GULFCUT® SOLUBLE HD

Gulfcut® Soluble HD is a heavy duty water extendable sulfur-chlorinated metalworking coolant formulated to offer outstanding performance in difficult machining and grinding operations involving hard-to-work metals such as stainless steel, tool steels, and high nickel alloys.

Gulfcut® Soluble HD may be used on all metals except magnesium, copper and some bronze alloys, which may be stained. It will perform as well as straight oil in most applications. It is suitable for use in all types of machining processes including turning, milling, tapping, reaming, broaching, hobbing, and sawing. It also works well in the various grinding processes, including centerless, cylindrical, surface, internal, belt and disc.

FEATURES AND BENEFITS:
- Can replace straight oils in most operations
- Excellent corrosion inhibition
- Better cooling than straight oils
- Increases tool life
- Excellent finish in machining and grinding operations
- More economical than straight oils

Typical Properties

<table>
<thead>
<tr>
<th>Product Code</th>
<th>Test Method</th>
<th>Appearance – concentrate</th>
<th>Appearance – dilution</th>
<th>pH @ 20:1 (5%)</th>
<th>Specific Gravity @ 60°F</th>
<th>Lbs/Gallon</th>
<th>Flash Point, PMCC, °F</th>
<th>Total Sulfur, wt %</th>
<th>Total Chlorine, wt %</th>
</tr>
</thead>
<tbody>
<tr>
<td>335195</td>
<td></td>
<td>Dark Brown Viscous Liquid</td>
<td>Tan Milky Liquid</td>
<td>9.5 ± 0.3</td>
<td>.96 ± 0.01</td>
<td>8.1 ± 0.1</td>
<td>None</td>
<td>2</td>
<td>6</td>
</tr>
</tbody>
</table>

Concentration: 3% (33:1) 4% (25:1) 5% (20:1) 6% (17:1) 7% (14:1) 8% (12:1) 9% (11:1) 10% (10:1)

Refractometer Reading: 3.0 4.0 5.0 6.0 7.0 8.0 9.0 10.0

Recommended Starting Dilutions:
- 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.

AVAILABILITY:

Gulfcut® Soluble HD 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.