Lubrication solutions for general machining
Lubrication solutions for general machining

BECHEM – Lubrication solutions for industry

As the oldest German manufacturer of industrial lubricants, BECHEM is one of the leading producers of high-quality special lubricants and metalworking fluids today.

BECHEM products stand out through innovative formulations in the most diverse industrial applications – in machining and forming for metalworking processes, in coating technology and as for-life lubricants in various technical components.

A strong network of distributors and several national and international production sites ensure that BECHEM products are readily available worldwide.

Tomorrow’s technologies. Today.
Lubrication solutions for the entire process chain

Everything from one source: BECHEM lubricants ensure maximum efficiency and performance over the entire process chain. For all process steps, from general machining, cleaning and corrosion protection, BECHEM developed a fine-tuned product series offering a wide range of benefits.

Due to extended lifetime; maintenance is reduced, productivity is increased and the process is continuously improved. In addition, fewer suppliers enables lower cost and more efficient use of the lubricant. Cost-intensive damage and machine downtime can be prevented.

Ideal process maintenance is crucial for the extended lifetime and functionality of wire producing assets. BECHEM provides technical consultation on the proper use of various lubricants, offering added value in terms of safety and reliability in production.

With its BECHEM Avantin, Berucut, Beruclean and Beruprotect product lines, BECHEM offers a highly capable range of products for machining that exceed growing customer requirements in terms of environmental regulations, optimizing processes and combining methods. BECHEM products achieve a high cooling effect, excellent performance and enable efficiency improvements.
Process media for metal removal and forming technology

**FRONT AXLE ASSEMBLY**

- Spring Seat
  - Metal Removal: BECHEM Avantin 400
- Engine Mount
  - Metal Removal: BECHEM Avantin 405
- Steering Gear
  - Grinding: BECHEM Avantin 331 G
- Fastener
  - Cold Heading: Berufome MF 148-68
- Steering Levers
  - Massive Forming: Beruforge 2450 B
- Axle Carrier
  - Massive Forming: BECHEM Avantin 320 FF
- Spring Strut Bearing
  - Grinding: Berufome STO 114 2F
- Coupling Rod
  - Berufme 740-88
- Shock Absorber Tube
  - BECHEM Avantin 355 FF
- Brake Piston Carrier
  - Massive Forming: Berufunge 906 HP
- Brake Disc
  - Berufuid ST 2000

**REAR AXLE ASSEMBLY**

- Fastener Torque Bolt
  - Cold Massive Forming: Berufome MF 148 NEU
- Pipe Production
  - Forming/Welding: BECHEM Avantin 320 FF
- Gear Wheel Machining
  - Gear Hobber: BECHEM Avantin 455
- Stabilizer Bar
  - Berufme 906 HP
- Axle
  - Hydroforming: BECHEM Avantin 400

**AUTOMATIC TRANSMISSION ASSEMBLY**

- Coupling
  - BECHEM Avantin 338
  - BECHEM Avantin 438
- Valve Plate
  - BECHEM Avantin 455
- Valve Body Assembly
  - BECHEM Avantin 361-1 ZF
- Gear Wheel Production
  - Hobbing/Shaping: Berufcut XC 1202
- Brake Disc Production
  - Shaping: Berufuid ST 2000
- Brake Disc
  - Berufuid ST 2000
- Stamped
  - Berufome STO 121

**WIRING SYSTEM**

- Copper Wire Drawing
  - BECHEM Unopol
  - Berufome AL
- Image: © LEONI
Water miscible coolants

BECHEM Avantin is a product series of water-miscible coolant lubricants that have ensured process reliability millions of times for decades. From the allrounder for multi-metal applications and the expert on series processing in automotive production lines, to the specialist in broaching and deep drilling operations, BECHEM offers optimal and economical product solutions.

High-quality and globally available raw materials combined with the exceptional BECHEM development know-how form the basis for processing fluids that meet highest standards. The adjustment to the permanently changing process parameter guarantee the continuous development of our products.

BECHEM Avantin stays cool even when things get hot. Processes that involve high thermal loads are ideally supported by oxidation resistant, semi and fully synthetic product concepts. With minimal consumption, BECHEM Avantin impresses by excellent cooling, outstanding corrosion protection, and excellent removal of process materials.

