Technical Data

Performance you can trust

ULTRACUT® 390H

General Purpose Semi-Synthetic Cutting Fluid

ULTRACUT® 390H is a high quality, semi-synthetic general purpose water mix cutting fluid formulated to provide a long and predictable sump life. It is designed for medium duty cutting operations on a wide range of ferrous and non-ferrous metals. It contains refined mineral oils and has a unique corrosion inhibition package. ULTRACUT® 390H is low foaming and emulsifies tramp oil. It forms a translucent fluorescent green micro-emulsion when mixed with water which provides a clear view of the workpiece.

Features

- Long and predictable sump life.
- Compatible with hard and soft water.
- Extends tool life.
- Inherently resistant to degradation.
- Suitable for a wide range of materials.
- Emulsifies tramp oil.
- Low foaming.
- Pleasant and safe to use.

Directions for Use

Recommended dilution: ULTRACUT® 390H should be used between 30:1 and 40:1 depending on the severity of operation, workpiece material and water hardness. To ensure dilution accuracy, it is preferable to use a ROCOL® Automatic Fluid Mixer. For manual mixing, add the concentrate to water at the recommended dilution ratio, stirring continuously.

It is advisable to use the appropriate ROCOL® ULTRAGUARD® Machine Tool Care product at fluid changeovers. Optimum fluid life is obtained by adequate initial machine cleaning, correct dilution control and regular maintenance of fluid, particularly prior to weekends and shutdown periods.

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ROCOL A division of ITW Ltd

BS EN ISO 9001 Certificate No. FM 12448
BS EN ISO 14001 Certificate No. EMS 67596
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Appearance	Green concentrate forming a translucent green emulsion
Odour	Mild
pH	9.3 at 15:1
Density at 20°C	1.00 g/cm^3
Storage	Store at normal ambient temperature (5°C to 30°C)
Pack Sizes – Part Codes	5 ltr - 51296 20 ltr - 51293 60 ltr - 51294 200 ltr -51299 1000 ltr -51295

Refractometer Calibration:

Dilution ratio	25:1	**30:1**	**35:1**	**40:1**	45:1
Refractometer reading	4.1	**3.0**	**2.8**	**2.4**	2.2

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