

S-1001 *Coolant Concentrate: Water Soluble Oil*

FEATURES

- Low Foam
- High Content of Extreme Pressure Additives
- Non-Toxic
- Non-Corrosive
- Improve Surface Quality
- Increases Tool Life
- Rejects Tramp Oil
- Long Sump Life

GENERAL DESCRIPTION

Hangsterfer's S-1001 is the first choice in heavy-duty performance oriented soluble oils. This premium grade coolant is designed to provide excellent results in difficult applications in a production environment. The biostable formula offers extended sump life, reduced coolant consumption and minimal waste. This makes S-1001 ideal for continuous use recycling systems. Operator safety and machine components are not compromised, as S-1001 is both non-toxic and non-corrosive.

APPLICATIONS

Primary		Secondary	
CNC Turning	CNC Milling & 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 that includes: Centerless, Creepfeed, Surface, ID/OD, Rotary	

MATERIALS

Primary		Secondary	
Aluminum Alloys	Steel, all forms	Brass, Bronze & Copper Alloys	Precious Metals
High Temperature Alloys	Powdered Metals	Ductile Iron & Cast Iron	Plastics & Composites
Nickel Alloys	Tool Steel/High Speed Steel	Ceramics	Refractory Metals
Stainless Steel	Titanium	Glass	
Chromium Alloys	Molybdenum	Steels-Bhn up to 250	
Refractory Metals	Stainless Steels: Bhn up to 250		
Tungston			

INSTRUCTIONS

Always premix coolant before adding to the machine sump. When mixing coolant by hand it is important to always add the concentrate to the water and then agitate. For best results a Hangsterfer's recommended proportioning unit should be used. To maintain recommended concentration, make-up should be added at one-half the desired concentration. To maintain 6%: first charge the machine at 6%, then as needed add make-up at 3%. Never add straight water or concentrate directly to machine.

MAINTENANCE

S-1001 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-1001 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-1001	Concentration Dilution Table		
Form	Liquid			
Color	Green			
Odor	Mild			
Specific Gravity	1.03	%	Ratio	Refractometer
Viscosity: SUS @ 100°F	395	20%	1:5	20
cSt @ 40°C	85	15%	1:7	15
Flash Point, COC, °F/°C	320 / 160	10%	1:10	10
Fire Point, COC, °F/°C	370 / 187	7.5%	1:13	7.5
Pour Point, °F/°C	<0 / -18	5%	1:20	5
Solubility in Water	100%	4%	1:25	4
Boiling Point, °F/°C	284 / 140	3%	1:33	3
Vapor Pressure, mm Hg @ 25°	<0.01	2.5%	1:40	2.5
pH @ 10%	9.3	2%	1:50	2
Chlorine	Added as EP Additive	1%	1:100	1

SHIPPING UNITS

S-1001 is available in 5 gallon, 55 gallon and Intermediate Bulk Containers (275 or 330 gallons). All products are distributed worldwide.

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