

Q-CUT 246C

High Performance Semi-Synthetic with EP

Performance Benefits

- Extended tool life resulting from state of the art additive technology
- Long fluid life in both central systems and individual sumps
- Residue free parts and machine tools
- Low foaming in both soft and hard water
- Complete rejection of tramp oil
- Bimetallic corrosion protection for parts and machine tools

Q-CUT 246C is a high oil containing semi-synthetic for machining and grinding ferrous and non-ferrous metals. This product utilizes state of the art raw materials to eliminate the rancidity and cleanliness issues associated with most soluble oils and semi-synthetics. The product is designed for use on a wide range of metals, making it well suited for job shop operations. Q-CUT 246C is non-staining to sensitive aerospace alloys, aluminum (including 319, 356, 6061T-6, 7075), and yellow metals. The product also has excellent corrosion control for ferrous metals. Q-CUT 246C contains an extreme pressure additive to improve tool life and part quality in difficult applications. The fluid has a tight emulsion to promote tramp oil rejection and exhibits excellent hard water stability up to 35 grains of hardness. Q-CUT 246C runs clean, has excellent bioresistance, and is non-foaming.

Typical Characteristics

Appearance of concentrate.....	Yellow liquid
Appearance of emulsion.....	Semi-translucent
Density	8.26 lbs./gal
pH of 5% emulsion.....	8.7-9.1
Nitrite, Phenols, DEA, formaldehyde	
Silicones.....	None

Recommended Dilutions

Q-CUT 246C is to be mixed with water for use (add concentrate to water)

Grinding:	3-5%
Machining:	4-12%

Concentration Control

The chart below was prepared using an Atago Master M refractometer and dilutions of Q-CUT 246C in distilled water. Refractometer readings can vary with the type of water and refractometer used. Atago Master M refractometers are available from QualiChem, Inc.

CONCENTRATION %:	3	4	5	6	7	8	10	12
REFRACTOMETER READING:	2.6	3.5	4.4	5.3	6.2	7.0	8.8	10.6

Packaging

Q-CUT 246C is packaged in 310-gallon, one-way tote tanks and 55-gallon, non-returnable steel drums. Bulk and 5-gallon pails are also available.

QUALICHEM
Metalworking Fluids

AN ISO 9001:2008 COMPANY
2003 Salem Industrial Drive | Salem, VA 24153
540.375.6700
www.qualichem.com/metalworking