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## Prime Cut

### Overview

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.

### Applications

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.

### Features Benefits

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

### Recommended Concentration

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

### Mixing

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	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 Sulphur, wt %	NO
Total Chlorine, wt %	8 - 9
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.