

ULTRACUT® 390H

General purpose, semi-synthetic cutting fluid

Applications

ROCOL® ULTRACUT 390H is a high quality, semi-synthetic, general purpose water mix cutting fluid formulated to give a long and predictable sump life with inherent resistance to degradation.

ULTRACUT 390H is designed for medium-duty cutting operations on a wide range of ferrous and non-ferrous metals, especially cast iron.

ULTRACUT 390H forms a translucent, fluorescent green micro-emulsion when mixed with water which provides a clear view of the workpiece.

ULTRACUT 390H contains refined mineral oils and has a unique corrosion inhibition package.

Features and Benefits

- ULTRACUT 390H provides a long and predictable sump life.
- Compatible with both hard and soft water.
- ULTRACUT 390H is suitable for a wide range of materials.
- Excellent residual corrosion protection.
- Inherently resistant to degradation.
- ULTRACUT 390H emulsifies tramp oil.
- Extends tool life.
- Low foaming.
- Pleasant and safe to use.

Usage Guidance

- ULTRACUT 390H should be used between 30:1 and 40:1 depending on the severity of operation, workpiece material and water hardness.
- To ensure dilution accuracy, it is preferable to use a ROCOL Automatic Fluid Mixer. For manual mixing, add the concentrate to the water at the recommended dilution ratio, stirring continuously.
- It is advisable to use the appropriate ROCOL ULTRAGUARD® Machine Tool Care product at fluid changeovers. Optimum fluid life is obtained by adequate initial machine cleaning, correct dilution control and regular maintenance of the fluid, particularly prior to weekends and shutdown periods.

Storage Guidance

- ULTRACUT 390H should be stored in a cool, well-ventilated area, between +5°C and +30°C, in the original container.
- If stored in accordance with the above guidelines, shelf life is 1 year from date of manufacture.

Approvals and Certifications

List any key industry and/or OEM approvals and certifications

Pack Sizes

Part Code	Pack Size
51296	5L
51299	200L

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Registered Office: Saxon House, 2-4 Victoria Street, Windsor, England, SL4 1EN



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Parameter	Test Method	Value
Appearance:		
Concentrate	N/A	Green liquid
Mixed with water	N/A	Translucent green emulsion
Odour	N/A	Mild
pH	N/A	9.3 at 15:1 dilution
Density at 20 °C (g/cm ³)	N/A	1.00

Refractometer Calibration

Dilution Ratio	25:1	30:1	35:1	40:1	45:1
Refractometer Reading	4.1	3.0	2.8	2.4	2.2

Safety Datasheets

These are available at <https://www.rocol.com/datasheets>. For further assistance, please contact us via the Rocol website or using the details below.

Note

The information in this Technical Datasheet is informed by our experience and feedback from industry. There are many variables outside our control or knowledge which affect the use and performance of our products, for which reason it is given without responsibility. Values quoted are typical and do not constitute a specification.

If you'd like to discuss the suitability of any Rocol solution for your system, please get in touch.

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