



TECHNICAL DATA SHEET

GRODAL CUTSOL AA

Multipurpose Metalworking Fluid

DESCRIPTION

Grodal Cutsol AA is a long life biostable water soluble cutting fluid with excellent corrosion resistant property which is designed for cutting and grinding operations. When it mixed with the water it forms milky white emulsion. Grodal Cutsol AA is formulated with the high quality mineral oil and high levels of lubricity additives to provide excellent performance in arduous operations. Grodal Cutsol AA is formulated to provide long service life and limits bacterial growth thereby helping to reduce smells associated with bacterial degradation.

APPLICATION

Grodal Cutsol AA is suitable for processing steel, cast iron, gray cast iron, Aluminium and non ferrous heavy metals. Grodal Cutsol AA is recommended for most metal cutting and grinding operations where high quality coolant is required.

BENEFITS

- | Excellent performance in high speed processing
- | Outstanding machining performance on aluminium, non-ferrous metals and ferrous metals.
- | Excellent anti-rust property and protects machine & work pieces from rusting.
- | Contributes for effective operation and protection of the earth environment.
- | Safe to use and disposal is easier.
- | Excellent cooling performance.
- | Wide multi-metal machining range.
- | Oil content protects machined components, machine fitting and fixtures.
- | Free of triazine biocides, phenols and nitrites.

TECHNICAL DATA

Colour and Appearance	:	brown liquid
Sp. Gravity @ 30 °C	:	0.87
Appearance of 5 % emulsion	:	Milky white emulsion
PH of 5 % emulsion	:	9 - 10
Foaming test	:	passes
Corrosion Test	:	Passes
Saponification no.	:	18 mgKOH/gm
Refractometer factor	:	1

RECOMMENDATIONS

Grodal Cutsol AA is designed for machining and grinding of ferrous and non ferrous metals, specially cast iron and its alloys.

Operation	Cast Iron	Stainless Steel	Non Ferrous
Turning	3 - 4 %	4 - 5 %	4 - 5 %
Drilling	3 - 4 %	4 - 5 %	4 - 5 %
Boring	3 - 4 %	4 - 5 %	4 - 5 %
Milling	3 - 4 %	4 - 5 %	4 - 5 %
Tapping	4 - 5 %	5 - 7 %	6 - 8 %
Grinding	3 - 4 %	3 - 4 %	2 - 3 %
Sawing	4 - 6 %	5 - 7 %	6 - 8 %
Screw cutting	4 - 6 %	5 - 7 %	6 - 8 %

SAFETY : This oil is unlikely to present any significant health or safety hazard when properly used in the recommended application as well as good standards of industrial and personal hygiene is maintained.

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