



Industrial Oils, Fluids & Lubricants

Technical Data Sheet (TDS)

Semi-Synthetic 3500

Product Description

Semi-Synthetic 3500 is a premium bio-stable coolant for industrial networking machining operations. This product is manufactured to be sulfur and chlorine free.

Features and Benefits

Semi-Synthetic 3500 forms a stable micro-emulsion for superior rust protection. Safe to use on all metals except magnesium. Excellent cooling properties to promote good finishes and extend tool life.

Applications

Product is recommended for general purpose metalworking applications of both ferrous and non-ferrous metals. Machining applications may include cutting, drilling, milling, tapping, sawing, and grinding. Excellent aerospace machining fluid for titanium and aluminum. Do **NOT** use for machining magnesium. Consult your account manager or our technical support team for questions regarding compatibility.

Typical Properties

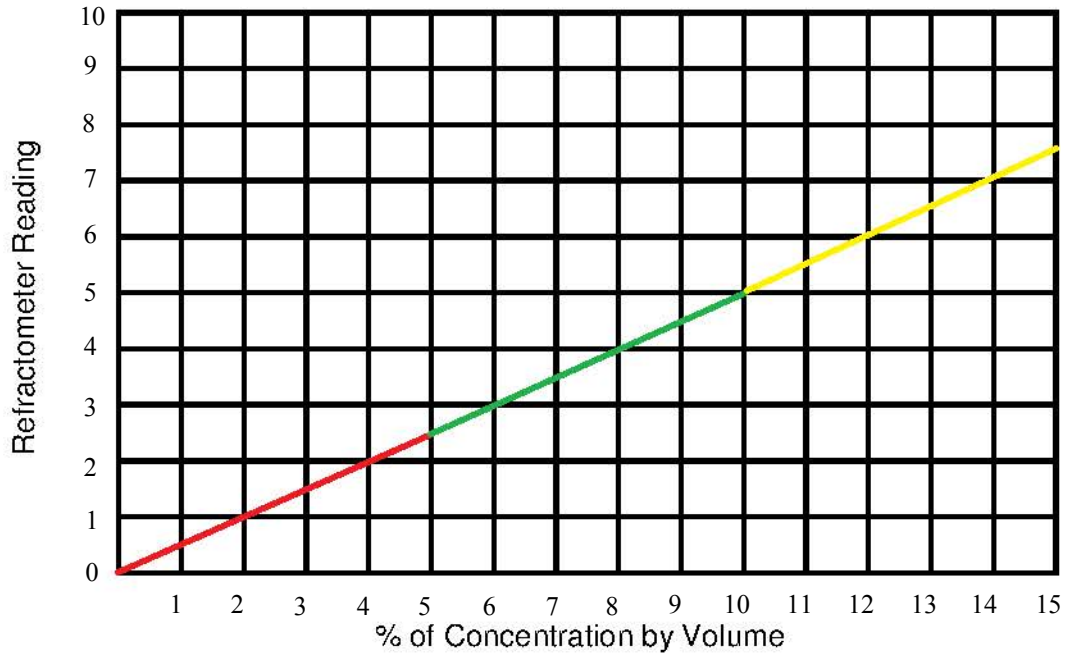
<u>Property</u>	<u>Specifications</u>
API Base Oil Category	Not applicable
Appearance	Blue
Density lb/gal.	8.568
Specific Gravity	01.029
Viscosity @ 40 C (cSt)	Not applicable
Pour Point, F	38
Flash Point (COC) F	None
Chlorine, wt %	0
Sulfur, wt %	0
Lubricity wt. %	5 - 10

All reasonable care has been taken to ensure that the information contained in this publication is accurate as of the date of printing. However, variations that do not affect performance are to be expected during normal manufacturing. The Safety Data Sheet (SDS) must be consulted for appropriate information regarding the safe handling, storage, and disposal of a product.

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Semi-Synthetic 3500

Refractometer Factor % Brix = 2.0



Dilution is too weak. Add 1 part concentrate to 10 parts water to increase concentration ratio.

Dilution is in the correct range.

Dilution is too strong. Add 1 part concentrate to 40 parts water to decrease concentration ratio.

Recommended Metalworking Concentrations

Light Duty.....4%-6%

Medium Duty.....6%-8%

Heavy Duty.....8%-10%

Mixing Instructions

Always add the concentrate to the water and mix thoroughly for maximum performance and extended coolant life.

Using premixed coolant as makeup will improve coolant performance and reduce coolant expenses. The makeup solution you select should balance the water evaporation rate with the coolant carryout rate. After initial startup, expect to mix coolant at a reduced ratio to allow for this natural process.