

S-500® CF *Coolant Concentrate: Water Soluble Oil, Chlorine-free*

GENERAL DESCRIPTION

- **Chlorine-Free**, Non-Toxic, Non-Irritating and Non-Corrosive.
- **Bio-stable** formulation for extended life and minimized waste.
- **Excellent rejection** of foreign contamination, including tramp oils.
- **Compatible** with all common machine tool components, including paint and seals.
- **Reduce inventories**; multi-purpose formulation eliminates need for multiple coolants.
- **Amine-free**, Phosphate-free and Nitrite-free.
- **Ideal for** continuous use recycling systems and central systems.
- **Advanced** Synthetic Extreme Pressure Additives.
- **Outstanding performance** on aluminum machining, including small drills and small taps.
- **Approved** for use in the Semi-Conductor Industry.

Approved by **Bombardier Aerospace, Lord Aerospace and Lockheed Martin.**

APPLICATIONS

Primary		Secondary	
CNC Turning	CNC Milling and Drilling	Broaching, Shaping & Slotting	Gear Cutting & Finishing
Tapping & Threading	Reaming & Boring	Drawing	Forming
Sawing & Cut-off	Light Stamping	Heavy Stamping	Fine Blanking
High Speed Machining	High Pressure Machining	Grinding, including:	
Conventional Contract Shop Applications		Centerless, Creepfeed, Surface, ID/OD and Rotary.	

MATERIALS

Primary		Secondary	
Aluminum Alloys	Tungston & Titanium	Brass & Bronze	Copper & Copper Alloys
High Temperature Alloys	Powdered Metals	Ductile Iron & Cast Iron	Refractory Metals
Nickel Alloys	Plastics & Composites	Plastics	Ceramics
Precious Metals	Molybdenum	Stainless Steels: Bhn 250 to 350	Stainless Steels: Bhn 350-450
Steels & Stainless Steels: Bhn up to 250		Steels-Bhn 250- 350	Steels- Bhn 350- 450

INSTRUCTIONS

Pre-mixing Procedures:	Recommended Concentrations:			
<ul style="list-style-type: none"> • <u>Always</u> premix coolant before adding to the machine sump. • <u>Never</u> add straight water or straight concentrate directly to the machine's sump. • For best results a Hangsterfer's recommended proportioning device should be used. • If mixing by hand, always add concentrate to water, and then agitate. 	Application	Ratio <small>Concentrate: Water</small>	%	Refractometer
	General Cutting	1:20 - 1:10	5% - 10%	5 - 10
	Severe Cutting	1:10 - 1:5	10% - 20%	10 - 20
	General Grinding	1:40 - 1:20	2.5% - 5%	2.5 - 5
	General Deformation	1:40 - 1:10	2.5% - 10%	2.5 - 10
	Severe Deformation	1:10 - 1:5	10% - 20%	10 - 20

Make-up Procedures:

<ul style="list-style-type: none"> • It is important to remember that as water evaporates from the coolant, the concentration will increase. • To maintain the recommended concentration in the machine, make-up coolant should be pre-mixed at half the % concentration as the initial fill. • To maintain 6% in the machine, first charge the machine at 6%, then add make-up at 3% to keep the machine full. This will keep the machine at 6%. • Never add just straight water to reduce the concentration, always add a light pre-mixed coolant 	<p>Hangsterfer's Accumix 14100 is a premium piston-style proportioning device that insures proper proportioning and mixing of the water and concentrate. A tight, stable emulsion is the result.</p>
	<p>Hangsterfer's Basic Refractometer measures concentrations from 0% to 18% and is one of the most important tools a shop can have in regards to coolant maintenance.</p>
	<p>Hangsterfer's Basic Belt Skimmer removes tramp oil from the machine sump as it accumulates. Take advantage of the tramp oil rejecting properties of the coolant and maximize sump life.</p>

MAINTENANCE

S-500 CF is a biostable coolant, designed to control the growth of bacteria. Regular maintenance is required for maximum performance. Concentration should be monitored regularly with a calibrated refractometer. S-500CF gives a direct read on the refractometer (e.g. 5=5%). Tramp oils should be removed from the coolant surface regularly to prevent unwanted bacterial growth. Keep the coolant system free of cleaners, solvents and other contaminants.

PRODUCT CHARACTERISTICS				
Product	S-500 CF	Concentration Dilution Table		
Form	Liquid			
Color	Green			
Odor	Mild	%	Ratio	Refractometer
Specific Gravity	0.94	20%	1:5	20
Viscosity: SUS @ 100°F	220	15%	1:7	15
cSt @ 40°C	48	10%	1:10	10
Flash Point, COC, °F/°C	325 / 162	7.5%	1:13	7.5
Fire Point, COC, °F/°C	345 / 173	5%	1:20	5
Pour Point, °F/°C	<0 / -18	4%	1:25	4
Solubility in Water	100%	3%	1:33	3
Boiling Point, °F/°C	289 / 143	2.5%	1:40	2.5
Vapor Pressure, mm Hg @ 25°	<0.01	2%	1:50	2
pH @ 10%	9.1	1%	1:100	1

SHIPPING UNITS

S-500 CF is available in 5 gallon, 55 gallon and Intermediate Bulk Containers (275 or 330 gallons). All products are distributed worldwide.

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