

# CT 250 NCPW

NON-CHLORINATED SOLUBLE OIL FOR MACHINING/GRINDING APPLICATIONS ON ALL METALS

## ▶ PRODUCT DESCRIPTION

**CT 250 NCPW** is a high performance, heavy duty, all purpose machining soluble oil. CT 250 NCPW is ideal for moderate to heavy duty cutting, grinding, threading, broaching, forging and drawing of all ferrous metals. The CT 250 NCPW contains a balanced blend of highly refined mineral oils, extreme pressure additives, and polar boundary lubrication to maximize the machining performance.

## ▶ FEATURED BENEFITS

- Non-chlorinated additive package maximizes machining performance in severe applications
- Extends tool life
- Good surface finish
- Medium viscosity to reduce product loss from carryout
- Easy to remove/clean
- Recyclable
- Freeze-thaw stable
- Does not contain chlorine, nitrates, phenols or dimethyl polysiloxane

## ▶ APPROVALS

- Pratt and Whitney: PMC 9397 Approved
- Pratt and Whitney: PMC 9318 Rev. A Metal Cutting Compound Water-type
- Not compliant for California SCAQMD Rule 1144

## 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

### ALL METAL SAFE

Yes

### REFRACT INDEX

1.05





## TYPICAL PROPERTIES

Fluid Type	Soluble oil
Appearance	Blue-green liquid
Odor	Mild
Specific Gravity, 60°F (15.6°C)	0.92
Weight, 60°F (15.6°C)	7.66 lbs/gal.
Boiling Point	Initial = 212°F (100°C)
Flash Point	350°F (176°C)
Freezing Point	-10°F (-23°C)
pH, (5% dilution)	9.6
VOC, ASTM E 1868	94.7 grams/liter

## PRODUCT APPLICATION / USAGE

CT 250 NCPW 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.

Operation	High Alloy Steels	Tool Steels	Nickel Alloys
Broaching, Tapping	10%	10%	10%
Gear Shaping, Deep Drilling, Form Milling, Tapping, Sawing	5%	6.7%	6.7%
Grinding: I.D., O.D., Centerless	3.3%	3.3%	3.3%

## MIXING DATA

CT 250 NCPW 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%	6.7%	5%	4%	3.3%
Refractometer Reading	10.3	7.2	5.4	4.6	3.0

## PRODUCT CODE

2400700000

## HEALTH AND SAFETY

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