

# ***PARACUT 2400***

## **DESCRIPTION**

**PARACUT 2400 premium grade, general purpose soluble oil, was developed for wide range versatility where soluble oil is preferred. PARACUT 2400 can be used on ferrous and nonferrous metals because of its unique combination and balance of carefully selected additives, highest quality base oil, and emulsifiers. It can be used on critical aircraft parts machining where chlorine and sulfur cannot be used.**

## **FEATURES**

- **Highly recommended for aluminum, brass, copper, and stainless steels**
- **Promotes finer finishes**
- **Prevents chip welding -- prolongs tool service life**
- **Fluid residue prohibits sticky surfaces and is easily re-emulsified**
- **Used in central systems, individual machine sumps, and mist applications**
- **Stable emulsions -- will not separate when left standing**

## **PHYSICAL PROPERTIES**

<b>Form:</b>	<i>Liquid</i>	<b>Fire point:</b>	<i>343 ° F (COC)</i>
<b>Appearance:</b>	<i>Amber</i>	<b>Viscosity:</b>	<i>277 SUS @ 100 ° F</i>
<b>Specific gravity:</b>	<i>0.95</i>	<b>Residue:</b>	<i>Resoluble fluid</i>
<b>Solubility in water:</b>	<i>100%</i>	<b>pH @ 5% solution:</b>	<i>8.9</i>
<b>Flash point:</b>	<i>320 ° F (COC)</i>	<b>pH @ 10% solution:</b>	<i>9.0</i>
<b>Pour point:</b>	<i>-20 ° F</i>	<b>Odor:</b>	<i>Mild</i>

## **RECOMMENDED STARTING CONCENTRATIONS**

**Sawing, broaching:10%(10:1 dilution)**

**Turning, boring:4%(25:1 dilution)**

**Milling, drilling centerless I.D., O.D:3%(33:1 dilution)**

**Surface grinding aluminum alloys:5%(20:1 dilution)**

## **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.**