



TECHNICAL DATA
ULTRACUT 320
Extreme Pressure Long Life
Semi-Synthetic Cutting Fluid

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Description

ROCOL ULTRACUT 320 is an extreme pressure semi-synthetic water mix cutting fluid formulated to give a long and predictable sump life. 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.

ROCOL ULTRACUT 320 can be used as a grinding fluid enabling the user to rationalise to one fluid for both cutting and grinding operations.

Outstanding Features

- Extends tool life
- Promotes excellent surface finish
- Suitable for cutting and grinding operations
- Suitable for medium/severe cutting operations
- Long and predictable sump life
- Inherently resistant to degradation
- Suitable for use with a wide range of ferrous and non-ferrous metals
- Inhibits corrosion and staining
- Resists foaming
- Emulsifies tramp oil
- Translucent emulsion gives good view of work piece
- Pleasant and safe to use

Directions for use

Recommended dilution: ROCOL Ultracut 320 should be used between 20:1 and 40:1 for cutting and between 40:1 and 60:1 for grinding, depending on the severity of operation, workpiece material and water hardness. To ensure dilution accuracy, it is preferable to use a ROCOL Automatic Fluid Mixer.

ROCOL Lubricants

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

Tel: 0113 232 2600 Fax: 0113 232 2760

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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>Dark blue concentrate forming a translucent blue emulsion</i>
<i>Odour:</i>	<i>Mild</i>
<i>pH:</i>	<i>9.3 at 15:1</i>
<i>Density at 20°C:</i>	<i>1.02 g/cm³</i>
<i>Storage:</i>	<i>Store at normal ambient temperature (5°C to 30°C)</i>

Refractometer calibration:

Dilution ratio	10:1	20:1	30:1	40:1	50:1	60:1	70:1
Refractometer reading	8.6	4.6	2.9	2.4	1.8	1.5	1.3

Pack sizes and part codes

20 ltr	part code 51323
200 ltr	part code 51329

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 320 TDS 5132
Date: Jan-04

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