

PARACUT 1504

DESCRIPTION

PARACUT 1504 is an economical, water soluble, semi-synthetic chemical cutting & grinding fluid concentrate which is designed to provide proper lubrication and cooling, as well as in-process rust protection for parts and machinery. It is a medium service product that will perform well in many applications. PARACUT 1504 mixes easily with water and provides a mild working solution for the operator.

FEATURES

- Extremely versatile -- can be used on all types of steel and other metals.
- Increased tool life and production with superior finishes and closer tolerances.
- Higher cooling capacity for high heat conditions. *Will not smoke.*
- Prevents rust and keeps machines and work areas clean.
- Can be used in central systems as well as individual machines.

PHYSICAL PROPERTIES

Form:	<i>Liquid</i>	Fire point:	<i>Noncombustible</i>
Appearance:	<i>Light amber</i>	Viscosity:	<i>179 SUS @ 68° F</i>
Specific gravity:	<i>1.016</i>	Residue:	<i>Non visible fluid</i>
Solubility in water:	<i>100%</i>	pH @ 5% solution:	<i>9.05</i>
Flash point:	<i>None</i>	Pour point:	<i>30° F</i>
Odor:	<i>Mild</i>		

RECOMMENDED STARTING CONCENTRATIONS

Turning, boring, milling, & drilling:	30 to	32-1 REF. READING:	40:1
Grinding O.D., I.D., centerless, surface:	25:1		
Aluminum operations (all):	25 to 40:1		
Tube mills:	15 to 20:1		
		3%	1.0
		5%	2.0
		7%	2.6
		10%	3.2

COMPATIBLE MATERIALS

Stainless steel Alloy steels Cast iron Aluminum Copper alloys

STORAGE AND HANDLING

Use at room temperature. If frozen, allow to thaw for several days before use. Do not expose to extreme high temperature due to possible drum rupture. Do not pressurize drum or reuse empty container.