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technical data sheet

Signal Cut 071

Product Application:

Signal Cut 071 is a high-quality, high-performance vegetable ester based, industrial grade emulsifiable water miscible metalworking concentrate designed to provide unsurpassed machining for aluminum & associated aerospace alloys such as Inconel and Hast alloys as well as most difficult to machine materials, ferrous and non-ferrous and the like from turning, milling, drilling, sawing and grinding applications.

Signal Cut 071 is formulated with the latest biostable technology to provide excellent machine tool efficiency under the most adverse conditions while doing so incorporating advanced chemistry utilizing vegetable ester technology to provide extended fluid life in long (lights out) production runs while inhibiting microbial growth and providing excellent corrosion protection without leaving sticky residues behind.

Signal Cut 071 incorporates a delicate balance of mild PH modifiers to ensure that it is gentle on the operator's skin as well as providing a clean trouble-free performance on a wide range of materials and diverse operations in central and individual sumps for unimpeded efficiency and performance.

*Signal Cut 071 is environmentally conscious fluid that contains no chlorine, nitrites, heavy metals, phenols or diethanolamines.

Package Size:

Drums, Pails

Recommended Concentrations:

Grinding	2-3% (50:1 to 30:1)
Milling, turning, drilling, sawing	3-4% (30:1 to 25:1)
Broaching, tapping, boring	4-5% (25:1 to 20:1)

Features and Advantages:

- *Excellent microbial resistance, increased sump life
- *Non-foaming and non-misting performance
- *Improved protection against chip buildup and tool face wear
- *Provides excellent rust and corrosion protection
- *Provides unequalled extreme pressure properties
- *Exceptionally clean fluid leaves no sticky residue on parts
- *Wide application range

Typical Characteristics:

Color	Pink
Specific Gravity	.98
pH @ 20:1 Dilution	9.2
Hard Water Stability	
25 hrs. @ 600ppm	No Cream
Cast Iron Rust Chip Test	
25 hrs. in 100 ppm water	No Rust @ 33:1
Refractometer Reading	
@ 20:1 Dilution (Brix)	2.8

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