



CUTTING FLUID GP™

General Purpose Cutting Fluid

Technical Information

Cutting Fluid GP is a general purpose, low odour, biostable soluble cutting fluid comprising of a blend of highly refined mineral oils, emulsifiers and corrosion inhibitors, with additional performance additives.

It does not contain any nitrites and resists biodegradation and spoilage.

It is designed to work in a wide variety of machines and is suitable for performing a multitude of different types of machining operations to yield an excellent finish on the machined parts.

Primary features attributable to Cutting Fluid GP are:

- Effective coolant with mild odour;
- Forms a stable emulsion even in hard water areas;
- Biostable – resistant to attack by bacteria;
- Prolongs tool life,
- Excellent finish on parts,
- Provides good corrosion and staining resistance,
- Contains an effective biocide – resists bacterial & fungal spoilage,
- Cost effective utilisation.

Applications

Cutting Fluid GP is formulated to be highly effective in use with all materials generally associated with machining processes.

The product is a general-purpose cutting fluid suitable for:

- Machining;
- Turning and Sawing;
- Drilling;
- Tapping and Broaching.

Compatibility



Cutting Fluid GP is compatible with all commonly used metallic materials and certain plastics and elastomers.

Health and Safety

Cutting Fluid GP is classified as IRRITANT to eyes and skin.

Users should avoid contact with skin and eyes and wear suitable protective gloves and safety glasses. Users should also avoid ingesting the coolant or inhaling vapours.

Do not eat, drink or smoke whilst using cutting fluids.

See Material Safety Data Sheet for details.

Typical Properties

Appearance	Viscous yellow-brown liquid
Odour	Mild
Density, g/cm ³ @ 15 °C	0.88 to 0.91
Solubility in water	Forms an emulsion
pH	9.0 to 9.4 units (5% sol'n)
Viscosity, mm ² /s @ 40 ⁰ C	30 to 80
Breakpoint, IP 287	25: 1
Corrosion, Herbert to IP 125	40: 1 (no rust)
Flash Point, Closed Cup, °C	> 100 (Neat Fluid)
Autoignition Temperature, °C	< 150 (Neat fluid)

Emulsion stability has been demonstrated in hard water areas (up to 400 ppm as calcium carbonate).

Storage life in original, unopened containers, at between 5 °C and 35 °C (41° to 95 °F), is not less than 24 months.

Directions for Use

Dilution:

Cutting Fluid GP requires to be diluted with water prior to use.

Recommended dilution rates for different applications are as follows:

Drilling, Screw Cutting & Tapping:	Dilute 1 part to 10 parts water
Turning, Milling and Sawing:	Dilute 1 part to 30 parts water

Application:

Cutting Fluid GP is suitable for flood or mist application.

CONTACT DETAILS:

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In the event of any technical queries, please contact:

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Packaging Details:

Cutting Fluid GP is available in:

- 25 Litre containers
- 210 Litre Drums.