



Formulations For Today's Technical Manufacturing Needs

An ISO 9001:2000 Certified Company

PRIME CUT

General Description

PRIME CUT is a heavy duty soluble oil concentrate containing a chlorinated additive for difficult machining operations. This product was designed to be extended with water for the machining and grinding of virtually all metals except magnesium. **PRIME CUT** is particularly effective on aluminum alloys.

Application

PRIME CUT is designed for use in all metalworking applications such as CNC milling, turning, drilling, tapping and grinding. **PRIME CUT** is also excellent on cast iron and sawing applications.

Advantages

- Low Foaming
- Excellent Corrosion Inhibition
- Excellent Hard Water Stability
- Mild Pleasant Odor
- Long Lasting
- Operator Friendly

Recommended Concentrations

Application	Concentration, %	Ratio	Refractometer
General Machining	5% - 10%	1:20 – 1:10	5.7 – 11.4
Grinding	4%	1:25	4.6
Tapping, Drilling, Sawing	10%	1:10	11.4

Mixing Instructions

When mixing coolant, it is best to use an automatic proportioner which accurately and thoroughly mixes coolant. To maintain recommended concentration, make-up or top-off should be added at one-half of the desired concentration. Never add concentrate directly to the machine; this could cause inverted emulsions.

Concentration, %	4%	5%	6%	7%	8%	9%	10%
Ratio	1:25	1:20	1:17	1:14	1:12	1:11	1:10
Refractometer	4.6	5.7	6.8	8.0	9.1	10.3	11.4

Typical Properties

Appearance-Concentrate	Amber liquid
Appearance- Dilution	Opaque Amber-White
Residual Film	Soft, fluid
pH @ 20:1	9.2 ± 0.2
Specific Gravity @ 60°F	0.96 ± 0.03
Lbs/Gallon	8.0 ± 0.1
Total Chlorine, wt %	8 - 9
Flash point, COC °F	None

PRIME CUT is available in 5 gallon pails, 55 gallon drums and 275 gallon IBCs. Material Safety Data Sheets are available for all products. All reasonable care has been taken to ensure that the above information is accurate as of the date of printing.

36 Draffin Road, Hilton, NY 14468 Phone: 800-828-6351 585-392-3434 Fax: 585-392-2691
sales@monroefluid.com Website: <http://www.monroefluid.com>