

# XTREME CUT 271

## Premium Extreme Duty Multi-metal Semi-Synthetic

### Performance Benefits

- Operator friendly- this product has virtually no odor in use and is very mild to the skin
- Unsurpassed tool life and surface finishes
- Excellent corrosion control for ferrous metals and machine tools
- Residue free parts and machine tools
- Extremely low foaming, even in high pressure application and in soft water
- Hard water stability up to 35 grains
- Minimal dermal irritation potential promotes operator acceptance

XTREME CUT 271 is an ultra high performance semi-synthetic fluid designed for rigorous machining applications on all metals. The product contains significant levels of extreme pressure and polar additives for machining operations that require multi-dimensional lubrication needs. Extreme machining performance is achieved through the use of unique chlorine and sulfur additive chemistry. XTREME CUT 271 will provide the performance level of heavy-duty soluble oils without unpleasant odors or high usage rates. This unique product combines new proprietary lubricant additives along with extreme pressure additives to give the best surface finishes and tool life of any water based metalworking fluid on the market. XTREME CUT 271 has excellent bioresistance resulting in long fluid life in central systems and individual sumps as well as a tight, stable emulsion that imparts excellent tramp oil rejection and stability.

### Typical Characteristics

Appearance of concentrate .....	Clear, amber viscous liquid
Appearance of emulsion.....	Semi-translucent
Density .....	8.19 lbs./gal
Specific gravity.....	0.972-0.992
pH of 5% emulsion.....	8.9-9.3
Chlorine, Sulfur.....	Yes
Diethanolamine, Formaldehyde Release Biocides, Mercurials, Nitrite, Phenols, Phosphates, Silicones,.....	None

### Recommended Dilutions

XTREME CUT 271 is to be mixed with water for use (add concentrate to water)

Grinding:	3-5%
Machining:	4-12%

### Concentration Control

The chart below was prepared using an Atago Master M refractometer and dilutions of XTREME CUT 271 in distilled water. Refractometer readings can vary with the type of water and refractometer used. Atago Master M refractometers are available from QualiChem, Inc.

CONCENTRATION %:	3	4	5	6	7	8	10	12
REFRACTOMETER READING:	3.0	4.0	5.0	6.0	7.0	8.0	10.0	12.0

### Packaging

XTREME CUT 271 (Formerly Q-CUT 271) is packaged in 310-gallon, one-way tote tanks and 55-gallon, non-returnable steel drums. Bulk and 5-gallon pails are also available.

**QUALICHEM**  
Metalworking Fluids

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