

# Technical Data Sheet

## HF Cutting Fluid

Ultra high performance extreme-pressure, long-life watermix metalworking fluid.

Hazard label-free, Chlorine-free, Amine-free, Boron-free, Formaldehyde-free.

HF Cutting Fluid is a hazard label-free, high oil, extreme pressure, watermix cutting fluid used for arduous machining on ferrous alloys and non-ferrous metals.

### Key Benefits

- Extremely High Performance
- Ultra Long Sump Life
- Improved Tool Life
- Highly Stable Macro-Emulsion
- Hazard Label Free
- Low Irritant
- Operator Friendly
- Excellent Corrosion Protection
- Low Foam
- No Sticky Deposits
- Less Product Loss due to Draw-Out

### Typical Applications

- |                                 |       |
|---------------------------------|-------|
| • General Machining             | 6%    |
| • Thread Cutting                | 6-10% |
| • Deep Hole Drilling and Boring | 6-8%  |
| • Reaming                       | 6-8%  |

### Typical Data

|                       |                  |
|-----------------------|------------------|
| <u>Concentrate</u>    |                  |
| Appearance            | Dark Amber Fluid |
| Specific Gravity      | 0.92             |
| Mineral Oil Content % | 65               |

|                      |            |
|----------------------|------------|
| <u>Emulsion</u>      |            |
| Appearance           | Good Milky |
| pH at 5%             | 9.0        |
| IP125 pass at %      | 3.0        |
| Refractometer Factor | 1.0        |

### Emulsion Type

- Tight Milky
- High Oil Content
- EP additives to enhance performance

### Compatibility

- Ferrous metals including stainless steel, not cast iron.
- Aluminium alloys
- Brass
- Inconel and other high spec alloys
- Titanium alloys
- Plastics

### General Compatibility

- Waters from 40ppm to 400ppm (Calcium hardness)
- Very low foaming tendency
- Suitable for high pressure applications
- Suitable for low pressure applications

### Health and Safety

Full health and safety data sheet is available on request.

### Storage

- Store indoors
- Store between 4 °C and 34°C
- Shelf life is 6 months from date of supply
- Store undercover.

**HF  
Cutting  
Fluid**

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