> Amine-containing, boron- and FAD free*.

<table>
<thead>
<tr>
<th>PRODUCT</th>
<th>Base material</th>
<th>Lubrication performance</th>
<th>Process</th>
<th>Material to be processed</th>
</tr>
</thead>
<tbody>
<tr>
<td>BECHEM Avantin 420</td>
<td>Cast iron, steel</td>
<td>20</td>
<td></td>
<td>General cutting and grinding, thread milling</td>
</tr>
<tr>
<td>BECHEM Avantin 421-30</td>
<td>Cast iron, steel, low alloy steels</td>
<td>30</td>
<td></td>
<td>Grinding and demanding metal cutting, machine construction and toolmaking, motor- and drive components</td>
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<tr>
<td>BECHEM Avantin 438</td>
<td>High alloyed steels, nickel-based alloys</td>
<td>28</td>
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<td>General to demanding metal cutting, machining of engine blocks, cylinder heads, gear-box housings, pistons</td>
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<tr>
<td>BECHEM Avantin 441-10</td>
<td>Low- to high-alloyed steels</td>
<td>38</td>
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<td>General metal cutting and grinding, thread milling</td>
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<tr>
<td>BECHEM Avantin 451</td>
<td>Aluminum, cast iron, nonferrous metals, steel, titanium</td>
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<td>General metal cutting and grinding, machining of engine blocks, cylinder heads, gear-box housings, pistons</td>
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<tr>
<td>BECHEM Avantin 465</td>
<td>Aluminum, nonferrous metals, steel, titanium</td>
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<td>General to demanding metal cutting, machining of engine blocks, cylinder heads, gear-box housings, pistons</td>
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<tr>
<td>BECHEM Avantin 469</td>
<td>ADT-materials, high-tensile stainless steels, nickel-based alloys</td>
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<td>General cutting and grinding, thread milling</td>
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<tr>
<td>BECHEM Avantin 400 FF</td>
<td>Cast iron, steel</td>
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<td>Grinding, disc grinding, plain- and flat grinding, roll grinding</td>
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<tr>
<td>BECHEM Avantin 400</td>
<td>Cast iron, steel</td>
<td>0</td>
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<td>Plan- and flat grinding, roll grinding</td>
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<tr>
<td>BECHEM Avantin 405</td>
<td>Cast iron, steel</td>
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<td></td>
<td>General metal cutting and grinding, thread milling</td>
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<tr>
<td>BECHEM Avantin 405</td>
<td>Cast iron, steel</td>
<td>0</td>
<td></td>
<td>General to demanding metal cutting and grinding, thread milling</td>
</tr>
<tr>
<td>BECHEM Avantin 404 HMR</td>
<td>Carbide metal, casting, non-ferrous metals, steel</td>
<td>0</td>
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<td>Grinding of hard metals in the tool manufacturing</td>
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<tr>
<td>BECHEM Avantin 404 HM</td>
<td>Carbide metal, casting, non-ferrous metals, steel</td>
<td>0</td>
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<td>Grinding of hard metals in the tool manufacturing</td>
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<tr>
<td>Berufliud AL 1004</td>
<td>Aluminum, steel, titanium</td>
<td>0</td>
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<td>Turning, drilling, milling, produces excellent surfaces</td>
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<tr>
<td>Berufliud AS 1006</td>
<td>Aluminum, cast iron, steel</td>
<td>0</td>
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<td>General metal cutting and grinding</td>
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<tr>
<td>Berufliud AS 1008</td>
<td>Aluminum, steel, titanium</td>
<td>0</td>
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<td>Drilling, turning, milling, optical components, control and regulation technology</td>
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<tr>
<td>Berufliud BT 2003</td>
<td>Cast iron, nickel-based alloys, steel, titanium</td>
<td>0</td>
<td></td>
<td>General cutting and grinding</td>
</tr>
</tbody>
</table>

* Free of formaldehyde release agents, FAD

Free of FAD release agents, FAD

High... = very high

Large bore piston manufacturing with BECHEM Avantin
For the highest of performances in metalworking: BECHEM XC Fluids

The new BECHEM XC Fluids establish a pioneering standard for metalworking fluids that are not miscible with water. Using innovative base fluids and synergistically active additive technologies results in new excellent performance benchmarks and optimized production processes. BECHEM XC Fluids have been developed for demanding metal cutting and make a compelling case given their higher flash-points, low evaporation and reduced oxidation tendency, and they lead to increased performance and extended tool life.

