

# PIRANHA COOLCUT 100T

PREMIUM HEAVY DUTY SOLUBLE OIL FOR DIFFICULT TO MACHINE METALS



A PRODUCT OF LUBRICATING SPECIALTIES COMPANY

## Product Description



**COOLCUT 100T** is a water soluble cutting and grinding fluid formulated for a wide range of machining operations on both ferrous and non-ferrous metals. With its advanced emulsifier technology, it mixes readily with water to form an extremely stable emulsion with excellent surface wetting characteristics and

virtually no foam. COOLCUT 100T has exceptional lubricity and extreme pressure properties that give outstanding surface finishes as well as longer tool life compared to conventional heavy duty soluble oils. It has excellent bio-resistance which allows for long term service without rancidity. It contains an effective biocide that controls bacteria and fungi growth without being irritating to machine operator's skin.

COOLCUT 100T forms an opaque, light blue emulsion with a mild, pleasant odor. It provides excellent rust and corrosion protection and leaves no deposits or build-up on the machine or finished parts.

**NOTE: NEVER USE SOLUBLE OIL EMULSIONS FOR MACHINING MAGNESIUM. HOT MAGNESIUM AND WATER ARE A FIRE HAZARD! ALWAYS MIX BY ADDING NEAT COOLCUT 100T TO WATER IN TANK OR COOLANT RESERVOIR. REMEMBER: WATER FIRST, THEN COOLCUT 100T.**

## Applications & Uses:

Coolcut 100T may be used for grinding and machining of both ferrous and non-ferrous metals at the following ratios:

- Surface & O.D. Grinding 50:1
- Centerless Grinding 20:1- 30:1
- Light Duty Machining 30:1
- Moderate Duty Machining 20:1
- Severe Duty Machining 15:1

## Features & Benefits:

- Multi-metal, multi-operation applications.
- Stable emulsion.
- Excellent surface wetting.
- Exceptional lubricity and EP characteristics.
- Outstanding rust and corrosion protection.
- Excellent bio-resistance for long term service.
- Low foam even at 15:1 dilution.
- Mild, pleasant odor.
- No build-up or deposits on machine or parts.
- Not irritating to operator's skin.
- Dyed green.

## Typical Test Data

TEST	ASTM	100T	Refractometer vs. Dilution Graph														
Gravity API	D-4052	13.3	<table border="1"> <caption>Refractometer vs. Dilution Graph Data</caption> <thead> <tr> <th>Dilutions</th> <th>Refractometer Reading</th> </tr> </thead> <tbody> <tr><td>5:1</td><td>20</td></tr> <tr><td>10:1</td><td>10</td></tr> <tr><td>20:1</td><td>5</td></tr> <tr><td>30:1</td><td>4</td></tr> <tr><td>40:1</td><td>3</td></tr> <tr><td>50:1</td><td>2</td></tr> </tbody> </table>	Dilutions	Refractometer Reading	5:1	20	10:1	10	20:1	5	30:1	4	40:1	3	50:1	2
Dilutions	Refractometer Reading																
5:1	20																
10:1	10																
20:1	5																
30:1	4																
40:1	3																
50:1	2																
Viscosity: cST @ 40° C	D-445	71.7															
Appearance	----	Bright/Clear															
Color	----	Green															
Order	----	Pleasant/Mild															
Rust Test	D-665A	Pass															
Foam Test	D-892	Pass															
Emulsion (10:1)	----	Excellent															
Emulsion Stability	----	Pass															
Sulfur, %WT.	----	1.1															
Chlorine, %WT.	----	7.0															
pH, 5% in DI Water	----	9.0															

\* CONTAINS HIGH PERFORMANCE ADDITIVE CHEMISTRY.  
VALUES SHOWN HERE ARE TYPICAL AND MAY VARY.

## TECHNICAL PRODUCT INFORMATION

PRODUCT CODE: 39066

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