

XTREME GRIND 321

Environmentally Friendly Premium Grinding Synthetic

Performance Benefits

- Operator friendly- this product has virtually no odor in use and is very mild to the skin
- Excellent size control and part quality resulting from state of the art technology
- Low usage rates promote low cost in-use and reduced chemical consumption as compared to petroleum oil based products
- Long fluid life in both central systems and individual sumps supports lower disposal volumes which minimizes environmental impact
- Exceptionally clean parts and machine tools often eliminates the need to use harsh chemicals for post cleaning processes
- Wheels kept clean and free cutting due to excellent detergency
- Low foaming in both soft and hard water
- Complete rejection of tramp oil allowing for safe disposal of waste oils
- Formaldehyde free to comply with environmental standards and promotes excellent operator health and safety
- Bimetallic corrosion protection for parts and machine tools

XTREME GRIND 321 is a full synthetic grinding fluid designed for use on ferrous metals. XTREME GRIND 321 does not contain any petroleum oil, making it environmentally friendly. This oil-rejecting fluid provides excellent in-process corrosion protection for parts and machine tools. XTREME GRIND 321 runs exceptionally clean, has excellent bioresistance and is virtually non-foaming. The product has been formulated with aquatic friendly surfactants specifically selected to promote rapid chip settling, good flushing properties, reduced cycle times, and improved G ratios. XTREME GRIND 321 can also be used for light duty machining operations.

Typical Characteristics

Appearance of concentrate.....	Dark blue liquid
Appearance of dilution.....	Transparent to slightly opaque, blue
Density	8.70 lbs./gal
pH of 5% solution.....	9.1-9.5
Chlorine, Diethanolamine, Formaldehyde Release Biocides, Mercurials, Nitrite, Phenols, Phosphates, Silicones, Sulfur.....	None

Recommended Dilutions

XTREME GRIND 321 is to be mixed with water for use (add concentrate to water)
Grinding: 3-7%

Concentration Control

The chart below was prepared using an Atago Master M refractometer and dilutions of XTREME GRIND 321 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
REFRACTOMETER READING:	1.1	1.5	1.9	2.2	2.6

Packaging

XTREME GRIND 321 (Formerly Q-COOL 321) is packaged in 310-gallon, one-way tote tanks and 55-gallon, non-returnable steel drums. Bulk and 5-gallon pails are also available. An undyed version is also available as XTREME GRIND 321C.

QUALICHEM
Metalworking Fluids

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