



Product Bulletin

Gulf CUT SOLUBLE SS-MG

High performance, semi-synthetic metalworking coolant

Gulf CUT Soluble SS-MG is an advanced, high-performance semi-synthetic coolant formulated with the right balance between lubricity and cooling. **Gulf CUT Soluble SS-MG** is designed for most machining and grinding operations on both ferrous and non-ferrous metals. It contains synthetic lubricity and anti-weld additives that helps to reduce the friction between the cutting tool and the work-piece interface.

RECOMMENDED USES:

Gulf CUT Soluble SS-MG has been developed as a versatile “*all purpose*” coolant that can work in a broad range of applications and metal alloys. It is the perfect coolant to consider for plants wanting to find one product to meet the challenges of the entire facility.

FEATURES AND BENEFITS:

- Low foam
- Multi-metal compatibility
- Excellent tramp oil rejection
- Contains no chlorine or sulfur
- Excellent sump life
- Clean running on cast iron
- Superior corrosion protection
- Bio-Stable to ensure longevity of use

TYPICAL PROPERTIES – Gulf CUT Soluble SS-MG

- **Product Code** **335198**
- Appearance, Concentrate Amber Fluid
- Dilution (5% in DI water) Semi-Translucent
- Density: 8.16 Lbs/Gal
- Viscosity cSt @ 40°C: 120.0
- pH @ 10% concentration 9.3 ± 0.2
- Specific Gravity: 0.98
- Cast Iron Chip Test 20:1 dilution Pass – No Rust
- **Refractometer Factor** **2.25**

* The above typical properties are subject to manufacturing tolerances.

Gulf CUT Soluble SS-MG: Recommended Starting Concentrations¹

Machining Operation	Aluminum Alloys ² , Non-Ferrous, Soft Metals	Carbon Steel, Cast Irons and Nickel Alloys	Tool Steels, “Monel” Metals	Titanium Alloys, High Alloys, Stainless Steels
Grinding	3% - 6%	5% - 8%	5% - 6%	5% - 6%
CNC Machining	5% - 8%	5% - 8%	5% - 8%	5% - 8%
Turning, Milling, Forming, Drilling, Sawing	5% - 8%	5% - 8%	5% - 10%	8% - 10%
Tapping, Reaming, Boring, Broaching, Form Milling	6% - 10%	6% - 10%	8% - 12%	8% - 12%

Notes: (1) Concentrations are approximate and may require higher or lower water concentrations depending on severity of the operation, type of metal being machined, water hardness and machine speed.

(2) Gulf CUT Soluble SS-MG might stain some sensitive aluminum alloys.

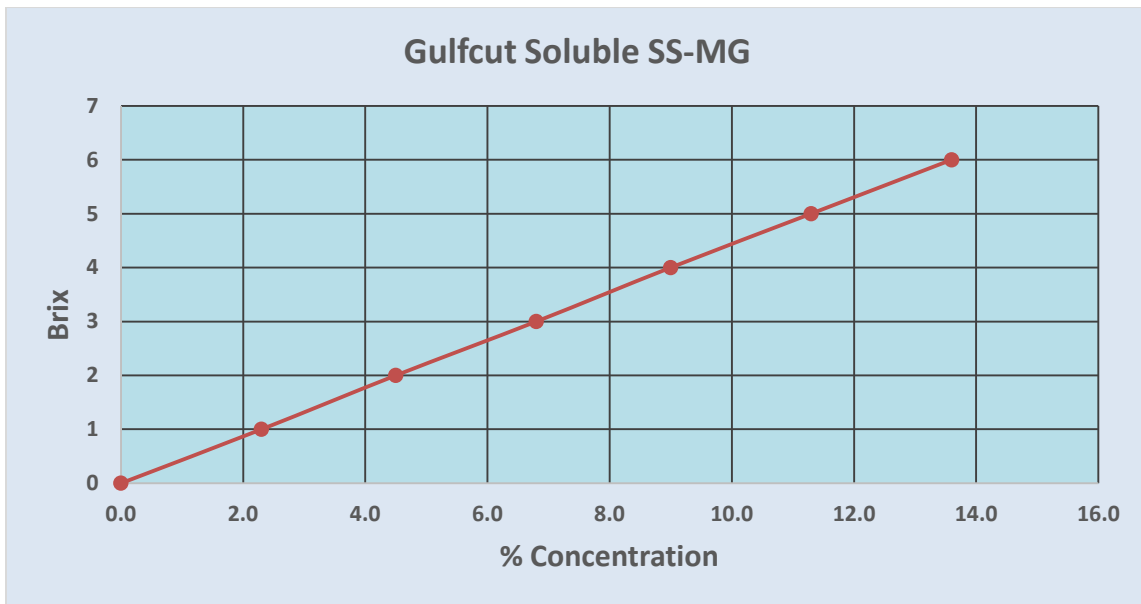
Monitor concentration by using a refractometer.

Refractometer Reading	% Concentration
1.0	2.3
2.0	4.5
3.0	6.8
4.0	9.0
5.0	11.3

Refractometer Factor = 2.25

Suggested Operating Dilutions:

Type of Use	% Concentration
Light Duty	3-5
Moderate Duty	5-9
Heavy Duty	7-10
Very Heavy Duty	9-12



Concentration (%) = Refractive index reading (brix reading) X 2.25

PRODUCT MAINTENANCE:

When mixing, always premix coolant before adding to the machine sump • **Never** add straight water or straight concentrate directly to the machine’s sump.

STORAGE AND HANDLING: Containers of **Gulfcut® Soluble SS-MG** should be stored indoors. Never store fluid at temperatures below 40°F (4°C) or above 125° (52°C). If frozen, product may separate. Thaw and stir thoroughly until fluid reaches room temperature.

AVAILABILITY: **Gulfcut® Soluble SS-MG** is available throughout Gulf’s marketing area. Your Gulf representative can provide specific information. Need additional information? Call Gulf @ 1-800-566-Gulf (4853) or visit Nu-tierbrands.com