



TECHNICAL DATA
ULTRACUT 280A HW
Hard Water Stable High Performance
Long Life Cutting Fluid for Aluminium

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Description

ROCOL Ultracut 280A HW is a high performance soluble oil water mix cutting fluid for aluminium, formulated to give a long and predictable sump life in hard water conditions (above 250ppm). It provides extra performance in medium and severe cutting operations when machining aluminium and its alloys, whilst promoting optimum surface finish, with almost no risk of staining most sensitive aerospace and industrial alloys. ROCOL ULTRACUT 280A HW can also be used to machine other non ferrous metals, for example, copper and its alloys and all but the most difficult to machine ferrous metals.

Outstanding Features

- **Emulsion stability in all normal and hard water conditions**
- **Gives optimum cutting performance on aluminium and its alloys**
- **Prevents built-up edge**
- **Extends tool life**
- **Promotes excellent surface finish**
- **Non-staining with most aerospace and industrial alloys**
- **Excellent residual corrosion protection**
- **Inherently resistant to degradation**
- **Long and predictable sump life**
- **Low foaming**
- **Rejects tramp oil**
- **Ideal for individual and central cutting fluid systems**
- **Pleasant and safe to use**

ROCOL Lubricants

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

Tel: 0113 232 2600 Fax: 0113 232 2760

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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

Directions for use

Recommended dilution: ROCOL Ultracut 280A Plus should be used between 15:1 and 25:1 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.

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>9.0 at 20:1</i>
<i>Density at 20°C:</i>	<i>0.94 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
Refractometer reading	9.4	6.1	4.9	3.8	3.3

Pack sizes and part codes

20 ltr	part code 51493
200 ltr	part code 51499
1000 ltr	part code 51495

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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