

ULTRACUT 390I General Purpose Semi-Synthetic Cutting Fluid

ROCOL Ultracut 390I is a high quality, semi-synthetic general purpose water mix cutting fluid formulated to provide a long and predictable sump life. It is designed for medium duty cutting operations on a wide range of ferrous and non-ferrous metals. It contains refined mineral oils and has a unique corrosion inhibition package. Rocol Ultracut 390 I is low foaming and emulsifies tramp oil. It forms a translucent micro-emulsion when mixed with water which provides a clear view of the workpiece.

Features

- Long and predictable sump life
- Compatible with hard and soft water
- Extends tool life
- Inherently resistant to degradation
- Suitable for a wide range of materials
- Emulsifies tramp oil
- Low foaming
- Pleasant and safe to use

Directions for Use

Recommended dilution: Rocol Ultracut 390I should be used between 10:1 and 30:1 depending on the severity of operation, workpiece material and water hardness. To ensure dilution accuracy, it is preferable to use a Rocol Automatic Fluid Mixer. For manual mixing, add the concentrate to water at the recommended dilution ratio, stirring continuously.

It is advisable to use the appropriate Rocol Ultraguard Machine Tool Care product at fluid changeovers. Optimum fluid life is obtained by adequate initial machine cleaning, correct dilution control and regular maintenance of fluid, particularly prior to weekends and shutdown periods.

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BS EN ISO 9001
Certificate No. FM 12448



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Certificate No. EMS 67596



OHSAS 18001
Certificate No. OHS 78173



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ULTRACUT 390I

Appearance	Amber concentrate forming a translucent emulsion
Odour	Mild
pH	9.6 at 20:1
Density at 20°C	0.99 g/cm ³
Storage	Store at normal ambient temperature (10°C to 30°C) Store out of direct sunlight

Refractometer Calibration:

Dilution ratio	10:1	15:1	20:1	25:1	30:1
Refractometer reading	9.1	6.1	4.5	3.6	3.0

Date: Feb-09

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