



PRO-CHEM-CO, INC.

TECHNICAL DATA

PRO-CUT 606

SYNTHETIC MACHINING & GRINDING COOLANT

DESCRIPTION:

PRO-CUT 606 is a medium-duty, synthetic machining and grinding coolant for ferrous and non-ferrous metals. PRO-CUT 606 is an “oil free” product that runs cleaner, lasts longer, and is more versatile than conventional oil containing coolants. PRO-CUT 606 provides unique extreme pressure lubrication and part finishes in CNC machining operations.

BENEFITS:

- Outstanding corrosion protection
- Outstanding tramp oil separation
- Non-foaming at high pressure
- Biocide package controls bacteria & fungi
- Heat treatable film
- Optimal tool & wheel life
- Extremely clean running
- Unique lubricity without oil
- Outstanding hard water stability
- Low surface finishes

OPERATIONS:

- CNC Machining
- Gang Drills
- Tube and Pipe Mills
- Creep Feed Grinding
- Machining Centers
- Roll Forming
- Gun Drilling
- Turning Centers
- Sawing
- Central Systems
- FMS
- Mills

DIRECTIONS FOR USE:

Clean and disinfect sump with PRO-CHEM-CO Machine Cleaner, rinse out thoroughly then add fresh PRO-CUT 606 at the appropriate concentration. The concentration chart below offers a rough starting point. We always recommend the use of a refractometer and good coolant management practices.

* Note – Contact your sales representative for sump cleaner, refractometers, or coolant dispensers.

Recommended Starting Dilutions					
OPERATION	CAST IRONS & COPPER ALLOYS	CARBON & TOOL STEELS	SUPER ALLOY & STAINLESS STEELS	ALUMINUM ALLOYS	TITANIUM & NICKEL ALLOYS
Grinding (Surface/Cylindrical/ Disk/Creep Feed)	2% - 3% (1:40 - 1:30)	2% - 4% (1:40 - 1:25)	3% - 4% (1:30 - 1:25)	2% - 4% (1:40 - 1:25)	3% - 5% (1:30 - 1:20)
CNC Turning Milling, Drilling	4% - 6% (1:25 - 1:17)	5% - 7% (1:20 - 1:14)	5% - 8% (1:20 - 1:12)	6% - 7% (1:17 - 1:14)	5% - 8% (1:20 - 1:12)
General CNC/Sawing Roll Forming	5% - 7% (1:20 - 1:14)	5% - 7% (1:20 - 1:14)	5% - 8% (1:20 - 1:12)	6% - 7% (1:17 - 1:14)	5% - 8% (1:20 - 1:12)
Tapping/Knurling Reaming/Boring	5% - 7% (1:20 - 1:14)	6% - 8% (1:17 - 1:12)	7% - 10% (1:14 - 1:10)	7% - 10% (1:14 - 1:10)	7% - 10% (1:14 - 1:10)

PROPERTIES:

Appearance ----- Opague, green liquid
 Odor ----- Characteristic
 pH (Conc) ----- 9.2
 pH (1:20) ----- 8.9
 Specific Gravity ----- 1.039
 Solubility ----- Complete at all proportions

PACKAGING:

PRO-CUT 606 is available in 5-gallon pails, 55-gallon drums, totes and bulk.