

PARACUT 4510-COB

DESCRIPTION

PARACUT 4510-COB synthetic cutting & grinding fluid that has inhibitors it to prevent Cobalt leaching as its main feature. PARACUT 4510-COB is mainly designed as cobalt grinding fluid, however, is well suited for cast iron machining or grinding. It readily rejects tramp oil & makes tramp oil removal from single machines or central systems easy. Provides superior rust protection and cleanliness to the operation and remains clear and clean in use and leaves a soft fluid residue.

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)
Carbide Grinding	

32-1 REF. READING:

3 %	1.2
5%	2.0
7%	2.6
10%	4.0

COMPATIBLE MATERIALS

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

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.