

# PRODUCT DATA SHEET



## SYNTHETIC CUTTING FLUIDS

### PAL SYNCO-300, 400

These are premium class of synthetic fluids based on combination of Ethylene & Propylene Oxide & provides both hydro dynamic & extreme pressure lubrication. At ambient temperature these are completely water soluble & at elevated temperatures these exhibits inverse solubility & are thus able to provide excellent lubricity at low concentration in water.

These fluids do not undergo bacterial degradation & leave objectionable odour. Further these fluids prevent the build-up of tacky or gummy residue & thus provides long term trouble free service in recirculating central cooling systems.

**PAL SYNCO - 300** is especially recommended for machining & grinding operations where it provides extremely smooth surface finish.

**PAL SYNCO - 400** is recommended for machining & cutting operations of steel & nickel chrome steel.

**Not recommended for the machining of non-ferrous metals.**

Dilution ratio with water varies between 4%-5% depending upon the operation and product handled.

\* Concentrated mixture may lead to paint peel off in the machines and some discoloration of the operator's skin.

\* Coolant should be used only in clean circulating system.

**PERFORMANCE LEVEL:** IS 11186-1985(Reaffirmed 1990) specifications.

CHARACTERISTICS			
S. NO.	PROPERTIES	PAL SYNCO - 300	PAL SYNCO - 400
1.	Appearance	Green	Green
2.	Solution Appearance, @2% in distilled water	Clear fluorescent	Green
3.	Cast Iron Corrosion, @250ppm,500ppm,1000ppm	Passes	Passes
4.	pH 2% dilution in distilled water	9	9.5
5.	Low temperature static test	Passes	Passes

**\* The specifications are subject to variations/ development / customization.**

**PACKING:** 210L, 50L, 20L