



Power Synthcut EP-40 HD

Premium Heavy Duty Semi Synthetic cutting fluid

General Description

Power Synthcut EP - 40 HD is a heavy duty BIOSTABLE semi-synthetic high pressure metalworking coolant. **Power Synthcut EP - 40 HD** combines the superior chemical flexibility of synthetics with mineral oil and a chlorinated extreme-pressure additive. **Power Synthcut EP - 40 HD** has exceptional foam control, hard water stability and tramp oil rejection. It provides outstanding extreme-pressure lubricity for machining and grinding virtually all metals, particularly Aluminum, Stainless Steels and other hard to machine alloys. **Power Synthcut EP- 40 HD** is not recommended for use on Magnesium.

Application

Power Synthcut EP - 40 HD is designed for use in high and low pressure metal removal operations such as all CNC milling, turning, drilling, tapping, grinding and sawing.

Recommended Concentrations

Application	Concentration, %	Ratio	Refractometer
Milling, Drilling, Turning	5%	1:20	4.0
Centerless, ID, OD, Surface	4%	1:25	3.2
Tapping, Sawing, Reaming	10%	1:10	8.0

Mixing Instructions

When mixing coolant, it is best to use an automatic proportioner which accurately and thoroughly mixes coolant. To maintain recommended concentration, make-up or top-off should be added at one-half of the desired concentration. Never add concentrate directly to the machine; this could cause inverted emulsions.

Concentration, %	4%	5%	6%	7%	8%	9%	10%
Ratio	1:25	1:20	1:17	1:14	1:12	1:11	1:10
Refractometer	3.2	4.0	4.8	5.6	6.4	7.2	8.0

Typical Properties

Appearance-Concentrate	Amber liquid
Appearance- Dilution	Translucent Amber
Residual Film	Soft, fluid
pH @ 20:1	9.1 ± 0.2
Density @ 29.5 °C	1.007
Total Chlorine, wt %	3 – 5% max

Disclaimer: APAR makes no warranties, representation or conditions of any kind expressed or implied for use with respect to these products. Final determination of suitability of the products for the application contemplated by the user is solely their responsibility.

Apur Industries Ltd., Apar House, Corporate Park, Sion-Trombay Road, Chembur, Mumbai – 400 071.

Tel: 91-22- 2526 3400 / 6780 0400 | Fax: 91-22-2524 6326 | website: www.apar.com