

ULTRACUT[®] 255 HW **Hard Water Stable Extreme Pressure** **Long Life Cutting Fluid**

ULTRACUT[®] 255 HW is an extreme pressure medium duty soluble oil water mix cutting fluid, formulated to provide a long and predictable sump life in hard water conditions (above 250ppm). It provides extra performance in medium/severe cutting operations on a wide range of ferrous and non-ferrous metals. The combination of extreme pressure performance and long sump life permits increased machining rates and true cost efficiency.

Features

- Emulsion stability in all normal and hard water conditions.
- Extends tool life.
- Promotes good surface finish.
- Increases production rates.
- Suitable for medium/severe cutting applications.
- Suitable for use with most ferrous and non-ferrous metals.
- Excellent residual corrosion protection.
- Long and predictable sump life.
- Inherently resistant to degradation.
- Low foaming.
- Rejects tramp oil.
- Ideal for individual and central cutting fluid systems.
- Pleasant and safe to use.

Directions for Use

Recommended dilution: ULTRACUT[®] 255 HW should be used between 15:1 and 35:1 depending on the severity of the 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 fluid, particularly prior to weekends and shutdown periods.

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Appearance	Clear amber liquid forming a white emulsion when mixed with water.
Odour	Mild
pH	9.4 at 25:1
Density at 20°C	0.95 g/cm ³
Storage	Store at normal ambient temperature (5 to 30°C)
Pack Sizes – Part Codes	20 ltr - 51473 200 ltr - 51479

Refractometer Calibration:

Dilution ratio	10:1	15:1	20:1	25:1	30:1	35:1	40:1
Refractometer reading	9.9	6.5	6.0	4.0	3.7	2.9	2.8

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