

PARACUT 4510

DESCRIPTION

PARACUT 4510 synthetic grinding coolant concentrate is a non-oil containing, high corrosion inhibiting, high heat removal fluid. It is specifically designed for grinding high carbon content cast irons and plain carbon steels. PARACUT 4510 forms a transparent solution that remains clear even in moderately hard water for good visual control of the operation. PARACUT 4510 is formulated with detergency to settle graphite and grinding debris rapidly and to keep the swarf from clinking in the sump.

FEATURES

- No oil content
- High heat removal
- Superior corrosion protection
- Settles graphite and swarf rapidly
- No hard residue

PHYSICAL PROPERTIES

Form:	<i>Liquid</i>	Fire point:	<i>Noncombustible</i>
Appearance:	<i>Clear amber</i>	Viscosity:	<i>Same as water</i>
Specific gravity:	<i>1.02</i>	Residue:	<i>Non visible fluid</i>
Solubility in water:	<i>100%</i>	pH @ 5% solution:	<i>9.5</i>
Flash point:	<i>None</i>	Odor:	<i>Mild</i>
Pour point:	<i>30° F</i>		

RECOMMENDED STARTING CONCENTRATIONS

Surface grinding:	3.5% (30:1)
Centerless, cylindrical:	2.5% (40:1)

32-1 REF. READING:

3 %	1.2
5%	2.0
7%	2.6
10%	3.8

COMPATIBLE MATERIALS

- Plain carbon steels
- Grey cast irons
- Ductile cast irons
- Nodular cast irons

STORAGE AND HANDLING

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