Cutting- and grinding oil performance

The mineral oil-free BECHEM XC Fluids are based on synthetic base fluids and ensure a stable and safe production process. Users profit from improved work safety and low consumption. The continuously rising demands in metal cutting and machining processes require fluids with ever stronger performance. BECHEM XC is the new generation of BECHEM metalworking fluids that have been developed today for the future already and which set the highest BECHEM standard.

Berucut XC – the new technology for more reliability and safety

The evaporation loss of a base oil in increased temperatures is closely tied to the aerosol load of the direct machine environment. The poorer the evaporation characteristics of a metalworking medium, the more must be invested in suitable extraction systems. Compared to conventional mineral oils, the evaporation loss could be lowered by more than one-quarter through the use of Berucut XC and the odor build-up could be reduced significantly as well.

Modern metalworking processes use high lubricant oil pressures of 70 bar up to more than 100 bar. The air separation characteristics of the base oil therefore becomes an important factor in terms of quality, as the high shear strain when pumping the lubricant oil introduces a lot of air to the medium. Compared to conventional mineral oils, the air separation characteristics of the new Berucut XC series is up to three times faster.

Cutting- and grinding oil performance

The lubrication performance of a metalworking medium is closely tied to the viscosity-temperature behavior. In deep temperatures, too strong a rise of the viscosity is counter-productive, as the cooling and flushing capacity of the oil reduces. This is decisive whenever a process has not reached its operating temperature yet. In very high temperatures, in contrast, the thickness of the available lubricant film is decisive because the aspect of cooling becomes less important. Compared to conventional metalworking oils, the Berucut XC series proves to have substantially better viscosity-temperature characteristics in both high as well as low process temperatures, whereby it contributes to a significant improvement of productivity.
Grinding and machining

Advantages of the Berucut XC series

- Excellent oxidation stability
- Very high flashpoint
- Very high viscosity index
- Very low evaporation loss
- Excellent UV stability
- Low pour point, good deep temperature behavior
- Very good lubrication performance
- High cutting speeds
- Good material compatibility
- Very good foam control
- Very low PAH values (polycyclic aromatic hydrocarbons)

In-vitro cytotoxicity

Products that are used in medical technology must fulfill particularly strict standards regarding their toxicity and compatibility with biological systems. For medical products with longer-term or permanent tissue contact, the biological safety test for biocompatibility according to ISO 10993 is mandatory. The Berucut XC series has passed the test for in-vitro cytotoxicity according to DIN EN ISO 10993-5:2009 with the best possible rating (0 reactivity).

In the processing of implants made of titanium, Berucut XC guarantees very good surface and processing quality.

