



LUBRICANTS



Product Data Sheet

Gulfcut[®] Soluble SS-MG

High Performance, Semi-synthetic Metalworking Coolant

An advanced, high-performance semi-synthetic coolant formulated with the right balance between lubricity and cooling. Designed for most machining and grinding operations on both ferrous and non-ferrous metals. It contains synthetic lubricity and anti-weld additives that helps to reduce the friction between the cutting tool and the work-piece interface.

Features and Benefits

- Low foam
- Multi-metal compatibility
- Excellent tramp oil rejection
- Contains no chlorine or sulfur
- Excellent sump life
- Clean running on cast iron
- Superior corrosion protection
- Bio-Stable to ensure longevity of use

Applications

Developed as a versatile **“all purpose”** coolant that can work in a broad range of applications and metal alloys. It is the perfect coolant to consider for plants wanting to find one product to meet the challenges of the entire facility.

Typical Properties

Product Code	335198
Appearance, Concentration	Amber Fluid
Dilution (5% in DI water)	Semi-Translucent
Density:	8.16 lbs. / gal
Viscosity cSt @ 40°C	120.0
pH @ 10% concentration	9.3 ± 0.2
Specific Gravity	0.98
Cast Iron Chip Test 20:1 dilution	Pass -No Rust
Refractometer Factor	2.25

* The above typical properties are subject to manufacturing tolerances.



1-800-566-4853



Tulsa, OK 74133



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Gulfcut® Soluble SS-MG: Recommended Starting Concentrations¹

Machining Operation	Aluminum Alloys ² , Non-Ferrous, Soft Metals	Carbon Steel, Cast Irons and Nickel Alloys	Tool Steels, "Monel" Metals	Titanium Alloys, High Alloys, Stainless Steels
Grinding	3% - 6%	5% - 8%	5% - 6%	5% - 6%
CNC Machining	5% - 8%	5% - 8%	5% - 8%	5% - 8%
Turning, Milling, Forming, Drilling, Sawing	5% - 8%	5% - 8%	5% - 10%	8% - 10%
Tapping, Reaming, Boring, Broaching, Form Milling	6% - 10%	6% - 10%	8% - 12%	8% - 12%

Notes: (1) Concentrations are approximate and may require higher or lower water concentrations depending on severity of the operation, type of metal being machined, water hardness and machine speed.

(2) Gulfcut Soluble SS-MG might stain some sensitive aluminum alloys.

Monitor concentration by using a refractometer.

Refractometer Reading	% Concentration
1.0	2.3
2.0	4.5
3.0	6.8
4.0	9.0
5.0	11.3

Refractometer Factor = 2.25

Suggested Operating Dilutions:

Type of Use	% Concentration
Light Duty	3-5
Moderate Duty	5-9
Heavy Duty	7-10
Very Heavy Duty	9-12



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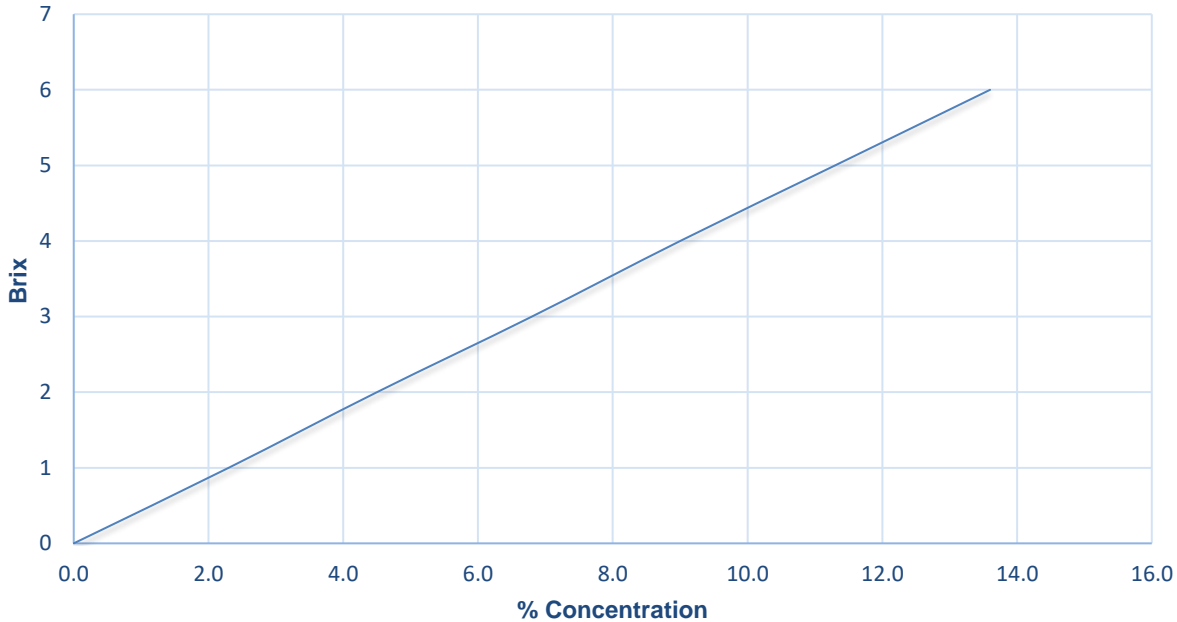


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Concentration (%) = Refractive index reading (brix reading) X 2.25

PRODUCT MAINTENANCE:

When mixing, always pre-mix coolant before adding to the machine sump • Never add straight water or straight concentrate directly to the machine's sump.

STORAGE AND HANDLING: Containers of Gulfcut® Soluble SS-MG should be stored indoors. Never store fluid at temperatures below 40°F (4°C) or above 125° (52°C). If frozen, product may separate. Thaw and stir thoroughly until fluid reaches room temperature.

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