



METAL WORKING FLUID

AUTHORIZED DISTRIBUTOR

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SUNCOOL GF-100

(JIS W3-2)

"New type cutting oil containing no nitrite"

SUNCOOL GF-100 is a solution type cutting oil which do not invite nitrosamine formation. Excellency in anti-rust effect, smoothness in cutting, and no foaming are well known characteristics of this product.

◆ TYPICAL ANALYTICAL DATA

Appearance (when diluted):	Clear transparency
Specific gravity 15/4 °C	1.15
pH (diluted 50/1)	9.6
Surface tension dyne/cm	70.8

◆ APPLICATION & RATE OF DILUTION

General cutting work of cast iron :	30 ~ 50
General cutting work of steel :	40 ~ 80

◆ RUST PREVENTIVE TESTS (methods and result)

1. Chip Test

Place deoiled and cleaned 20g of cast iron (F-20) chips on filter paper covered tray. Pour solution on chips to dampen well and leave then for 30 minutes, then remove the solution and cover the chips with a Schale. There-after visually observe the degree of rusting condition by the time.

30/1 dilution	72 hours :	The oil result in no change
50/1 dilution	48-72 hours :	The oil result in rust on a few chips

2. Match test

Well polish and deoil a cast iron (FC-20) plate. Pour 1 - 2 ml of the solution on the plate, treat another plate same way and place it on the other plate face to face. After leaving 24 hours, observe the degree of rust appearance on the contacted surfaces.

30/1 dilution	The oil result in no change at all
50/1 dilution	The oil result in a negligible change