



Goldcut™ 309 is a long life, semi-synthetic water miscible, metalworking fluid concentrate that produces an ultra-stable translucent micro emulsion. This product is also chlorine free.

Goldcut™ 309 is suitable for sawing, turning, milling, drilling and threading, general purpose surface, cylindrical and centreless grinding on ferrous alloys including cast iron. Its performance on cast iron is excellent.

Key Benefits

- Ultra Long Sump Life
- Improved Tool Life
- Highly Stable Micro-Emulsion
- Operator Friendly
- Excellent Corrosion Protection
- Low Foam in soft water.
- Reduced Sticky Deposits
- Less Product Loss due to Draw-Out

Typical Applications

- | | |
|---|------|
| • General Machining | 4-6% |
| • Grinding: - cylindrical, centreless, surface. | 3-5% |
| • Milling and threading | 5-6% |

Typical Data

Concentrate

Appearance	Red Fluid
Specific Gravity	~1.01
Mineral Oil Content %	~15

Emulsion

Appearance	Red liquid
pH at 5%	9 – 9.3
IP287 pass at %	30:1
Refractometer Factor	2.3 = 20:1

Emulsion Type

- Micro-emulsion
- Low Oil Content
- Chlorine-free EP additives.

Compatibility

- Ferrous metals including stainless steel, mild steel and cast iron.
- Cuprous alloys
- Aluminium
- Plastics

General Compatibility

- Waters from 40ppm to 400ppm (Calcium hardness)
- Low foaming tendency
- Suitable for high pressure applications
- Suitable for low pressure applications

Health and Safety

Full health and safety data sheet is available on request.

Storage

- Store indoors
- Store between 4°C and 35°C
- Shelf life is 6 months from date of supply
- Store undercover or if outdoors on its side.