



LUBRICANTS



# Product Data Sheet

## Gulfcut® Soluble HD-NC

### Non-chlorinated, high performance machining and grinding fluid

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. 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

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

### Applications

<b>Concentration:</b>	3% (33:1)	4% (25:1)	5% (20:1)	6% (17:1)	7% (14:1)	8% (12:1)	9% (11:1)	10% (10:1)
<b>Refractometer Reading:</b>	3.0	4.0	5.0	6.0	7.0	8.0	9.0	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%)

### 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

\*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. **Storage**, containers of **Soluble HD-NC** should be stored indoors. Do not store in temperatures below 40°F.

Rev. 06/21



1-800-566-4853



Tulsa, OK 74133



www.nu-tierbrands.com

