# Technical Data

Performance you can trust

# ULTRACUT® EVO 250

## General Purpose Long Life Cutting Fluid

**ULTRACUT® EVO 250 is a high quality soluble oil water mix cutting fluid formulated to give a long and predictable sump life. It is designed for light/medium cutting operations on ferrous and non-ferrous metals. It contains a high percentage of refined mineral oils affording a high degree of residual corrosion protection and lubricity whilst machining.**

## Features

- Long and predictable sump life.
- Suitable for use with a wide range of ferrous and non-ferrous metals.
- Excellent residual corrosion protection.
- Good cutting performance.
- Inherently resistant to degradation.
- Low foaming.
- Rejects tramp oil.
- Ideal for individual and central cutting fluid systems.
- Contains no biocides nor skin sensitisers and carries no hazard label.
- Pleasant and safe to use.

## Directions for Use

**Recommended dilution:** ULTRACUT® EVO 250 should be used between 20:1 and 40:1 depending on the severity of the 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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The information in this publication is based on our experience and reports from customers.
There are many factors outside our control or knowledge which affect the use and performance of our products, for which reason it is given without responsibility.

# ULTRACUT® EVO 250

| | |
|---|---|
| **Appearance** | Clear amber liquid forming a white emulsion when mixed with water |
| **Odour** | Mild |
| **pH** | 9.4 at 25:1 |
| **Density at 20°C** | 0.95 g/cm$^3$ |
| | |
| **Storage** | Store at normal ambient temperature (5 to 30°C) |
| | |
| **Pack Sizes – Part Codes** | 5 ltr - 51366<br>20 ltr - 51363<br>60 ltr - 51362<br>200 ltr - 51369<br>1000 ltr - 51365 |

## Refractometer Calibration:

| **Dilution ratio** | 10:1 | **20:1** | **30:1** | **40:1** | 50:1 |
|---|---|---|---|---|---|
| **Refractometer reading** | 9.5 | **5.0** | **3.4** | **2.6** | 2.1 |

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