

CT 250 ND

CHLORINATED SOLUBLE OIL FOR MACHINING/GRINDING APPLICATIONS ON ALL METALS

▶ PRODUCT DESCRIPTION

CT 250 ND is a water emulsifiable, soluble oil cutting and grinding fluid. CT 250 ND exhibits a balanced lubrication regime of both boundary lubricant additives and chlorine for extreme pressure requirements. CT 250 ND forms a clean and stable emulsion in all water types and is formulated with a non-formaldehyde biocide to extend the serviceable sump life of the emulsion.

CT 250 ND combines tenacious film strength with improved cooling capacity found only in water reducible products. It is particularly well suited for a variety of cutting and grinding operations such as broaching, tapping, gear shaping, deep drilling, boring, screw machining, end milling, and reaming of hard steels and nickel alloys. CT 250 ND is applicable for use on both ferrous and non-ferrous metals.

▶ FEATURED BENEFITS

- Unusually tight emulsion for a soluble oil. Improves wetting and cooling for superior tool life.
- Reduced Consumption: A stable tight emulsion reduces usage from carry out when compared with other soluble oils.
- Additive Independent: No need for tank side pH buffers, emulsifiers, or costly and hazardous biocides
- Cost effective regardless of whether you have individual sumps or large central systems
- Applicable for both ferrous and non-ferrous metal applications
- Does not contain formaldehyde releasers, nitrites, phenols or dimethyl polysiloxane

APPLICATION



COMPATIBLE METALS

Cast Iron
Carbon Steel
Tool Steel
Stainless Steel
Aluminum
Titanium
Inconel
Bronze
Copper
Brass

Machining Capabilities

Milling
Turning
Sawing
Drilling
Reaming
Tapping
OD/ID/Centerless Grinding
Burnishing
Light Duty Hobbing & Broaching
Medium-Duty Stamping & Drawing

HIGH PRESSURE COOLANT CAPABILITY

Yes

ALL METAL SAFE

Yes

REFRACT INDEX

1.00





TYPICAL PROPERTIES

Fluid Type	Soluble oil machining fluid
Appearance	Dark brown fluid
Odor	Mild
Specific Gravity, 60°F (15.6°C)	0.9564
Weight, lb/gal., 60°F (15.6°C)	7.97
Flash Point (COC)	350°F (176.7°C)
Chlorine	Present
Sulfur	Present

PRODUCT APPLICATION / USAGE

CT 250 ND is particularly well suited for a variety of cutting and grinding operations such as turning, broaching, tapping, gear shaping, deep drilling, boring, screw machining, end milling, and reaming of hard steels and ferrous alloys. CT 250 ND metal working fluid is to be mixed with water for use. Always add product concentrate to the water, not water to product concentrate. Product concentration can easily be monitored by refractometer.

Operation	High Alloy Steels/Tool Steels	Tool Steels	Non-Ferrous Alloys
Broaching, Tapping	12.5%	10%	12.5%
Gear Shaping, Deep Drilling, Form Milling, Tapping, Sawing	5%	6.7%	10%
Grinding: I.D., O.D., Centerless	5%	5%	5%

MIXING DATA

CT 250 ND metalworking fluid is to be mixed with water for use. Always add product concentrate to the water, not water to product concentrate. Add with mild agitation. Product concentration can easily be monitored by refractometer.

Concentration	10%	6%	5%	3%	2%
Refractometer Reading	10	6	5	3	2

PRODUCT CODE

2400000000

HEALTH AND SAFETY

For health and safety guidance, please refer to the Chemtool SDS (Safety Data Sheets).