

## POWEROIL SYNTHCUT 50 HH

**POWEROIL SYNTHCUT 50 HH** is a BIOSTABLE semi-synthetic metalworking coolant for high pressure applications containing highly refined naphthenic base oils with multi-functional additive packages. It has exceptional foam control, hard water stability and tramp oil rejection while providing outstanding lubricity for machining and grinding. It is compatible with virtually all metals ideal for cast iron and steel grades, except Magnesium. The product is Chlorine Free.

CHARACTERISTICS	POWEROIL SYNTHCUT 50 HH
Appearance-Concentrate	Pale yellow to Amber thick liquid
Appearance- Dilution	Translucent white
Residual Film	Soft, fluid
pH @ 20:1	9.3
Density @ 29.5 °C, gm/cc	1.00
Total Sulphur, wt %	None
Total Chlorine, wt %	None

The above properties are typical values and do not constitute specification of the product

### APPLICATION:

- Poweroil Synthcut 50 HH is designed for use in all high and low pressure metal removal operations such as CNC milling, turning, , drilling, tapping, grinding and sawing etc.

RECOMMENED CONCENTRATION			
Application	Concentration %	Ratio	Refractometer (Brix)
Milling, Drilling, Turning	5	1:20	3.5
Centerless, ID, OD, Surface Grinding	4	1:25	2.8
Tapping, Sawing, Reaming	7	1:14	4.8

**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 invert emulsions.

Concentration, %	4%	5%	6%	7%	8%	9%	10%
Ratio	1:2	1:20	1:17	1:14	1:12	1:11	1:10
Refractometer(+/-0.2)	2.8	3.4	4.2	4.8	5.5	6.1	6.8

Refractometer factor : 1.47 ( Factor x Refractometer reading = Actual concentration)