



TECHNICAL DATA (R256)

MACHINING & CUTTING FLUID OIL

(FLUIDCUT XP)

Description

Without warranty. Fluidcut XP is a high oil content water emulsifiable cutting and grinding fluid. It is triazene free and contains medium chain chloroparaffins to provide excellent cutting performance. Fluidcut XP is suitable for machining a wide variety of materials including cast iron, aluminium, mild steels, stainless steels and other steel alloys.

APPLICATIONS

Turning, milling, drilling, threading, boring, deep-hole drilling and reaming, creep feed grinding.

COMPATIBILITY

Suitable for a wide variety of water qualities

With hardness values typically between 50 and 450 ppm

Fluidcut XP has a very low foaming tendency.

Technical Data

<u>Concentrate</u>	
Appearance	Amber Liquid
Specific Gravity	1.02
Mineral Oil Content %	50
<u>Emulsion</u>	
Appearance	White
pH at 3%	9.3
IP 287 Corrosion Test %	2.0
De foam ml(3% in 50ppm water)	Nil(15 secs)
Refractometer: Factor	1.0

STORAGE

The product should be stored under cover and protected from extreme temperatures(above 0°C and below 40°C). Avoid water collecting in the rim of upturned barrels.

SHELF LIFE

Fluidcut XP has a shelf life of six months from the date of supply.

MIXING .

We advise the use of automated mixing systems. If the fluid is to be mixed manually, always add the concentrate to the water with maximum agitation. The emulsion strength should always be checked using a calibrated refractometer.