



# Product Bulletin

## GULFCUT® AL-XP SA

Gulfcut® AL-XP SA is a medium-to-heavy duty biostatic soluble oil. This product was designed to be extended with water for the machining and grinding of virtually all metals except magnesium. This chlorine-free formulation is especially suited for aerospace and other applications which restrict the use of chlorine. Gulfcut® AL-XP SA has exceptional foam control for high pressure operations and was designed using raw materials that have the ability to resist extreme biological degradation, thus providing very long sump life in a properly maintained machine tool. Gulfcut® AL-XP SA is designed for use in metalworking applications such as all CNC milling, turning, drilling, tapping, grinding and sawing applications

### FEATURES AND BENEFITS:

- Eliminates need for tank-side additives
- Excellent corrosion inhibition
- Outstanding lubricity for superior finishes
- Mild odor
- Exceptional hard water stability
- Operator friendly and clean running

Typical Properties	
Product Code	335355
Appearance – concentrate	Amber Liquid
Appearance – dilution	Opaque Amber
Odor	Mild
Residual Film	Soft, Fluid
pH @ 20:1 (5%)	9.5 ± 0.2
Specific Gravity @ 60°F	0.95 ± 0.03
Lbs/Gallon	8.0 ± 0.1
Flash Point, COC, °F	355
Total Chlorine, wt %	None

Recommended Concentrations			
Application	Concentration, %	Ratio	Refractometer
Grinding	4%	1:25	4.2
General Machining	7%	1:14	7.4
Tapping, Drilling, Reaming	10%	1:10	10.6

MIXING INSTRUCTIONS							
Concentration, %	4%	5%	6%	7%	8%	9%	10%
Ratio	1:25	1:20	1:17	1:14	1:12	1:11	1:10
Refractometer	4.2	5.3	6.4	7.4	8.5	9.5	10.6

\*When mixing coolant, it is best to use an automatic proportioner which accurately and thoroughly mixes coolant. To maintain recommended concentration, make-up or top-off should be added at one-half of the desired concentration. **Never add concentration** directly to the machine; this could cause invert emulsions.

### AVAILABILITY:

Gulfcut® AL-XP SA 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](http://Nu-tierbrands.com).