



# Product Bulletin

## GULFCUT<sup>®</sup> SOLUBLE HD-NC

*High performance machining & grinding fluid*

**Gulfcut<sup>®</sup> Soluble HD-NC** is a medium-to-heavy duty chlorine-free metalworking fluid with high lubricity. It is formulated to emulsify easily and form a stable, milky emulsion when mixed with water. This product is recommended for machining most Aerospace grade aluminum alloys as well as a wide range of ferrous alloys.

**Gulfcut<sup>®</sup> Soluble HD-NC Soluble** may be used on most metals except magnesium. It has very low foaming tendency, which is an advantage in high-speed and high-pressure applications. It is suitable for use in many types of machining processes including turning, boring, CNC milling, tapping, threading, and sawing. It also works well in various grinding applications.

### FEATURES AND BENEFITS:

- Can replace straight oils in most operations
- Excellent corrosion inhibition
- Better cooling than straight oils
- Improves tool life and surface finish
- Operator friendly
- Reduces disposal costs

### Typical Properties

Product Code	Test Method	335196
Appearance – concentrate		Amber Liquid
Appearance – dilution		Milky Liquid
pH @ 20:1 (5%)		9.8 ± 0.3
Viscosity cSt @ 40°C	ASTM D445	74.0
Viscosity cSt @ 100°C	ASTM D445	9.2
Specific Gravity @ 60°F		.94 ± 0.01
Lbs/Gallon		7.82 ± 0.1
Flash Point, COC, °F		320
Total Chlorine, wt %		Nil

<b>Concentration:</b>	3% (33:1)	4% (25:1)	5% (20:1)	6% (17:1)	7% (14:1)	8% (12:1)	10% (10:1)
<b>Refractometer Reading:</b>	3.0	4.0	5.0	6.0	7.0	8.0	10.0
<b>Recommended Starting Dilutions:</b>	Milling, Drilling, Turning	20:1 (5%)					
	Centerless, ID, OD, Surface Grinding	33:1 (3%)					
	Tapping, Reaming, Sawing	10:1 (10%)					

When mixing coolant, it is best to use an automatic proportioner which accurately and thoroughly mixes coolant. **Always** replenish the coolant with a mixture of coolant and water, not just coolant or water. **Never** add coolant concentrate directly to the sump. **Storage**, containers of **Soluble HD-NC** should be stored indoors. Do not store in temperatures below 40°F.

### AVAILABILITY:

**Gulfcut<sup>®</sup> Soluble HD-NC** 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).