



TECHNICAL DATA SHEET

Ultracut 250R Metalworking Fluid Concentrate

DESCRIPTION

Ultracut 250R is a superior heavy-duty, biostable, water-soluble oil with chlorinated and non-chlorinated extreme-pressure additives. Resistant to bacteria and fungus for low maintenance with corrosion protection and great lubricity.

APPLICATIONS

- General and through-the-spindle machining
- Milling, drilling, broaching

MATERIALS COMPATIBILITY

- Recommended for ferrous metals and hard-to-machine alloys
- Limited use for aluminum, titanium, brass, bronze, and copper

PHYSICAL PROPERTIES

<i>Concentrate Color</i>	Light brown
<i>Dilute Color</i>	Milky white
<i>pH at 10%</i>	9.5
<i>Specific Gravity</i>	0.95
<i>Density</i>	8.0 lbs/gal (957 kg/m ³)
<i>Flash Point</i>	220°F (104°C)
<i>Boiling Point</i>	212°F (100°C)
<i>Chlorine</i>	None
<i>Mineral Oil</i>	58%
<i>Refractometer Readings</i>	10:1 = 10.9 20:1 = 5.5 30:1 = 3.6

DILUTION RATIOS

- Milling, tapping, threading, turning, sawing, drilling, broaching.....10:1 – 20:1
- General, form, and centerless grinding

AVAILABLE IN

5 gal.....	74705
55 gal.....	74755

HEALTH AND SAFETY

Refer to MSDS (Material Safety Data Sheet) for complete information on health and safety on our web site at www.rocolnorthamerica.com.

For additional information please contact our Customer Service Department at 800-452-5823 ext. 2.

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