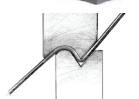
Drilling



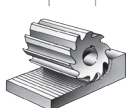
Tapping
Reaming



Forming



Milling



And many more...

BOELUBE PASTES

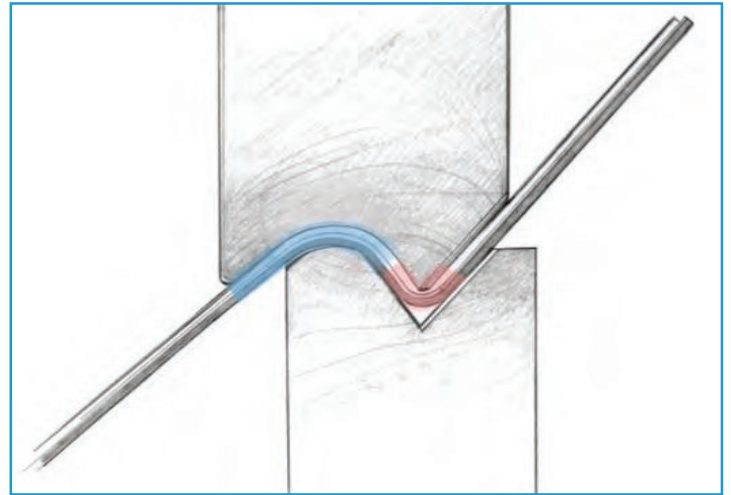
Technical information

FOR FORMING AND BENDING ■■■

BOELUBE® Pastes provide an excellent means of obtaining maximum stretch area and close tolerance bends by providing superior lubrication that allows the workpiece to attain the desired shape without creating areas that are stressed.

Product Recommendation:

- Less Severe: Boelube 70302 or 70307
- More Severe: Boelube 70305



BOELUBE PASTES ■■■



- Non-petroleum
- Non-sulfur
- Non-phosphorus
- Non-silicone
- Non-paraffin wax
- Non-halogen
- Non-corrosive
- Contain no water
- Used in aerospace and other manufacturing industries

BOELUBE PASTES PRODUCT LIST ■■■

70302-02	Multi Use Soft Blue Paste	Jar 2 oz - 57 g	150 per Box	
70302-L	Multi Use Soft Blue Paste	Jar 4 oz - 113 g	30 per Box	150 per Case
70302-12	Multi Use Soft Blue Paste	Jar 12 oz - 340 g	12 per Box	36 per Case
70302-05	Multi Use Soft Blue Paste	Pail 35 lb - 16 kg	1 each	
70305-02	Multi Use Hard Pink Paste	Jar 2 oz - 57 g	150 per Box	
70305-L	Multi Use Hard Pink Paste	Jar 4 oz - 113 g	30 per Box	150 per Case
70305-12	Multi Use Hard Pink Paste	Jar 12 oz - 340 g	12 per Box	36 per Case
70305-05	Multi Use Hard Pink Paste	Pail 35 lb - 16 kg	1 each	
70307-02	Multi Use Medium Blue Paste	Jar 2 oz - 57 g	150 per Box	
70307-L	Multi Use Medium Blue Paste	Jar 4 oz - 113 g	30 per Box	150 per Case
70307-12	Multi Use Medium Blue Paste	Jar 12 oz - 340 g	12 per Box	36 per Case
70307-05	Multi Use Medium Blue Paste	Pail 35 lb - 16 kg	1 each	

BOELUBE® PASTES ■■■

Save time and money while being environmentally responsible.

Historically, the metalworking industry has used metalworking fluids by flood application in machining operations. But because the costs associated with use, management, and disposal of flood coolants has risen over the years, in part due to increasing federal, state, and local regulations aimed at worker safety and fluid disposal, there has been a growing trend to utilize methods requiring less metalworking fluid to reduce cost, protect the environment, and improve and protect worker health, without sacrificing productivity and quality.

A metalworking lubricant should impart sufficient lubricity between the tool and the workpiece to cause a significant reduction in friction to occur. BOELUBE® is a technologically advanced lubricant that significantly reduces friction (one of the major elements in generating heat during the material removal process).



Near dry machining lubricants can also be formulated into paste forms - BOELUBE® Pastes. In near dry machining the goal is high efficiency, which is achieved as a result of using a minimal quantity of lubricant. Because minimal quantities are used and consumed for the most part in the machining process, BOELUBE® Pastes produce near dry workpieces and chips with little or no clean-up or related costs and no disposal costs.

Drilling is one of the most widely used machining processes to produce circular holes in metallic and nonmetallic materials. A drill is a rotary endcutting tool, with the most common type being the twist drill. The drill, attached to either a stationary machine or hand held, is used to originate or enlarge a hole in a solid material. Drilling can be characterized as in a rough form, whereas reaming is the exact form.

A tap is a cylindrical tool that cuts internal threads and has flutes to remove chips and carry lubricant to the point of cut. Tapping is a machining operation in which a tap, with teeth on its periphery, cuts internal threads in a predrilled hole having a smaller diameter than the tap diameter.

COST SAVINGS ■■■

Cost savings are derived through longer tool life, better surface finish, increased productivity, reduction in lubricant usage and subsequent cleaning and disposal costs, reduced environmental impact, improved housekeeping and easier chip handling and recycling.

WORKER FRIENDLY ■■■

Manufactured from personal care ingredients, BOELUBE® is dermal non-irritant and biodegradable. Minimal lubricant usage reduces worker exposure.



The Orelube Corporation

Specialty Industrial Lubricants Since 1958

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