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## Table of Products

<table>
<thead>
<tr>
<th>PRODUCT</th>
<th>Material</th>
<th>Viscosity [mm²/s] at 40 °C</th>
<th>Flashpoint [°C]</th>
<th>Kinematic Viscosity</th>
<th>Machining</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Berucut XC 1010</td>
<td>Steel, stainless steel</td>
<td>13</td>
<td>185</td>
<td>++</td>
<td>medium to difficult</td>
<td>Turning, drilling, milling, grinding, deep drilling, thread milling, tool flank grinding</td>
</tr>
<tr>
<td>Berucut XC 1015</td>
<td>Steel, stainless steel</td>
<td>16</td>
<td>185</td>
<td>++</td>
<td>medium to difficult</td>
<td>Turning, drilling, milling, grinding, deep drilling, thread milling, tool flank grinding</td>
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<tr>
<td>Berucut XC 1022</td>
<td>Cast iron, steel</td>
<td>21,5</td>
<td>185</td>
<td>++</td>
<td>medium to difficult</td>
<td>Turning, drilling, milling, grinding, deep drilling, tool flank grinding</td>
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<tr>
<td>Berucut XC 1110</td>
<td>Cast iron, steel</td>
<td>10</td>
<td>190</td>
<td>++</td>
<td>medium</td>
<td>Grinding, simple metal cutting</td>
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<tr>
<td>Berucut XC 1115</td>
<td>Non-ferrous metals, stainless steel, steel</td>
<td>15</td>
<td>195</td>
<td>+++</td>
<td>medium to difficult</td>
<td>Turning, drilling, milling, grinding, deep drilling, thread milling, tool flank grinding</td>
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<tr>
<td>Berucut XC 1122</td>
<td>Non-ferrous metals, stainless steel, steel, titanium</td>
<td>21</td>
<td>165</td>
<td>++</td>
<td>medium</td>
<td>Turning, drilling, milling, grinding, deep drilling, thread milling, tool flank grinding</td>
</tr>
<tr>
<td>Berucut XC 1215</td>
<td>Steel, stainless steel, titanium, copper alloys, aluminum alloys</td>
<td>19</td>
<td>202</td>
<td>++</td>
<td>medium to difficult</td>
<td>Turning, drilling, milling, deep drilling, thread cutting, tool flank grinding</td>
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<td>Berucut XC 2003</td>
<td>Steel, stainless steel, aluminum, non-ferrous metals</td>
<td>3,4</td>
<td>136</td>
<td>•</td>
<td>easy</td>
<td>Cold rolling of sheet metals, punching, bending, edging, grinding</td>
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<tr>
<td>Berucut XC 2105</td>
<td>Cast iron materials, steel, nonferrous metals</td>
<td>7</td>
<td>168</td>
<td>•</td>
<td>easy</td>
<td>Honing, grinding, finishing</td>
</tr>
<tr>
<td>Berucut XC 2005</td>
<td>Cast iron materials, steel, stainless steel, titanium, carbide metal, non-ferrous metals</td>
<td>6</td>
<td>170</td>
<td>•</td>
<td>easy</td>
<td>Honing, grinding, finishing</td>
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<td>Berucut XC 2007</td>
<td>Cast iron materials, steel, stainless steel, titanium, carbide metal, non-ferrous metals</td>
<td>8</td>
<td>185</td>
<td>•</td>
<td>easy</td>
<td>Honing, grinding, finishing</td>
</tr>
<tr>
<td>Berucut XC 2010</td>
<td>Carbide metal, non-ferrous metal, stainless steel, steel, titanium</td>
<td>10</td>
<td>190</td>
<td>•</td>
<td>easy to medium</td>
<td>High speed, carbide metal processing, tool flank grinding, tool manufacturing</td>
</tr>
</tbody>
</table>
Deep drilling and broaching

BECHEM process oils of the Berucut series guarantee the best machining results even under the most severe conditions. Grinding processes exposed to high thermal stress, deep drilling operations in special materials, broaching processes with maximum feed rates, as well as optimised minimum quantity lubrication meet all challenges in serial production and always fulfill the highest expectations. The special BECHEM formulations set the standard in this industry.

BECHEM is a pioneer for innovations in national and international research projects. Our specialist in research, development and application technology create benefits and take responsibilities for processes that are exposed to permanent changes. BECHEM convinces as a strong partner with extraordinary expertise and product innovations.
Clean and protect

Cleaners

BECHEM offers the Beruclean series both in aqueous and solvent-based products for the residue-free cleaning of any process fluids in metalworking covering a wide range of materials and cleaning processes. The Beruclean neutral cleaners are highly concentrated and therefore very economical in use. Due to the various application possibilities of Beruclean neutral cleaner, the number of products required for the process chain can also be reduced.

Influencing factors when choosing the right cleaner

An optimal cleaner affects the factors of time, temperature and costs.

Corrosion protection

Extreme corrosion influences act on the manufactured components, such as semi-finished products or vehicle components, during long international transport routes and storage times. BECHEM has developed the Beruprotect product program especially for these requirements. Solvent-, oil-, and water-based products are mutually harmonised through modern additives for various applications in temporary corrosion protection.

Dewatering fluids are used for drying metal parts after treatment in an aqueous medium. The oily, waxy or vaseline-type film that forms protects against corrosive atmospheric influences and, to a limited extent, also against mechanical stresses.

