

SmoothKut SS Ultra Tough 2010

Premium Grade Water Miscible Metal Working Fluid



DESCRIPTION

Smoothkut SS Ultra Tough 2010 is a cutting fluid that is water miscible and contains low amounts of mineral oil. It is specifically formulated for versatile machining tasks involving cast iron, carbon steel, and Ferrous alloys. When blended with water, it produces a stable, finely dispersed, long-lasting emulsion that is transparent and translucent in appearance.

YOUR BENEFITS

- ✔ Good emulsion, bio stability and cleanliness in hard water.
- ✔ Strong rust and corrosion protection under hard water conditions
- ✔ Excellent foam control
- ✔ Efficient tramp oil rejection
- ✔ No scum or sludge residue formation.
- ✔ Product being robust needs minimum fluid care.
- ✔ Improves surface finish.
- ✔ Extends lubricity and provides extended tool life.
- ✔ HSE Compliant product free of heavy metals.

APPLICATION

- ✔ General cutting operations.
- ✔ Most suitable for Sawing, Turning, Drilling, Boring, Milling and Grinding operations.
- ✔ Suitable for Reaming and Tapping operations.

MATERIAL COMPATIBILITY

- ✔ Mild Steel, Stainless Steel and Low-medium-High Tensile Steel.

RECOMMENDED CONCENTRATION

- ✔ Normal Operation: 5-7%
- ✔ Difficult operation: 8-10%

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INSTRUCTIONS FOR USE:

- Most suitable for high hardness water of 200 ppm to 1000 ppm of calcium carbonates.
- Product designed for low and high pressure CNC systems.
- Sump should be thoroughly cleaned before charging preferably using our system cleaner package.
- Concentration and pH levels should be checked periodically and maintained.
- Recommended to add oil to water and not vice versa. Do not add oil directly to the sump. Make emulsion before adding.
- Recommended chloride level <30 ppm in water.
- For additional information refer Coolant Management Guidelines available with Molygraph® Regional Application / Service Engineers.

CHARACTERISTICS	TEST METHOD	UNIT	TECHNICAL VALUES
Concentrate Parameters:			
Appearance	Visual	-	Pale Yellow
Specific Gravity @27°C	*CTM	gms/cc	1.0 ± 0.05
Emulsion Parameters :			
Emulsion type	Visual	-	Light Milky White
Emulsion stability test – 5% in 100 ppm water	*CTM	-	Stable
pH @5% in deionized water	*CTM	-	9.20 ± 0.05
Foam Depression in 5% in Water	IP 312/74	Secs	< 10
Cast Iron Corrosion Protection	IP 287	%	3 % BP
Refractometer Reading (1:20)	*CTM	-	2.5± 0.2
R. I. Factor	*CTM	-	1.91

*CTM: - Corporate Test Method

The values quoted above are typical and do not constitute a specification.

INDUSTRY:

Metal Cutting & Forming

PACK SIZE:

30 Ltrs. / 210 Ltrs.

SHELF LIFE:

12 Months

Marginal variation in shade can be expected from batch to batch. The color has no effect on the lubricating properties of the product. MSDS available on request. Due to continual upgradation of products above data is subject to change without notice.

This supersedes our previously issued data sheets.

Information and data given herein is offered in good faith as accurate, but without guarantee. Conditions of use and suitability of a product for a particular use is beyond our control; all risks of use of the product are assumed by the user and WE EXPRESSLY DISCLAIM ALL WARRANTIES OF EVERY KIND AND NATURE.

