



TECHNICAL DATA  
**ULTRACUT 610**  
Extreme Pressure Long Life  
Chlorine Free Semi-Synthetic Cutting Fluid

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### Description

ROCOL ULTRACUT 610 is an extreme pressure, semi-synthetic water mix cutting fluid specially formulated to give optimum tool life and a long predictable sump life. It is designed to give superior performance in severe cutting operations on a wide range of ferrous and non-ferrous metals including difficult to machine alloys. The combination of outstanding extreme pressure performance and long sump life permits increased machining rates and maximum cost efficiency.

### Outstanding Features

- Optimum tool life
- Promotes excellent surface finish
- Increases production rates
- Suitable for severe machining applications
- Suitable for use with most metals
- Inherently resistant to degradation
- Long and predictable sump life
- Low foaming
- Ideal for individual and central cutting fluid systems
- No chlorinated additives
- Pleasant and safe to use

### Directions for use

**Recommended dilution:** ROCOL ULTRACUT 610 should be used between 20:1 and 30:1 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.

### 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>Amber concentrate forming a semi-translucent emulsion</i>
<i>Odour:</i>	<i>Mild</i>
<i>pH:</i>	<i>9.0 at 25:1</i>
<i>Density at 20°C:</i>	<i>0.98 g/cm<sup>3</sup></i>
<i>Storage:</i>	<i>Store at normal ambient temperature (5°C to 30°C)</i>

### Refractometer calibration:

<b>Dilution ratio</b>	<b>15:1</b>	<b>20:1</b>	<b>25:1</b>	<b>30:1</b>	<b>35:1</b>
<b>Refractometer reading</b>	<b>6.0</b>	<b>4.6</b>	<b>3.8</b>	<b>3.2</b>	<b>2.8</b>

### Pack sizes and part codes

200 ltr      part code 51919

### 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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