Corrosion protection oils are used to apply oily protective films of different strengths and to preserve dry or oil-wet parts in intermediate storage for protection against moisture and corrosive components contained in ambient air. Humidity and other traces of water are partly absorbed by the protective film before they can penetrate to the base material and cause corrosion. BECHEM corrosion protection oils are also suitable for untreated ferrous metals as well as for galvanized or phosphated material.

Carbon waxes are used for drying metal parts after metalworking processes, for instance for steel and ferrous materials, and for use in conditioning media. Solvent containing protective waxes for long-term rust protection, outstanding adhesive properties, also suitable for salt water atmosphere.
Machine lubrication

For multiple applications in machine lubrication, BECHEM offers a product range that contributes significantly to the most modern production- and manufacturing technology as well as service and maintenance. BECHEM hydraulic fluids reduce friction and wear, including at high thermal loads, and inhibit corrosion with special additives, even under extreme loads. High performance gear oils and circulating oils from BECHEM also meet the requirements for wear protection even under high mechanical and dynamic loads and convince with very good air and water release properties. In slideway oils, friction and wear reducing additives ensure smooth machine table sliding in guide rails, even at slow sliding speeds and high specific surface pressures.

**PRODUCT**

| BECHEM Staroil NR 10 + 68 | Mineral oil | 10 to 68 | > 85 | -30 to -24 | ≥ 150 to 250 | HLP | DIN 51524-2 | Hydraulic oil with high thermal stability and resistance to oxidation, excellent protection against wear and corrosion, excellent air and water separation capacity as well as outstanding viscosity/temperature behavior, free of zinc
| BECHEM Staroil G 100 + 680 | Mineral oil | 100 to 680 | 95 to 100 | -33 to -18 | ≥ 230 to 270 | CLP | DIN 51517-3 | High-performance gear oil for spur, bevel, planetary and worm gears, excellent wear protection, very high ageing resistance, good load-carrying capacity and viscosity/temperature behavior, excellent water and air separation capacity
| BECHEM Spindle Oil 2 | Mineral oil | 2.3 | – | – | ≥ 101 | – | – | Non-water miscible spindle oil for the lubrication of fast running machine spindles, good cooling and lubricity, acid-free, non-resinous, effective water separation, good corrosion protection, chlorine-free
| BECHEM Staroil CGLP 32 + 220 MF | Mineral oil | 32 to 220 | 95 to 110 | -35 to -20 | ≥ 170 to 200 | CGLP, CLP | DIN 51502 | Multifunctional CGLP slideway oils and CLP gear oils, optimal adhesion on slide- and guide rails, very good aging resistance, very good load carrying capacity, excellent water separation capacity, very good non-ferrous metal tolerance, good AW/EP properties, chlorine- and heavy metal-free

**PRODUCT**

| Berulub PY 3 | Synthetic oil mixture | Diurea | 3 | 22 5 | 120 | Ball bearings in machine tool spindles for high speed machines, spindle bearings, hybrid bearings for the highest speeds, motor spindles also for additional heat build-up | Synthetic high performance lubricant for high speed ball bearings, good spindle start-up behavior at the first start, low air temperature development, lifetime lubrication at the highest speed
| BECHEM High-Lub LIC-200 | Mineral oil, synthetic oil | Lithium soap | 000 | 25 5 | 80 | Small high-speed gears | Semi-fluid grease for gear units and to supply lubrication points on trucks via central lubrication systems, reliable wear and corrosion protection even in case of water absorption, for high speed
| Berutox FB 22 | Polyalpha-olefin (PAO) Barium complex soap | 2 | 50 8 | 180 200 | High speed spindle bearings e.g. in tools and textile machines, high speed ball- and slide bearings, threaded spindles, gearwheels in compact gearboxes, worm gears, electric motor and fan bearings, bearings for guide rollers and slitting machines | For long-term lubrication at high speeds, good consistency-temperature-behavior, excellent water resistance, excellent corrosion and wear protection, good pumpability

**PRODUCT**

- **Base oil**
- **Viscosity** [mm²/s] at 40 °C
- **Viscosity index**
- **Pourpoint** [°C]
- **Flashpoint** [°C]
- **Specification**
- **Type**
- **Description**

**Further information**

- [Lubrication solutions for all machine components.](#)
Beruclean 3050 – Machine and floor cleaning agent

BECHEM also offers a product range of high-performance machine and floor cleaning agents, besides the complete range of fully matched process fluids, industrial cleaning agents and corrosion protection agents for the metal-processing industry.

