



## TECHNICAL DATA

# ULTRAGRIND CARBIDE

### High Performance Synthetic Grinding Fluid

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#### Description

ROCOL 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.

ROCOL Ultragrind Carbide is suitable for all types of surface, centreless and cylindrical grinding operations on hard metals.

#### Outstanding 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

ROCOL 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.

#### ROCOL Lubricants

ROCOL House, Swillington, Leeds LS26 8BS, England.

Tel: 0113 232 2600 Fax: 0113 232 2760

ROCOL is a BS EN ISO 9001 registered company.

ROCOL is a trade mark of ITW inc

The information in this publication is based on our experience and reports from customers. There are many factors outside our control and knowledge which effect the use and performance of our products for which reason the information in this publication is given without responsibility

## Technical Data (typical values)

<i>Appearance:</i>	<i>Green concentrate forming a translucent green solution</i>
<i>Odour:</i>	<i>Mild</i>
<i>pH:</i>	<i>9.3 at 20:1</i>
<i>Density at 20°C:</i>	<i>1.05 g/cm<sup>3</sup></i>
<i>Storage:</i>	<i>Store at normal ambient temperature (5°C to 30°C)</i>

## Refractometer calibration:

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

## Pack sizes and part codes

20 ltr	part code 51713
200 ltr	part code 51719

## Health and Safety

Safety data sheet is available from the Customer Service Department, ROCOL Lubricants, ROCOL House, Swillington, Leeds, LS26 8BS, England.

**Telephone:** 0113 232 2700, (When calling from outside UK: 44 113 232 2700).

**Fax:** 0113 232 2760, (When faxing from outside UK: 44 113 232 2760).

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