



TECHNICAL DATA

ULTRACUT 390H

General Purpose Semi-Synthetic Cutting Fluid

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Description

ROCOL Ultracut 390H is a high quality, semi-synthetic general purpose water mix cutting fluid formulated to provide a long and predictable sump life. It is designed for medium duty cutting operations on a wide range of ferrous and non-ferrous metals. It contains refined mineral oils and has a unique corrosion inhibition package. ROCOL Ultracut 390H is low foaming and emulsifies tramp oil. It forms a translucent fluorescent green micro-emulsion when mixed with water which provides a clear view of the workpiece.

Outstanding Features

- Long and predictable sump life
- Compatible with hard and soft water
- Extends tool life
- Inherently resistant to degradation
- Suitable for a wide range of materials
- Emulsifies tramp oil
- Low foaming
- Pleasant and safe to use

Directions for use

Recommended dilution: ROCOL Ultracut 390H should be used between 30:1 and 40:1 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. 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>Green concentrate forming a translucent green 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>1.00 g/cm³</i>
<i>Storage:</i>	<i>Store at normal ambient temperature (5°C to 30°C)</i>

Refractometer calibration:

Dilution ratio	25:1	30:1	35:1	40:1	45:1
Refractometer reading	4.1	3.0	2.8	2.4	2.2

Pack sizes and part codes

5 ltr	part code 51296
20 ltr	part code 51293
60 ltr	part code 51294
200 ltr	part code 51299
1000 ltr	part code 51295

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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