



PRODUCT DATA SHEET

POWER CUT - ULTRA®

PRODUCT DESCRIPTION

POWER CUT - ULTRA® IS A DARK AMBER WATER SOLUBLE OIL CUTTING AND GRINDING FLUID THAT BECOMES WHITISH IN COLOR UPON DILUTION. IT IS DESIGNED WITH A PREMIUM EXTREME PRESSURE ADDITIVE (EP) PACKAGE FOR HEAVY DUTY MACHING APPLICATIONS OF MOST MATERIALS. IT IS BOTH ENVIRONMENTALLY AND WORKER SAFE. POWER CUT - ULTRA® OFFERS EXCELLENT CORROSION PROTECTION ON FERROUS METALS.

ATTRIBUTES

- EXCELLENT CORROSION PROTECTION
- EXCELLENT TOOL LIFE
- GOOD SURFACE FINISH
- FERROUS AND NON-FERROUS METALS AND SUPER ALLOYS
- HEAVY DUTY APPLICATIONS

GENERAL APPLICATIONS

POWER CUT - ULTRA® IS TYPICALLY USED IN HEAVY-DUTY MACHING APPLICATIONS LIKE TAPPING AND SAWING. IT IS SUITABLE FOR USE WITH A VARIETY OF MATERIALS INCLUDING FERROUS METALS, CAST IRON, STAINLESS STEELS, AND NON-FERROUS ALLOYS. IT IS NON-STAINING TO MOST COPPER AND ALUMINUM ALLOYS.

APPLICATION INFORMATION

NOTE: THIS PRODUCT IS 2 X'S CONCENTRATED.

OPERATION	DILUTION	REFRACTOMETER READING	pH DI
SAWING	20:1	5.0	8.9
GENERAL MACHINING	40:1	2.5	8.6
GRINDING	50:1	2.0	8.5

DIRECTIONS

INITIAL CHARGE:

1. ADD DESIRED AMOUNT OF WATER TO SUMP.
2. ADD DESIRED AMOUNT OF UNDILUTED POWER CUT - ULTRA TO THE WATER IN THE SUMP.
3. USE MODERATE AGITATION TO MIX THOROUGHLY BY STIRRING.
4. MEASURE REFRACTOMETER READINGS AND ADJUST AS NECESSARY.

MAKE-UP (IN ORDER TO COMPENSATE FOR WATER EVAPORATION)

WHEN REFILLING YOUR SUMP YOU MUST TAKE INTO CONSIDERATION YOUR COOLANTS EVAPORATION RATE. SINCE THE WATER PORTION EVAPORATES DURING THE MACHINING PROCESS THE CONCENTRATION OF THE REMAINING SUMP VOLUME IS HIGHER THAN WHAT YOU STARTED WITH. AT THIS POINT YOU WILL NEED TO REFILL THE SUMP WITH A LOWER CONCENTRATED MIXTURE.

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