Q-CUT 235C is a general purpose, moderate duty semi-synthetic cutting and grinding fluid for ferrous metals and most non-ferrous metals. The product is designed for use in central systems and individual sumps. Q-CUT 235C is designed for use on a wide range of metals, which makes it well suited for job shop operations. Typical operations include centerless grinding, cylindrical grinding, internal grinding, surface grinding, drilling, milling, sawing, and turning. The product contains a new generation of additive technology to improve tool life and part quality without the problems associated with extreme pressure additives such as chlorine, sulfur, and phosphorous. The fluid forms a stable emulsion in hard and soft water. Q-CUT 235C has good biological resistance to ensure long fluid life.

**Typical Characteristics**

- Appearance of concentrate: Light Amber
- Appearance of emulsion: Translucent
- Density: 8.32 lbs/gal
- pH of 5% emulsion: 8.8-9.2

Chlorine, Diethanolamine, Mercurials, Nitrite, Phosphate, Silicones, Formaldehyde: None

**Recommended Dilutions**

Q-CUT 235C is to be mixed with water for use (add concentrate to water)

- Grinding: 3-5%
- Machining: 4-12%

**Concentration Control**

The chart below was prepared using an Atago Master M refractometer and dilutions of Q-CUT 235C in distilled water. Refractometer readings can vary with the type of water and refractometer used. Atago Master M refractometers are available from QualiChem, Inc.

<table>
<thead>
<tr>
<th>CONCENTRATION %:</th>
<th>3</th>
<th>4</th>
<th>5</th>
<th>6</th>
<th>7</th>
<th>8</th>
<th>10</th>
<th>12</th>
</tr>
</thead>
<tbody>
<tr>
<td>REFRACTOMETER READING:</td>
<td>1.7</td>
<td>2.2</td>
<td>2.8</td>
<td>3.4</td>
<td>3.9</td>
<td>4.5</td>
<td>5.6</td>
<td>6.7</td>
</tr>
</tbody>
</table>

**Packaging**

Q-CUT 235C is packaged in 310-gallon, one-way tote tanks and 55-gallon, non-returnable steel drums. Bulk and 5-gallon pails are also available.