

COOLCUT S-50

Long life, high stability soluble cutting fluid

Water miscible coolant for metal cutting processes on individual machine tools as well as centralized systems. Special formulation results in high coolant stability and long coolant life. Active EP-additives ensure long tool life and often allow to reduce concentration.

Universally applicable for severe machining processes. Preferably for hard-to-machine materials like high tensile & stainless steels, titanium grades, and also mixed materials including aluminium, brass and copper alloys.

Features & Benefits:

- Dilutes up to 1:30
- Extra lubricity prolongs tool life
- Free from bactericides and secondary amines
- Low foam
- Excellent cutting performance and corrosion protection-enhanced tool life
- Highly stable for long bath life
- Non skin irritant as per dermatological study (human patch test)
- Drilling, milling, turning, threading, tapping, broaching, reaming and grinding of ferrous and non-ferrous metals
- Works at high pressures (up to 80 bars)

Concentration control: By refractometer: measurement °Brix x F_{refr} = Vol-%; F_{refr} = 1.0

Description	Size		Order No.	SDS
	Metric	Imperial		
Liquid	5L	1.3 gal.	53-C 026	L-109E
Liquid	20L	5.2 gal.	53-C 027	L-109E
Liquid	208L	55 gal.	53-C 028	L-109E

ACCESSORIES

SB-30 Preservative Booster*	53-C 011
Valve for 5L containers	53-L 113
Valve for 20L container	53-L 207

**SB-30 Preservative Booster enhances the homogeneity of the emulsion, helps maintain pH levels and improves corrosion protection while eliminating odors.*

Technical Information

Refractometer Factor	1.0
Density	0.98 g/ml (at 15°C)
Flashpoint	N/A
Odor/color	Mineral oil like / Brown
pH (at 5%)	9.5
Rinsability	Fully miscible
Kinematic viscosity	252 mm ² /s (at 20°C)

SDS available upon request or visit our web site at www.walter.com

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Recommended concentration:

- Minimum: 4 %
- Centerless grinding: 5 - 7 %
- Cutting: 5 – 15 %

Application dilution chart:

Material	Dilution ratio	Dilution %	Application
Steel and Cast iron	1:20 - 1:10	5% - 10%	Turning, Milling, Drilling, Threading, Tapping, Sawing, Reaming, Broaching, Shaping, Hobbing
Stainless Steel and High Tensile Steel	1:12 - 1 :8	8% - 12%	Turning, Milling, Drilling, Threading, Tapping, Sawing, Reaming, Broaching, Shaping, Hobbing
Copper alloys and Aluminum Alloys	1:20 – 1:8	5% - 8%	Turning, Milling, Drilling, Threading, Tapping, Sawing, Reaming, Broaching, Shaping, Hobbing
Other Non-Ferrous Alloys	1:30 - 1:10	5% - 10%	Turning, Milling, Drilling, Threading, Tapping, Sawing, Reaming, Broaching, Shaping, Hobbing

Dilution Chart

Dilution ratio	Dilution %	ml of cleaner/ 1L of water	fl. oz. of cleaner/ 1 gal of water
1:30	3,3%	33ml	4,3 fl. oz.
1:20	5%	50ml	6,4 fl. oz.
1:14	7%	70 ml	9,0 fl. Oz.
1:10	10%	100ml	12,8 fl. oz.
1:8	12%	120 ml	15,4 fl. oz.
1:7	15%	150 ml	19,2 fl. oz.

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