

Performance you can trust

## ULTRACUT® 620 Extreme Pressure Long Life Chlorine Free Semi-Synthetic Cutting Fluid

ULTRACUT® 620 is an extreme pressure, chlorine free, semi-synthetic water mix cutting fluid formulated to give a long and predictable sump life. It provides extra performance in medium/severe cutting operations on a wide range of ferrous and non-ferrous metals. The combination of extreme pressure performance, excellent corrosion and staining inhibition and long sump life permits increased production rates and provides cost effective use.

ULTRACUT® 620 can also be used as a grinding fluid enabling the user to rationalise to one fluid for both cutting and grinding operations.

### Features

- Contains no chlorinated additives.
- Extends tool life.
- Promotes excellent surface finish.
- Suitable for cutting and grinding operations.
- Suitable for medium/severe cutting operations.
- Long and predictable sump life.
- Inherently resistant to degradation.
- Suitable for use with a wide range of ferrous and non-ferrous metals.
- Inhibits corrosion and staining.
- Resists foaming.
- Emulsifies tramp oil.

### Directions for Use

**Recommended dilution:** ULTRACUT® 620 should be used between 20:1 and 40:1 for cutting and 40:1 to 55:1 for grinding 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 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  
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The information in this publication is based on our experience and reports from customers. There are many factors outside our control or knowledge which affect the use and performance of our products, for which reason it is given without responsibility.

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## ULTRACUT® 620

|                                |   |
|--------------------------------|---|
| <b>Appearance</b>              | Blue concentrate forming a blue opaque emulsion   |
| <b>Odour</b>                   | Mild  |
| <b>pH</b>                      | 9.5 at 15:1                                       |
| <b>Density at 20°C</b>         | 1.00 g/cm <sup>3</sup>                            |
| <b>Storage</b>                 | Store at normal ambient temperature (5°C to 30°C) |
| <b>Pack Sizes – Part Codes</b> | 20 ltr - 51383<br>200 ltr - 51389                 |

### Refractometer Calibration:

|                              |      |             |             |             |             |      |
|------------------------------|------|-------------|-------------|-------------|-------------|------|
| <b>Dilution ratio</b>        | 10:1 | <b>20:1</b> | <b>30:1</b> | <b>40:1</b> | <b>50:1</b> | 60:1 |
| <b>Refractometer reading</b> | 8.7  | <b>5.0</b>  | <b>3.1</b>  | <b>2.3</b>  | <b>1.9</b>  | 1.7  |

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