

**TECHNICAL DATA SHEET**
REL COOL #3™

Chlorine-Free Soluble Oil

Description:

Rel Cool #3 is premium grade soluble oil, which exhibits excellent performance characteristics, equaling and exceeding soluble oils containing chlorinated paraffins. However, REL COOL contains no chlorinated or sulfurized additives. Also, the incorporated biocide package promotes longevity in single sumps as well as central systems.

Typical Uses:

- Recommended for any medium to heavy duty applications such as: milling, turning, boring, drilling, reaming, broaching, and sawing on ferrous metal ranging from cast irons to tool steels and even on tough to machine stainless steel.

Typical Inspections:

Specific Gravity, 60/60F:	0.94
Density (lb./gal):	7.8
pH Value, 5% emulsion:	9.2
Acid Value (meqKOH/g):	14.0
Total Alkalinity (meqHCL/g):	4.0
Appearance:	Clear Amber Fluid

Technical Data Sheet - REL COOL #3 (Chlorine-Free Soluble Oil)

Operating Recommendations:

- For milling, sawing and drilling operations, dilute Rel Cool #3 concentrate with water at a ratio of 25:1 – 20:1
 - For boring, and turning operations, dilute Rel Cool #3 concentrate with water at a ratio of 25:1 – 16:1.
 - For reaming, broaching or stainless operations dilute Rel Cool #3 concentrate with a water ratio of 12:1 – 8:1.
 - Check fluid concentration with hand-held refractometer. For best protection against biological problems, keep concentration above 25:1 dilution (4% volume)
 - Check fluid's alkalinity with pH paper, pH value should range between 8.7 – 9.2 for optimum performance
 - Always add product to water; never water to product when making emulsions
-
-

Features:

- Is stable in soft to very hard water conditions
- Designed to perform as well as highly chlorinated soluble oils
- Promotes cleaner running machines compared to conventional soluble oils
- Long emulsion life

REL COOL #3
Soluble Oil
5/01/99
Updated: 07/22/05
04/01/08

317 Rolyn Place • Arcadia, CA 91007-2838 / P.O. Box 60019 • Arcadia, CA 91066-6019
PHONE: (800) 423-1505 • FAX: (626) 446-9671
e-mail reltoninfo@relton.com