



TECHNICAL DATA

ULTRACUT 250 Plus

General Purpose Long Life Cutting Fluid

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Description

ROCOL ULTRACUT 250 *Plus* is a high quality soluble oil water mix cutting fluid formulated to give a long and predictable sump life. It is designed for light/medium cutting operations on ferrous and non-ferrous metals. It contains a high percentage of refined mineral oils affording a high degree of residual corrosion protection and lubricity whilst machining.

Outstanding Features

- Long and predictable sump life
- Suitable for use with a wide range of ferrous and non-ferrous metals
- Excellent residual corrosion protection
- Good cutting performance
- Inherently resistant to degradation
- Low foaming
- Rejects tramp oil
- Ideal for individual and central cutting fluid systems
- Pleasant and safe to use

Directions for use

Recommended dilution: ROCOL Ultracut 250 *Plus* should be used between 20:1 and 40:1 depending on the severity of the operation, workpiece material and water hardness. To ensure dilution accuracy, it is preferable to use a ROCOL Automatic Fluid Mixer. For manual mixing, add the concentrate to water at the recommended dilution ratio, stirring continuously.

It is advisable to use the appropriate ROCOL Ultraguard Machine Tool Care product at fluid changeovers. Optimum fluid life is obtained by adequate initial machine cleaning, correct dilution control and regular maintenance of fluid, particularly prior to weekends and shutdown periods.

ROCOL Lubricants

ROCOL House, Swillington, Leeds LS26 8BS, England.

Tel: 0113 232 2600 Fax: 0113 232 2760

ROCOL is a BS EN ISO 9001 registered company.

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The information in this publication is based on our experience and reports from customers. There are many factors outside our control and knowledge which effect the use and performance of our products for which reason the information in this publication is given without responsibility

Technical Data (typical values)

<i>Appearance:</i>	<i>Clear amber liquid forming a white emulsion when mixed with water</i>
<i>Odour:</i>	<i>Mild</i>
<i>pH:</i>	<i>9.4 at 25:1</i>
<i>Density at 20°C:</i>	<i>0.93 g/cm³</i>
<i>Storage:</i>	<i>Store at normal ambient temperature (5 to 30°C)</i>

Refractometer calibration:

Dilution ratio	10:1	20:1	30:1	40:1	50:1
Refractometer reading	8.6	5.1	3.3	2.7	2.1

Pack sizes and part codes

5 ltr	part code 51366
20 ltr	part code 51363
60 ltr	part code 51362
200 ltr	part code 51369
1000 ltr	part code 51365

Health and Safety

Safety data sheet is available from the Customer Service Department, ROCOL Lubricants., ROCOL House, Swillington, Leeds, LS26 8BS, England.

Telephone: 0113 232 2700, (When calling from outside UK: 44 113 232 2700).

Fax: 0113 232 2760, (When faxing from outside UK: 44 113 232 2760).

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