

# PRODUCT DATA

## SCF 2602-47-02

### HEAVY-DUTY VEGETABLE-OIL BASED MACHINING AND GRINDING FLUID FOR USE WITH ALL METALS INCLUDING AUTOMOTIVE GRADE CAST ALUMINUMS

Many of today's modern machine shops require the use of one coolant capable of working in many applications on a wide variety of metals. **SCF 2602-47-02** is such a product. Whether you're cutting high or low carbon steels, alloy steels such as 4130 and 4140; cast iron, nodular iron and gray iron; 300 and 400 series stainless steel, **SCF 2602-47-02** is the choice. It is especially suitable when machining automotive grade aluminum cast alloys including 308, 319, 356, 380, 384 and 390.

**SCF 2602-47-02** is formulated from vegetable oil with a combination of ingredients that provide a greater resistance to microbial degradation of the fluid.

Tests have shown that the synergies of the components in this product will reduce the frequency of sumpside additions of antimicrobial agents.

**SCF 2602-47-02** is compatible with hard water, is clean running and biostable, which assures long, odor-free sump life. It provides corrosion protection without staining and affords superior lubrication which will yield improved tool life and part finish. Low foaming characteristics make **SCF 2602-47-02** an excellent choice for gun drilling and other high pressure applications.



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**FEATURES**

Clean running/low foam  
Excellent corrosion protection  
Excellent machining capabilities

**BENEFITS**

Reduced disposal cost/less  
down time/operator acceptance  
In-process protection of  
machinery and parts  
Increased tool life;  
improves surface finish

**TYPICAL PHYSICAL AND CHEMICAL PROPERTIES**

Appearance	
Neat	Amber liquid
5% Emulsion	Whitish emulsion
pH	
Neat	9.8
5% Emulsion	9.3
Pounds per Gallon, 60°F	8.3

**RECOMMENDED USE CONCENTRATION**

Machining	20:1
Grinding	30:1

**CONCENTRATION CHECKS**

The refractometer factor for **SCF 2602-47-02** is 1.4. Multiply the refractometer reading by this factor to obtain the emulsion concentration in percent.

**SHELF LIFE**

Under normal conditions, the recommended shelf life for **SCF 2602-47-02** is six (6) months.

**SHIPPING INFORMATION**

**SCF 2602-47-02** is shipped in 55 (U.S.) gallon (208 liter) steel drums and in bulk.



**SHIPPING CLASSIFICATION**

Metal Cutting and Drawing Compound

**STORAGE/HANDLING/DISPOSABILITY**

No health or safety hazards exist when **SCF 2602-47-02** is stored, used and disposed of in accordance with instructions given on the Material Safety Data Sheet for this product.

**WARRANTY**

The information given here is considered to be correct and is offered for your consideration, investigation and verification. No warranties are expressed or implied, since the use of our products is beyond our control. Statements concerning the use of Houghton products are not to be construed as recommending the infringement of any patent.

**EXPORT STATEMENT**

This commodity and its technology are subject to the export control laws and regulations of the United States Government. Buyer agrees that it shall not make any disposition, by way of export, diversion, transshipment, re-export or otherwise, except as expressly permitted under United States law.

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