

# GRINDING FLUID



A water-mix metal lathe cutting fluid, free from phenol, nitride and chlorine. Mixed with water to give a milky colour, the fluid can be applied to several types of metalwork, and is especially suitable for the cutting and surface polishing of iron and other metals. Excellent in preventing corrosion, the fluid mixes with water without separating. It also contains agents to halt the growth of bacteria and the formation of foam, leading to minimal formation of foam in the system.

## Usage of Grinding Fluid

- Suitable for general tools - can be used for the polishing of steel and other metals
- Helps prolong the working life of tools and improve the quality of the surface of the work
- Helps maintain the cleanliness of machinery in the vicinity of usage
- Polishing 3-4%
- Medium duty machinery 5-6%
- Heavy duty machinery 5-10%

## Special characteristics of Grinding Fluid

Properties	Grinding Fluid
Appearance	Clear, Light Amber
Specific Gravity @ 30°C	0.88
Spontaneity	Good
Copper Corrosion Test, D-130	1a
Emulsion, IP 263 (at 5% in 350 ppm. as CaCO <sub>3</sub> Water) (ml. oil/ ml. cream)	Nil/Nil
pH (100 ppm. Water (CaCO <sub>3</sub> ))	
- 5% Dilution	9.3
- 10% Dilution	9
Foaming (ml.) (50 ml. sahken for 15S, 20:1) (100 ppm. Water CaCO <sub>3</sub> )	
- Initial	10.0
- After 30 Sec.	2

Packages: 200 litres and 18 litres

# SYNTHETIC CUT SPEED G



Synthetic Cut Speed G is an oil and nitrile-free chemical grinding coolant that provides excellent rust protection with iron cast. It may be highly diluted with water while still providing protection to freshly ground surface.

## Special characteristics of Synthetic Cut Speed G

The General Characteristics	Synthetic Cut Speed G
Appearance, Neat	Clear, Liquid
Specific Gravity @ 30°C	1.1
Water Solubility	Complete
Cast Iron Test, IP 287	3% Pass
pH (100 ppm. Water (CaCO <sub>3</sub> ))	
2%	9.3
5%	9.6
pH Neat	10.5
Refractometer Index	2.2
Foaming (ml.) (50 ml. shaken for 15S. 20:1)(100 ppm Water CaCO <sub>3</sub> )	
Initial	5
after 30 sec.	0

Packages : 18 litre, 200 litre