

PARACUT 4518

DESCRIPTION

PARACUT 4518 synthetic cutting and grinding fluid concentrate contains no nitrites or phenols. Its oil rejecting property makes for easy removal of tramp oil from machine tool sumps or central systems. PARACUT 4518 is well suited for cast iron machining or grinding due to the superior rust protection of the work piece and equipment, but is safe for soft alloys of aluminum and copper. PARACUT 4518 provides cleanliness to the operation, remains clear and clean in use, and leaves a soft fluid residue to protect the finished part.

FEATURES

- Nitrite and phenol FREE
- Rejects oil
- Superior rust protection
- Excellent settling properties
- Soft fluid film residue
- Safe on both ferrous and nonferrous metals

PHYSICAL PROPERTIES

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|------------------------|----------------------|-------------------|------------------------|
| • Form: | <i>Liquid</i> | Fire point: | <i>Noncombustible</i> |
| • Appearance: | <i>Golden yellow</i> | Viscosity: | <i>Same as water</i> |
| • Specific gravity: | <i>1.07</i> | Residue: | <i>Soft fluid film</i> |
| • Solubility in water: | <i>100%</i> | pH @ 5% solution: | <i>8.34</i> |
| • Flash point: | <i>None</i> | Odor: | <i>Mild</i> |
| • Pour point: | <i>30° F</i> | | |

RECOMMENDED USAGE CONCENTRATIONS

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|-------------------------------------|----------|----------------|
| • Milling, drilling, & turning: | 3 - 5% | (30:1 to 20:1) |
| • Centerless and internal grinding: | 2.5 - 5% | (40:1 to 20:1) |
| • Cylindrical and surface grinding: | 2.5 - 5% | (40:1 to 20:1) |

COMPATIBLE MATERIALS

Plain carbon steels, Alloy steels, Cast steels, Stainless steels, All cast irons, Aluminum alloys, Copper and brass alloys

STORAGE AND HANDLING

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