**Q-CUT 246C**

**High Performance Semi-Synthetic with EP**

Q-CUT 246C is a high oil containing semi-synthetic for machining and grinding ferrous and non-ferrous metals. This product utilizes state of the art raw materials to eliminate the rancidity and cleanliness issues associated with most soluble oils and semi-synthetics. The product is designed for use on a wide range of metals, making it well suited for job shop operations. Q-CUT 246C is non-staining to sensitive aerospace alloys, aluminum (including 319, 356, 6061T-6, 7075), and yellow metals. The product also has excellent corrosion control for ferrous metals. Q-CUT 246C contains an extreme pressure additive to improve tool life and part quality in difficult applications. The fluid has a tight emulsion to promote tramp oil rejection and exhibits excellent hard water stability up to 35 grains of hardness. Q-CUT 246C runs clean, has excellent bioresistance, and is non-foaming.

**Typical Characteristics**

- Appearance of concentrate: Yellow liquid
- Appearance of emulsion: Semi-translucent
- Density: 8.26 lbs./gal
- pH of 5% emulsion: 8.7-9.1
- Nitrite, Phenols, DEA, formaldehyde: None
- Silicons: None

**Recommended Dilutions**

Q-CUT 246C 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 246C 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>2.6</td>
<td>3.5</td>
<td>4.4</td>
<td>5.3</td>
<td>6.2</td>
<td>7.0</td>
<td>8.8</td>
<td>10.6</td>
</tr>
</tbody>
</table>

**Packaging**

Q-CUT 246C is packaged in 310-gallon, one-way tote tanks and 55-gallon, non-returnable steel drums. Bulk and 5-gallon pails are also available.