

ULTRACUT® 250 HW Hard Water Stable General Purpose Long Life Cutting Fluid

ULTRACUT® 250 HW is a high quality general purpose soluble oil water mix cutting fluid, formulated to provide a long and predictable sump life in hard water conditions (above 250ppm). It is designed for light/medium cutting operations on ferrous and non-ferrous metals. It contains a high percentage of refined mineral oils affording a high degree of residual corrosion protection and lubricity whilst machining. ULTRACUT® 250 HW rejects tramp oil, is low foaming and forms a milky emulsion when mixed with water.

Features

- Emulsion stability in all normal and hard water conditions.
- Long and predictable sump life.
- Suitable for use with a wide range of ferrous and non-ferrous metals.
- Excellent residual corrosion protection.
- Good cutting performance.
- Inherently resistant to degradation.
- Low foaming.
- Rejects tramp oil.
- Ideal for individual and central cutting fluid systems.
- Pleasant and safe to use.

Directions for Use

Recommended dilution: ULTRACUT® 250 HW should be used between 15:1 and 35:1 depending on the severity of the 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 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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ULTRACUT[®] 250 HW

Appearance	Clear amber liquid forming a white emulsion when mixed with water.
Odour	Mild
pH	9.4 at 25:1
Density at 20°C	0.94 g/cm ³
Storage	Store at normal ambient temperature (5 to 30°C)
Pack Sizes – Part Codes	20 ltr - 51483 200 ltr - 51489

Refractometer Calibration:

Dilution ratio	10:1	15:1	20:1	25:1	30:1	35:1	40:1
Refractometer reading	9.2	6.5	4.7	4.2	3.2	2.9	2.6

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