LUBRICANTS

Powered By ECOSE

Product Data Sheet

Gulfcut® Soluble HD-NC

Non-chlorinated, high-performance machining and grinding fluid

Medium-to-heavy duty chlorine-free metalworking fluid with high lubricity. It is formulated to emulsify easily and form a stable, milky emulsion when mixed with water. This product is recommended for machining most Aerospace grade aluminum alloys as well as a wide range of ferrous alloys. It has very low foaming tendency, which is an advantage in high-speed and high-pressure applications. It is suitable for use in many types of machining processes including turning, boring, CNC milling, tapping, threading, and sawing. It also works well in various grinding applications. Contains a very effective biocide to control anaerobic bacteria keeping system free of objectionable odor.

Features and Benefits

- Better cooling than straight oils
- Can replace straight oils in most operations
- High lubricity to increase tool life
- Excellent corrosion inhibition

Applications

Concentration:	3% (33:1)	4% (25:1)	5% (20:1)	6% (17:1)	7% (14:1)	8% (12:1)	9% (11:1)	10% (10:1)
Refractometer Reading:	3.0	4.0	5.0	6.0	7.0	8.0	9.0	10.0

Recommended Starting Dilutions	Milling, Drilling, Turning	20:1 (5%)
	Centerless, ID, OD, Surface Grinding	33:1 (3%)
	Tapping, Reaming, Sawing	10:1 (10%)

Typical Properties

Product Code	**Test Method**	**335196**
Appearance – concentrate		Amber Liquid
Appearance – dilution		Milky Liquid
pH @ 20:1 (5%)		9.8 ± 0.3
Viscosity cSt @ 40°C	ASTM D445	74.0
Viscosity cSt @ 100°C	ASTM D445	9.2
Specific Gravity @ 60°F		.94 ± 0.01
Lbs/Gallon		7.82 ± 0.1
Flash Point, COC, °F		320
Total Chlorine, wt %		Nil

*Refractometer Factor = 1.0

When mixing coolant, it is best to use an automatic proportioner which accurately and thoroughly mixes coolant. **Always** replenish the coolant with a mixture of coolant and water, not just coolant or water. **Never** add coolant concentrate directly to the sump. **Storage,** containers of **Soluble HD-NC** should be stored indoors. Do not store in temperatures below 40°F.

Rev. 06/21