



Perkool 627

Synthetic Cutting & Grinding Fluid

GENERAL DESCRIPTION

Perkool 627 is a heavy duty, oil-rejecting, synthetic cutting and grinding fluid developed for use in especially severe operations on all ferrous metals and difficult to machine exotic alloys.

Perkool 627 provides outstanding performance in some of the most difficult machining operations and will replace straight cutting oils in many applications.

PRODUCT INTEGRITY

Perkool 627 is a new generation product specifically designed with the highest quality raw materials to *focus* on high performance and outstanding operator acceptance. **Perkool 627** uses premium raw materials that significantly improve key physical characteristics unique to cutting fluids. **Perkool 627** requires no additives to remain protected from bacteria, mold, and fungus and it remains water clear even when confronting major tramp oil contamination or long periods of fluid inactivity.

PERFORMANCE FEATURES

CLEANLINESS

Perkool 627 significantly reduces product residues and easily splits tramp oils. Clean, no odor, and no gummy residues results in high operator acceptance. Has high performance consistency because there is no depletion of vital fluid components. Any residues that do accumulate remain soft and are easily removed by rinsing with water.

CORROSION PROTECTION

Perkool 627 provides excellent in-process corrosion protection to ensure no rust on parts and no staining of machine surfaces.

FOAM & MIST

Perkool 627 is a very low foaming and low misting product. Operators can see the work more clearly and less mists results in a haze-free shop making for a safer work environment.

ODOR

Perkool 627 reduces odors, both in fresh system charges and in continued use. It is exceptionally resistant to bacteria, mold and fungus and remains clean and odor free for extended periods of time. It is also very gentle to operator's skin and has virtually no odor when mixed at typical use concentrations.

EMLUSION STABILITY

Perkool 627 greatly reduces selective component depletion that leads to increased product usage which allows for consistent performance. **Perkool 627** remains clear and stable in all water conditions from soft to hard, even when contaminated with tramp oil.

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RECOMMENDED APPLICATIONS

Perkool 627 is designed for machining and grinding of all ferrous applications, where bio-stability, cleanliness, corrosion prevention, low odor, and high operator acceptance are primary concerns. Broaching, centerless grinding, deep hole drilling, gear hobbing, gun drilling, honing, internal grinding, lapping, micro-sizing, reaming, tapping, and threading are typical applications.

TYPICAL CHARACTERISTICS

HEALTH & SAFETY	RESULT
Caprylic Acid	None
Dyes	None
Phosphorous	None
Sulfur	None

HEALTH & SAFETY	RESULT
Chlorine	None
Formaldehyde	None
Nitrites	None
Phenols	None

HEALTH & SAFETY	RESULT
DEA	None
MEA	None
Perfumes	None

TEST	RESULT
Appearance of Concentrate	Clear, Yellow Fluid
pH of Concentrate	8.6
Appearance at 5% Dilution	Clear
pH at 5% Dilution	7.9
Foam at 5% Dilution	Low, Quick
Lbs per gallon	8.5

RECOMMENDED DILUTIONS

- For machining applications the recommended dilution is 4 - 10%
- For grinding applications the recommended dilution is 3 - 5%
- For severe machining applications the recommended dilution is 8 - 12%

CONCENTRATION CONTROL

It is always important to adjust (zero) the refractometer with plant (make-up) water prior to testing the product. The refractometer reading should be multiplied by 1.54 to determine the concentration of the **Perkool 627** "working" fluid.

REFRACTOMETER READING	% CONCENTRATION
2.0	3%
3.2	5%
4.5	7%
6.5	10%

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