



XTREME CUT 290

Premium Extreme Duty Semi-Synthetic

Performance Benefits

- Boeing Approved
- Extended tool life resulting from state of the art additive technology
- Suited for use on both ferrous and non-ferrous metals. Non-staining to aluminum
- Excellent corrosion control for ferrous metals and machine tools
- Residue free parts and machine tools
- Low foaming
- Hard water stability up to 35 grains
- Formaldehyde and DEA free to comply with health and safety regulations
- Minimal dermal irritation potential promotes operator acceptance

XTREME CUT 290 is a high performance semi-synthetic fluid designed for the most difficult machining applications. The product is formulated to improve tool life on difficult aerospace alloys such as Inconel, Titanium, and Stainless Steel. **XTREME CUT 290** provides the performance level of heavy-duty soluble oils without the unpleasant odors or high usage rates associated with soluble oils. This unique product does not contain chlorine, phosphorous, or sulfur; yet its performance exceeds soluble oils, which contain these extreme pressure additives. **XTREME CUT 290** has excellent bioresistance resulting in long fluid life in both central systems and individual sumps. It has a tight, stable emulsion that imparts excellent tramp oil rejection and product stability.

XTREME CUT 290 is approved under Boeing's BAC 5008 specification, PSD 6-128.

Typical Characteristics

Appearance of concentrate.....	Clear, amber viscous liquid
Appearance of emulsion.....	Semi-Translucent
Density	8.07 lbs./gal
Specific gravity.....	0.957 - 0.977
pH of 5% emulsion.....	8.8 - 9.2
Chlorine, Nitrite, Phosphorous, Sulfur.....	None

Recommended Dilutions

XTREME CUT 290 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 **XTREME CUT 290** 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:	3.0	4.0	5.0	6.0	7.0	8.0	10.0	12.0

Packaging

XTREME CUT 290 is packaged in 310-gallon, one-way tote tanks and 55-gallon, non-returnable steel drums. Bulk and 5-gallon pails are also available.



The Next Generation in Metalworking Chemistry