Beruclean 3050, the mildly alkaline, intensive special cleaner, permits effortless removal of industrial contamination and effective cleaning and care of industrial floors, motors, vehicles and machinery. It can be used on concrete, sealed- and coated floors or on even floor surfaces such as slabs, tiles and plastic. High solubility makes Beruclean 3050 particularly suitable for cleaning organic deposits such as oils, greases, waxes and tars while protecting surfaces. Beruclean 3050 will not attack surfaces of aluminum, cast iron or steel and is neutral on varnishes, rubber seals, plastics and textiles.

Beruclean 3050 was developed especially for scrubbing machines, high pressure- and steam jet devices and manual cleaning procedures. The contents conserve resources and a low-consumption formulation ensures maximum cost effectiveness and excellent cleaning results.

Beruclean 3050 is very good for the residue-free cleaning and care of sealed and coated floors.

BECHEM scientific network

Thanks to intensive R & D work, as well as the participation in various international and national research projects, BECHEM has successfully tailored their high-performance lubricants to the corresponding application. Modern test equipment and control benches allow the optimal selection of the suitable lubricant already during the early stage of development. BECHEM finds the right solution which contributes to our customers’ success.

Awarded

High-quality lubricants are indispensable products that are worth their investment. They have received prestigious awards – by making a decisive contribution to performance, energy efficiency and sustainability of products and processes.

BECHEM wins the award for innovative lifetime lubrication of various vehicle components.

BECHEM as an award-winner is one of the 20 most innovative companies in North Rhine-Westphalia.

BECHEM wins award for tailored solutions in the premium vehicle sector.

Beruclean 3050 – Machine and floor cleaning agent

For all surfaces and all applications.

Innovation drives sustainability.
BECHEM – the brand for high performance lubricants

BECHEM stands for outstanding high performance lubricants developed in collaboration with leading machinery manufacturers and technical colleges. We move solutions along and develop tomorrow’s products sustainably and compatible with standards. They safeguard people, machinery and resources and additionally go far beyond the REACH requirements, the VSI specifications, and the VDI 3035 and VDI 3397 guidelines. Many products for the metal processing industry have skin assessments and a number of medical approvals.

As one of the leading companies in lubricant technology, we contribute significantly to the success of our customers. We consider ourselves a development partner in industry and problem solvers in questions related to lubrication technology in the most varied markets. Our high level of competence in tailored, innovative ideas leads our tribology specialists to develop pioneering innovations such as, for example, Berufliud cooling lubricant, which has been distinguished with the Deutscher Rohstoff Effizienz Preis (German Raw Material Efficiency Prize).

Our water-based, mineral oil-free Berufliud cooling lubricants have led to a completely new cooling lubricant category in addition to the conventional water miscible and non-water miscible metal processing media, making more sustainable and energy efficient manufacturing possible and providing answers to raw material questions of the future, even today.

» Everything from one source. «

Development expertise and service

At the BECHEM technical center, the latest chemical-physical testing and analysis systems are available that are used to characterize lubricants, to monitor their application, to analyze customer problems and finally to develop the appropriate lubricant solutions. Cutting-edge opportunities for testing can simulate the most varied conditions under which lubricants are used around the world.

In many applications and components, lubricants and lubrication systems are a critical feature in development, and cannot be considered separate from the respective project. Product success hinges on lubricants tailored to the requirements profile. Powerful analysis is crucial here.

The BECHEM service department ensures continuous improvement of processes:
- Inventory/analysis on site
- Analysis at the BECHEM technical center
- Development of tailored system solutions
- Extensive tests in the work process
- Process-oriented technical support
- Optimized service life
- Improved working conditions for users
- Full fluid management

The performance capacity of the products used, and competent technical service, are crucial inputs to guarantee each industrial challenge is met with sufficient proficiency to create success stories. BECHEM has the necessary expertise to provide individual consultation to users and to assess the effectiveness of system solutions.
Lubrication solutions for industry