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## Monroe HD

### Overview

MONROE HD is a heavy duty water extendable sulfur-chlorinated metalworking coolant formulated to offer outstanding performance in difficult machining and grinding operations involving hard-to-work metals such as stainless steel, tool steels and high nickel alloys. MONROE HD may be used on all metals except magnesium, copper and some bronze alloys, which may be stained.

### Applications

MONROE HD is suited for all types of machining processes including turning, milling, tapping, reaming, broaching, hobbing, and sawing. This product also works well in the various grinding processes, including centerless, cylindrical, surface, internal, belt, and disc.

### Features Benefits

- Used to Replace Straight Oils in Most Operations
- Excellent Finish in Machining and Grinding Operations
- Increases Tool Life
- Better Cooling than Oils
- Excellent Corrosion Inhibition
- More Economical than Straight Oil

### Recommended Concentration

Application	Concentration	Ratio
Tapping, Sawing, Reaming	(5%)	20:1
General Machining	(10%)	10:1
Grinding	(3%)	33:1

### Mixing

Concentration	4%	5%	6%	7%	8%	9%	10%	
Ratio	(1:33)	(1:25)	(1:20)	(1:17)	(1:14)	(1:12)	(1:11)	(1:10)
Refractometer	3.4	4.5	5.6	6.7	7.8	9.0	10.1	11.2

### Typical Properties

Appearance-Concentrate	Dark brown viscous liquid
Appearance - Dilution	Tan milky liquid
Residual Film	Soft, Fluid
pH @ 20:1	9.5 ± 0.3
Specific Gravity @ 60°F	0.96 ± 0.01
Lbs/Gallon	8.1 ± 0.1
Total Sulphur, wt %	2
Total Chlorine, wt %	6
Flash point, PMCC	None

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.