



LUBRICANTS



Product Data Sheet

Gulfcut® Soluble HD

Heavy-duty, water extendible cutting and grinding fluid

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. May be used on all metals except magnesium, copper and some bronze alloys, which may be stained. It is suitable for use in most 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

- Better cooling than straight oils
- Can replace straight oils in most operations
- High lubricity to increase tool life
- Excellent corrosion inhibition

Applications

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%)

Typical Properties

Product Code	Test Method	335195
Appearance – concentrate		Dark Brown Viscous Liquid
Appearance – dilution		Tan Milky Liquid
pH @ 20:1 (5%)		9.5 ± 0.3
Specific Gravity @ 60°F		.96 ± 0.01
Flash Point, PMCC, °F, conc.		300
Total Sulfur, wt %		2
Total Chlorine, wt %		6

*Refractometer Factor = 1.0

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.

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