



Product Bulletin

GULFCUT® HD SOLUBLE

Gulfcut® HD Soluble is a heavy duty water extendable sulfur-chlorinated metalworking coolant formulated to offer outstanding performance in difficult machining and grinding operations involving hard-to-work metals such as stainless steel, tool steels, and high nickel alloys.

Gulfcut® HD Soluble may be used on all metals except magnesium, copper and some bronze alloys, which may be stained. It will perform as well as straight oil in most applications. It is suitable for use in all types of machining processes including turning, milling, tapping, reaming, broaching, hobbing, and sawing. It also works well in the various grinding processes, including centerless, cylindrical, surface, internal, belt and disc.

FEATURES AND BENEFITS:

- Can replace straight oils in most operations
- Excellent corrosion inhibition
- Better cooling than straight oils
- Increases tool life
- Excellent finish in machining and grinding operations
- More economical than straight oils

Typical Properties

Product Code	Test Method	335195
Appearance – concentrate		Dark Brown Viscous Liquid
Appearance – dilution		Tan Milky Liquid
Residual Film		Soft, Fluid
pH @ 20:1 (5%)		9.5 ± 0.3
Specific Gravity @ 60°F		.96 ± 0.01
Lbs/Gallon		8.1 ± 0.1
Flash Point, PMCC, °F		None
Total Sulfur, wt %		2
Total Chlorine, wt %		6

Concentration:	3% (33:1)	4% (25:1)	5% (20:1)	6% (17:1)	7% (14:1)	8% (12:1)	9% (11:1)	10% (10:1)
Refractometer Reading:	3.0	4.0	5.0	6.0	7.0	8.0	9.0	10.0
Recommended Starting Dilutions	Milling, Drilling, Turning					20:1 (5%)		
	Centerless, ID, OD, Surface Grinding					33:1 (3%)		
	Tapping, Reaming, Sawing					10:1 (10%)		

When mixing coolant, it is best to use an automatic proportioner which accurately and thoroughly mixes coolant. **Always** replenish the coolant with a mixture of coolant and water, not just coolant or water. **Never** add coolant concentrate directly to the sump.

AVAILABILITY:

Gulfcut® HD Soluble is available throughout Gulf's marketing area. Your Gulf representative can provide specific information. Need additional information? Call Gulf @ 1-800-566-GULF(4853) or visit Nu-tierbrands.com.

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NU-TIER BRANDS, INC.

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