



Peregrine

Additives & Lubes

PAL AQUACUT 1000 **High Performance Soluble Cutting Oil**

Last Revision: 31/07/19

Description

PAL AQUACUT 1000 is a general-purpose amine-free, phenol-free and chlorine-free water-soluble cutting fluid giving a milky opaque emulsion when mixed with water and containing high lubricity and anti-corrosion properties. It is suitable for a wide range of cutting and grinding applications that require a combination of water-soluble lubricant and coolant, and is recommended for a variety of ferrous and non-ferrous metals. The product is more bio-stable than most conventional water-soluble oil and will not give off foul smell easily. For stable emulsion, oil should be added to water. The most common emulsion strength used for machining ranges from 5 to 10 percent depending on the severity of operation and the metal types involved.

Features

- Wide application range
- Superior emulsion stability for longer sump life
- Outstanding lubricity and corrosion control
- Resist bacteria attack
- Low foam and odor
- Emulsify readily
- Hard water stability

Applications

The following general ratio is recommended

Operations	Ratio, Parts Oil to Water
Grinding	1: 40 - 60
Light cutting	1: 30 - 40
Turret lathe, screw machining, milling and drilling	1: 20
Broaching, threading, gear cutting	1: 10
General machining- Non-ferrous materials	1: 20 - 30
General machining- ferrous materials	1: 20

Typical Properties

Density@15°C, kg/L	0.890
Colour ASTM	2.0
Viscosity@40°C, cSt	40.1
Emulsion Characteristics- pH@5% dilution	9.0
IP 287 Corrosion, Break Point, %	5
Emulsion Type	Dense milky white emulsion

Typical values do not constitute as specifications. Due to continual product research and development, the information contained herein is subjected to change without notification

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