

# CARBIDE GRINDING FLUID 3336

## CARBIDE GRINDING FLUID

### Description

Carbide Grinding Fluid 3336 is an engineered grinding fluid possessing excellent properties with respect to swarf settling. The product does not hold metal fines in solution, allowing the metal to settle out and improve filtering and recirculation systems.

Designed specifically for carbide grinding, the product prevents cobalt leaching. Carbide Grinding Fluid 3336 is a 100 % synthetic formulation containing no oil. The oil-free nature of this product assures no "loading" of grinding wheels assuring metal removal rather than metal polishing.

A completely biodegradable material, the disposal of Carbide Grinding Fluid 3336 is not an issue. The product contains a tri-phase corrosion inhibitor package assuring no rust formation with best in class bacteria and fungus resistance.

### Features & Benefits

- Prevents cobalt leaching
- Excellent swarf settling properties
- No defatting of skin (doesn't cause dermatitis)
- Will not cause rust on machines
- No "gummy" buildup on machines
- Non foaming chemistries
- Improves filtering

### Health & Safety

See the most recent MSDS which is available directly from Precision Fluids, your local salesman, or authorized distributor. Precision Fluids uses only raw materials not listed as carcinogenic by IRAC.

### Physical Data

Appearance:	Clear Amber
Diluted Appearance:	Clear Amber
Solubility	Water
Odor:	Mild Industrial
Specific Gravity:	1.02
Concentrate pH:	9.4
pH, 5 % dilution:	8.8
Freeze/Thaw Cycles:	Passed 3x

### Application & Usage

Precision Fluids recommends using our Super Green cleaner before adding Carbide Grinding Fluid 3336 to a machine.

The recommended concentration for Carbide Grinding Fluid 3336 is 10% for optimum results. However, results for any operation can only be determined through testing.

Maintaining the coolant at its optimum concentration is achieved through daily refractive index checking.

No special precautions are necessary with respect to seals or valves.

### Refractive Index Monitoring (3.6X multiplier)

Percent	Ratio	Refractometer Reading
5	19 to 1	1.4
10	9 to 1	2.8
15	6 to 1	4.2
20	4 to 1	5.6

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