



EMBLEM SYNCUT

EMBLEM Syncut is a true synthetic metalworking fluid that may be further diluted with water to form a clean, blue-green solution that is effective for medium to heavy duty machining and grinding of ferrous and non-ferrous metals. **EMBLEM** Syncut provides excellent extreme pressure lubricity and boundary lubrication for extended tool life. When used for grinding, the fluid provides effective cooling and cleanliness, promoting open, free grinding for maximum "G" ratios. Parts and machinery are protected from rust, and machine tool operators will appreciate the mildness of this moderately alkaline fluid.

EMBLEM Syncut can be blended with water (either hard or soft) to form a transparent machining and grinding coolant that will offer the following features:

* Excellent tramp oil rejection properties. * Low foaming properties. * Excellent rust control. * Compatible with all metals. * 100% Synthetic-biodegradable. * Excellent EP and lubricity properties. * Clean running - grinding wheels stay clean. * No residue on machines.

Recommended dilutions in the shop

General Machining	25:1 (4%) to 20:1 (5%)
Reaming, tapping, broaching	20:1 (5%) to 10:1 (10%)
Grinding	30:1 (3%) to 20:1 (5%)

Disposing of used mixes - A simple in-house process

EMBLEM Syncut does not contain phenolic ingredients, nitrites, phosphates or heavy metals. None of the materials contained in this mildly alkaline product are classified as potentially hazardous wastes. Contaminating lubricants and hydraulic oils are easily removed by skimming. Many localities may only require removal of floating oils before blending the fluid into the normal flow or waste water from your plant.

In some areas, it is necessary to remove all traces of alkalinity before dumping watery wastes. For these areas, we suggest the following procedure.

Skim the floating oils as above. To the remaining clarified water, neutralize to pH 7.0 by adding hydrochloric acid. A commercial grade of hydrochloric acid is generally available at hardware stores and lumber yards as "muriatic acid", used for washing excess mortar from new brickwork. Approximately two quarts of muriatic acid should be enough to neutralize 100 gallons of a used 5% mix of **EMBLEM** Syncut. Add a small amount of acid at a time and check your progress by using a pH indicator paper. When you reach neutral pH of 7.0, you are ready to bleed into your plant waste effluent. Plants that have plating departments may wish to use their spent acid pickling solution instead of the hydrochloric acid, thus solving two disposal problems. Whatever process is used, the procedure should satisfy the requirements of most sanitary districts for the

disposal of watery waste effluents. We suggest you check with your own sanitary district; you may find a greater or lesser degree of treatment will meet their requirements.