

Technical Information Sheet

HICUT BIO 120 (Bio-stable EP semi-synthetic coolant)

DESCRIPTION

HICUT BIO 120 is a low odour, biostable, EP, semi-synthetic cutting fluid designed to give exceptionally long sump life, typically in excess of 12 months in central systems unobtainable with normal soluble cutting fluid. It mixes readily with water to provide excellent corrosion protection and lubricating properties.

HICUT BIO 120 is formulated from solvent refined mineral oil and a composite emulsifier, anticorrosion, EP, lubricating system. It provides long emulsion life without the problems associated with coolant degradation caused by bacterial and fungal contamination. The high degree of corrosion protection has been achieved without the use of nitrite or other undesirable components, which makes it environment - friendly.

APPLICATION

HICUT BIO 120 is suitable for majority of machining operations and is designed for use in individual machines and central systems. It is recommended for the grinding and machining of all ferrous and most non-ferrous metals.

TYPICAL USAGE CONCENTRATION ARE

Ferrous grinding	3 - 5%
General machining operations on mild, steel, medium tensile steels and aluminium	4 - 8%
Severe machining operations i.e. cutting and milling on stainless and high speed steel, where tool life and fine surface finish are required	6 - 10%

EATURES

Water soluble

Exceptionally long sump life; typically in excess of 12 months in central systems with filtration.

BENEFITS

No fire hazard.

Reduced cost.

Regd Office: HARDCASTLE PETROFER PVT. LTD

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Hicut Bio 120

Resistance to bacterial growth	No stain marks Addition of biocide not required.
Excellent cutting performance	Improved finish Increase productivity
Excellent corrosion protection	No rust, Avoid rejection
Excellent lubricity	Increased tool life, Better dimensional control, Easy chip removal.
Freedom from sticky deposits	Better operational performance.

TYPICAL PHYSICAL PROPERTIES

Appearance (Neat)	Brown fluid
(5% emulsion in water)	Translucent fluid
Specific gravity @ 30 ^o C	1.01
pH (5% Emulsion)	9.20

CONCENTRATION CONTROL

To obtain best cutting performance, freedom from corrosion and bacterial control, it is essential that coolants are maintained at the correct working concentration. This may be easily determined on a day to day basis by refractometer. Check refractometer reading and multiply the same by a factor of 1.33 to obtain the concentration of **HICUT BIO 120**.

TITRATION METHOD

Ask our representative for the detailed procedure.

PACKING

HICUT BIO 120 is available in 30 / 210 kg Drums.

WARRANTY:

Information given here is considered to be correct and is offered for your consideration, investigation and verification. No warranties are expressed or implied since the use of our product is beyond our control.

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