

## ULTRACUT CLEAR

### *High Dilution Semi-Synthetic Metal Cutting Fluid*

#### Description

**Ultracut Clear** is a high dilution, semi-synthetic general purpose water-mix cutting & grinding fluid formulated to provide optimum performance at high dilutions on a wide range of ferrous and non-ferrous metals.

**Ultracut Clear's** versatility enables the user to rationalise to one fluid for both cutting and grinding operations.

**Ultracut Clear** is formulated to provide a long and predictable sump life with inherent resistance to bacterial degradation.

**Ultracut Clear** forms a translucent green micro-emulsion when mixed with water which provides a clear view of the workpiece.

#### Areas of application

Flood applied to:-

- Manual lathes and other machine tools
- CNC controlled machine tools
- Surface and cylindrical grinders

#### Features

- Translucent liquid gives clear view of workpiece
- Very high dilution ratio
- Excellent surface finish
- Biocide protected – no rancidity
- Excellent residual corrosion protection
- Tolerant to tramp oil
- Excellent coolant life even at high dilutions

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The information contained in this Technical Bulletin is as up to date and correct as possible as at the time of issue. The data provided should be used as a guide only as the performance of the product will vary depending on differing operating conditions and application methods.

The sale of any product described in this Technical Bulletin will be in accordance with ITW Polymers & Fluids Conditions Of Sale, a copy of which is available on request. To the extent permitted by law, ITW Polymers & Fluids excludes all other warranties in relation to this product.

## Technical data

Appearance .....	Green concentrate forming a translucent green emulsion
Odour .....	Mild Amine
Specific Gravity .....	1.01
pH .....	9.0 at 50:1
Nitrites .....	Contains no nitrites
Flammability .....	Non-flammable

## Directions for use

**Recommended dilution:** **Ultracut Clear** should be used between 40:1 and 60:1 for cutting and between 50:1 and 70:1 for grinding depending on severity of the operation, workpiece material and water hardness. To ensure dilution accuracy, it is preferable to use a Venturi Fluid Mixer. For manual mixing, add the concentrate to water at the recommended dilution ratio, stirring continuously.

It is advisable to use **Rocol® Ultraguard SC** at fluid changeovers. Optimum fluid life is obtained by adequate initial machine cleaning, correct dilution control and regular maintenance of the fluid.

## Refractometer calibration:

Dilution ratio	40:1	50:1	60:1	70:1
Refractometer reading	1.6	1.3	1.1	0.9

## Storage and Shelf Life

Store in indoor dry conditions between 5°C and 50°C, keep away from sources of heat and naked flames. When stored in original sealed containers, the minimum shelf life is two (2) years.

## Packaging

**Ultracut Clear** is available in 20 Litre and 205 Litre containers.

## Ordering Information:

20Lt Cube	#RY561411
205Lt Drum	#RY561421

## Health & Safety Information

The product is non-hazardous. A Material Safety Data Sheet is available from the ITW Polymers & Fluids Technical Department upon request or available on our website [www.rocol.com.au](http://www.rocol.com.au).

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