



LUBRICANTS



Product Data Sheet

Gulfcut[®] AL-XP SA

Water extendible, non-chlorinated for ferrous metals and aluminum alloys

Medium-to-heavy duty biostatic soluble oil designed to be extended with water for the machining and grinding of virtually all metals except magnesium. This chlorine-free formulation is especially suited for aerospace and other applications which restrict the use of chlorine. This product has exceptional foam control for high pressure operations and was designed using raw materials that can resist extreme biological degradation, thus providing very long sump life in a properly maintained system. Formulated for use in metalworking applications such as CNC, milling, turning, drilling, tapping, grinding, and sawing applications.

Features and Benefits

- Eliminates need for tank-side additives
- Outstanding lubricity for superior finishes
- Exceptional hard water stability
- High lubricity to increase tool life
- Excellent corrosion inhibition
- Mild odor

Recommended Concentrations			
Application	Concentration, %	Ratio	Refractometer
Grinding	4%	1:25	4.2
General Machining	7%	1:14	7.4
Tapping, Drilling, Reaming	10%	1:10	10.6

Mixing Instructions							
Concentration, %	4%	5%	6%	7%	8%	9%	10%
Ratio	1:25	1:20	1:17	1:14	1:12	1:11	1:10
Refractometer	4.2	5.3	6.4	7.4	8.5	9.5	10.6

Typical Properties

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Product Code	335355
Appearance – concentrate	Amber Liquid
Appearance – dilution	Opaque Amber
Odor	Mild
Residual Film	Soft, Fluid
pH @ 20:1 (5%)	9.5 ± 0.2
Specific Gravity @ 60°F	0.95 ± 0.03
Lbs/Gallon	8.0 ± 0.1
Flash Point, COC, °F	355
Total Chlorine, wt %	None

When mixing coolant, it is best to use an automatic proportioner which accurately and thoroughly mixes coolant. To maintain recommended concentration, make-up or top-off should be added at one-half of the desired concentration. **Never add concentration directly to the machine; this could cause invert emulsions.*

Rev. 06/21



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