



TECHNICAL DATA
ULTRACUT 255 HW
Hard Water Stable Extreme Pressure
Long Life Cutting Fluid

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Description

ROCOL Ultracut 255 HW is an extreme pressure medium duty soluble oil water mix cutting fluid, formulated to provide a long and predictable sump life in hard water conditions (above 250ppm). It provides extra performance in medium/severe cutting operations on a wide range of ferrous and non-ferrous metals. The combination of extreme pressure performance and long sump life permits increased machining rates and true cost efficiency.

Outstanding Features

- **Emulsion stability in all normal and hard water conditions**
- **Extends tool life**
- **Promotes good surface finish**
- **Increases production rates**
- **Suitable for medium/severe cutting applications**
- **Suitable for use with most ferrous and non-ferrous metals**
- **Excellent residual corrosion protection**
- **Long and predictable sump life**
- **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 255 HW should be used between 15:1 and 35:1 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.

ROCOL Lubricants

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

Tel: 0113 232 2600 Fax: 0113 232 2760

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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

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.

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>0.95 g/cm³</i>
<i>Storage:</i>	<i>Store at normal ambient temperature (5 to 30°C)</i>

Refractometer calibration:

Dilution ratio	10:1	15:1	20:1	25:1	30:1	35:1	40:1
Refractometer reading	9.9	6.5	6.0	4.0	3.7	2.9	2.8

Pack sizes and part codes

20 ltr	part code 51473
200 ltr	part code 51479

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).

Issue: Ultracut 255HW TDS 5147
Date: Jan-04

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