

Performance you can trust

## ULTRAGRIND™ CARBIDE High Performance Synthetic Grinding Fluid

**ULTRAGRIND™ Carbide is a high performance, long life, low foaming, synthetic water mix grinding fluid formulated specifically for the grinding of cemented tungsten carbide. The transparent emulsion gives a good view of the work piece and being oil-free, ensures rapid settlement of grinding fines.**

**ULTRAGRIND™ Carbide is suitable for all types of surface, centreless and cylindrical grinding operations on hard metals.**

### Features

- Inhibits leaching of cobalt.
- Promotes excellent surface finish.
- Keeps the grinding wheel clean.
- Transparent liquid gives clear view of workpiece.
- Excellent residual corrosion protection.
- Low odour.
- Long sump life.

### Directions for Use

ULTRAGRIND™ Carbide should be used at between 15:1 and 30:1 dilution depending upon the severity of the grinding operation, work piece material and water hardness. To ensure dilution accuracy it is preferable to use a ROCOL® Automatic Fluid Mixer. For manual mixing add the concentrate to water at the recommended dilution ratio, whilst stirring continuously.

It is advisable to use the appropriate ROCOL® ULTRAGUARD® Machine Tool Care product at fluid changeovers. Optimum fluid life is obtained by adequate initial machine cleaning, correct dilution control and regular maintenance of fluid, particularly prior to weekends and shutdown periods.

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BS EN ISO 9001  
Certificate No. FM 12448



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OHSAS 18001  
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## ULTRAGRIND™ CARBIDE

<b>Appearance</b>	Green concentrate forming a translucent green solution
<b>Odour</b>	Mild
<b>pH</b>	9.3 at 20:1
<b>Density at 20°C</b>	1.05 g/cm <sup>3</sup>
<b>Storage</b>	Store at normal ambient temperature (5°C to 30°C)
<b>Pack Sizes – Part Codes</b>	20 ltr - 51713 200 ltr - 51719

### Refractometer Calibration:

<b>Dilution ratio</b>	10:1	15:1	20:1	25:1	30:1	35:1
<b>Refractometer reading</b>	2.6	1.8	1.5	1.2	1.0	0.8

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