



HP Lubricants - Product Data Sheet

METAL CUTTING FLUIDS



KOOLKUT 40

THIS IS GENERAL-PURPOSE EMULSIFIABLE OIL AND FORMS MILKY WHITE EMULSION. IT MEETS THE REQUIREMENTS AS SPECIFIED BY IS: 1115-1986 (RE-AFFIRMED IN 1991) AND ZX- OF DEFENCE STANDARD. IT IS SUITABLE FOR ALL METALS FOR ALL MACHINING OPERATIONS WHERE EMULSIFIABLE OIL ARE NORMALLY USED. THE MOST COMMON EMULSION STRENGTH USED FOR MACHINING RANGES FROM 5 TO 10 PERCENT DEPENDING ON THE SEVERITY OF MACHINEING.

KOOLKUT 60

THIS FORMS A TRANSLUCENT EMULSION USEFUL FOR ALL APPLICATIONS REQUIRING SOLUBLE OIL WHERE SIGHT OF THE WORK PIECE IS IMPORTANT. THE ULTRA FINE DISPERSION OF THE OIL GLOBULES REDUCES GRINDING WHEEL CLOGGING AND LOW OIL CONTENT EMULSION MAY BE USED SAFELY WITHOUT LOSS OF NON-CORROSIVE PROPERTIES. THE MOST EMULSION STRENGTH USED FOR MACHINING RANGES FROM 5 TO 10 PERCENT DEPENDING ON THE SEVERITY OF MACHINING. MEETS IS: 9611-1980 SPCS.

KOOLKUTE EP 66

THIS IS HEAVY-DUTY SOLUBLE OIL, WHICH CONTAINS EXTREME PRESSURE ADDITIVES. ITS MAIN APPLICATION IS WITH HIGH-SPEED STEEL TOLLS IN PRACTICALLY ALL MAJOR CUTTING PROCESSES AND ON MOST METALS, INCLUDING DIFFICULT ALLOY STEEL. IT IS MORE EFFECTIVE THAN ORDINARY EMULSIFIABLE OILS IN EXTENDING TOOL LIFE. THE MOST COMMON EMULSION STRENGTH USED FOR MACHINING RANGES FROM 5 TO 10 PERCENT DEPENDING ON THE SEVERITY OF MACHINING.



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KOOLKUT 70

IT IS SOLUTION TYPE FLUID THAT CONTAINS NO OIL. IT CONSISTS OF SPECIAL CORROSION PREVENTIVE ADDITIVES IN WATER. IT IS SUPPLIED AS CONCENTRATE, WHICH MUST BE MIXED WITH WATER IN A SUITABLE PREPARATION. THE SOLUTION PROVIDES AN ECONOMICAL, RUST PREVENTIVE COOLANT OF EXCEPTIONALLY SUPERIOR PROPERTIES FOR GRINDING OR HIGH SPEED MACHINING. DILUTION RATIO RECOMMENDED WITH WATER IS 2-4 PERCENT, DEPENDING ON THE TYPE OF MACHINING.

KOOLKUT 80

IT IS SUPERIOR QUALITY MINERAL BASE EMULSIFIABLE TYPE OF CUTTING FLUID, WHICH IS PRIMARILY AIMED FOR LONGER PERIODS OF OPERATION. THE OIL ACTS ON INVERSE SOLUBILITY PHENOMENON TO PROVIDE EXCELLENT COOLING IF THE CUTTING SPEED ARE DESIRED TO BE INCREASED THAN NORMAL. IN ADDITION IT HAS THE FOLLOWING CHARACTERISTICS.

- BETTER LUBRICITY
- SUITABILITY FOR MULTI-METAL, MULTI OPERATION MACHINING
- EXCELLENT PH STABILITY
- BIO-STABLE EMULSIONS-EASY FOR HANDLING AND DISPOSAL.

KOOLKUT 80 IS RECOMMENDED FROM 3 TO 5% CONCENTRATION. IT MEET THE REQUIREMENTS AS SPECIFIED BY IS : 1115 – 1986 (RE- AFFIRMED IN 1991)



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METAL CUTTING FLUIDS

PROPERTIES	KOOLKUT				
	40	60	EP 66	70	80
EMULSION TEST	MILKY EMULSION	TRANSLUCENT EMULSION	SLIGHT YELLOWISH EMULSION	TRANSPARENT YELLOW FLUORESCENT SOLUTION	MILKY EMULSION
LOW TEMPERATURE EMULSION STABILITY	PASS	PASS	PASS	PASS	PASS
FOUR BALL EP VALUE OK LOAD (KG), MIN	--	--	180	--	--

SYNTHKOOL 100

IT IS SEMI-SYNTHETIC CUTTING FLUID THAT IS COMPLETELY WATER-SOLUBLE. IT IS SUPPLIED AS A CONCENTRATE THAT CONSISTS OF CAREFULLY SELECTED RUST PREVENTIVE ADDITIVES AND OTHER PERFORMANCE IMPROVERS IN A WATER SOLUTION.

THE CONCENTRATE SHOULD BE DILUTED IN THE RATIO OF 2-4% IN WATER. THE RESULTANT SOLUTION PROVIDES EXCEPTIONAL ANTI-RUST & COOLING PROPERTIES WHEN USED IN GRINDING AND OTHER HIGH SPEED MACHINING OPERATIONS. IT IS HIGHLY RESISTANT TO BACTERIAL ATTACK AND PROVIDES LONG LIFE IN USE.

PROPERTIES	SYNTHKOOL 100
COPPER STRIP CORROSION 3HR @ 100°C, MAX	1
CAST IRON CORROSION TEST 1:40 IN DISTILLED WATER	PASS
FOUR BALL TEST OK LOAD KG., MIN	180