

TECHNICAL DATA

ULTRACUT 280A *Plus*

High Performance Long Life Water
Mix Cutting Fluid For Aluminium

Description

ROCOL ULTRACUT 280A Plus is a high performance water mix, aluminium cutting fluid uniquely formulated to give a long predictable sump life. It provides extra performance in medium and severe cutting operations when machining aluminium and its alloys whilst promoting optimum surface finish. Rocol ULTRACUT 280A Plus can also be used to machine other non ferrous metals, for example, copper and its alloys and all but the most difficult to machine ferrous metals.

Outstanding Features

- Gives optimum cutting performance on aluminium and its alloys
- Prevents built-up edge
- Extends tool life
- Promotes excellent surface finish
- Non-staining with most aerospace and industrial alloys
- Excellent residual corrosion protection
- Inherently resistant to degradation
- Long and predictable sump life
- Low foaming
- Rejects tramp oil
- Ideal for individual and central cutting fluid systems
- Pleasant and safe to use

Directions for use

Recommended dilution: Rocol Ultracut 280A *Plus* should be used between 15:1 and 25:1 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 the sump, particularly prior to weekends and shutdown periods.

Technical Data (typical values)

<i>Appearance</i>	: Clear brown concentrate forming a milky white emulsion when mixed with water
<i>Odour</i>	: Mild
<i>Nitrites</i>	: None
<i>Biocides</i>	: Contains no formaldehyde -releasing biocides
<i>Specific gravity</i>	: 0.94
<i>pH</i>	: 8.9 at 15:1 dilution
<i>Mineral oil</i>	: Contains 55% refined mineral oil
<i>Storage direct</i>	: 0°C to 40°C. Do not allow to freeze. Store in a cool place out of sunlight.
<i>Pack Sizes</i>	: 5ltr, 25ltr, 100ltr, 200ltr, 1000ltr

Refractometer readings:

Dilution	Refractometer Reading
10:1	9.6
20:1	4.8
30:1	3.0
40:1	2.4

Health and Safety

Further Technical Data and Safety Data Sheets are available from the Customer Service Department, Rocol Lubricants, Rocol House, Swillington, Leeds, LS26 8BS, England.
Telephone: 0113 232 2700, (When calling from outside UK: 44 113 232 2700).

Fax: 0113 232 2760, (When faxing from outside UK: 44 113 232 2760).