

FLUIDTECH TECHNICAL DATA SHEET

semi-synthetic

FLUIDTECH 270 Semi-Synthetic / Heavy Duty

DESCRIPTION

A heavy duty, general purpose semi-synthetic water soluble metalworking fluid designed for use on ferrous and most nonferrous metals including cast iron and aluminum. Contains extreme pressure additives for difficult machining and grinding operations. It is suitable for turning, milling, drilling, sawing and grinding in individual sumps or central systems.

Works well in hard and soft water. It will not form hard water soaps or cause excessive foaming in soft water. Leaves machines clean and free of gummy tramp oil deposits which enhances operator acceptance. It provides trouble free performance on a wide range of metals and diverse operations.

ADVANTAGES

- EXTREME PRESSURE ADDITIVES FOR EXTENDED TOOL LIFE • SUPERIOR TRAMP OIL REJECTION
- EXCELLENT CORROSION PROTECTION • STABLE EMULSION IN HARD AND SOFT WATER • MULTI-METAL COMPATIBILITY

RECOMMENDED STARTING DILUTIONS

Operation	Carbon Steels, Cast Steels	High Alloy Steels, Stainless Steels	Aircraft, Tool Steels	Copper, Aluminum
Machining- Milling, Drilling, Turning	1:20 (5.0%)	1:20 (5.0%)	1:15 (6.7%)	1:20 (5.0%)
Grinding	1:25 (4.0%)	1:25 (4.0%)	1:20 (5.0%)	1:25 (4.0%)
Reaming, Tapping, Sawing, Broaching	1:10 (10.0%)	1:10 (10.0%)	1:10 (10.0%)	1:10 (10.0%)

PHYSICAL PROPERTIES

Form	Liquid
Color	Amber or Blue
Specific Gravity	1.03
Flash Point	None
Odor.....	Mild
pH @ 5% conc.....	9.5

REFRACTOMETER READINGS

Dilution Ratio	1:10 (10.0%)	1:15 (6.7%)	1:20 (5.0%)	1:25 (4.0%)	1:30 (3.3%)
Refractometer Reading	5.8	4.4	3.3	3.0	2.2

AVAILABILITY

Undyed	
A-FT270-05	5 Gal Pail
A-FT270-55	55 Gal Drum
A-FT270-275	275 Gal Tote
Blue	
A-FT271-05	5 Gal Pail
A-FT271-55	55 Gal Drum
A-FT271-275	275 Gal Tote