

VULSOL 3500 S



METALWORKING



TOTAL

Moderate-Duty, Synthetic Metalworking Fluid for Ferrous Metals

APPLICATIONS

- **VULSOL 3500 S** represents the most up-to-date technology in the development of synthetic metalworking fluids. Formulated with specially selected components, it produces a clear solution in all types of makeup water and contains no nitrites, phenols, or heavy metals.
- **VULSOL 3500 S** is recommended for the moderate machining and grinding of ferrous metals. It will also perform well in cutting and grinding aluminum. It contains a strong rust inhibitor package, anti-weld agents, lubricity additives, and extreme pressure additives that provide outstanding boundary lubrication during the machining process.

ADVANTAGES

- Resistant to microbiological growth.
- Excellent extreme pressure protection.
- Increases tool life, prevents ridging, promotes good surface finish.
- Excellent lubricity properties--Increases the tool life on a large scale of cutting parameters maintaining an additive layer on the chip / workpiece / tool surface.
- Contains no sulfur, chlorine, nitrites, phenols, or heavy metals.
- Protects workpiece and tools against corrosion.
- Long sump life.
- Low foaming fluid.
- Non-staining.
- Permits operator surveillance of the workpiece at all times.
- Light viscosity means good flushing ability.

TYPICAL CHARACTERISTICS	VULSOL 3500 S
Appearance	Clear to slightly hazy liquid
Specific Gravity @ 60°F/60°F	1.008
Density @ 60°F, lbs./gal.	8.397
Flash Point, COC, °F	None
Chlorine, %wt.	None
Sulfur, %wt.	None
pH @ 5%	8.6
Refractive Index @ 5%	2.2
Refractive Index @ 10%	4.3
Refractive Index Factor	2.3

Standard dilution of water to concentrate is 20:1. May be mixed satisfactorily from 10:1 to 25:1 depending on the type and severity of the operation. For grinding operations, 25 to 30 parts water to 1 part **VULSOL 3500 S** is recommended. The concentration should be adjusted as necessary to maximize performance.

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