

# PRIMEGRIND XL



## PRODUCT DESCRIPTION

Fully synthetic grinding fluid designed for high speed, High pressure system. Capable of being used on High pressure multi axle systems.

**Primegrind XL** was specifically designed to manage any high speed grinding processes.

**Primegrind XL** was developed to manage the extreme speeds and feeds demanded in twin wheel creep feed grinding applications.

**Primegrind XL** is a fully synthetic water-mix cutting & grinding fluid that forms a true solution when diluted with water. **Primegrind XL** provides superior cooling and flushing characteristics. **Primegrind XL** provides excellent corrosion protection whilst minimising the build-up of 'sticky' residues.

Its unique formulation enables the product to be used on all high speed grinding and machining application.

The unique low foam emulsifier system does not rely on traditional antifoams for foam control. The emulsion when in use produces 50% less foam compared to similar emulsion types with a 50% repeatable rapid increase in foam collapse. To be used in both soft and hard water conditions from 50ppm – 500ppm.

## FEATURES & BENEFITS

- ✓ Chlorine free
- ✓ Sulphur Free
- ✓ Mineral Oil Free
- ✓ Formaldehyde free
- ✓ Extreme Low foam performance
- ✓ Excellent swarf settlement
- ✓ Extremely bio-stable, even under the most arduous of conditions
- ✓ Specifically designed for high pressure cooling systems

**MATERIALS & PERFORMANCE & TYPICAL PROPERTIES**

Material types	Performance rating	Applications	Dilution
Titanium	**	Tapping	10-12%
Aluminium	****	Milling	10-12%
Aero aluminium alloys	*****	Turning	10-12%
High alloy/stainless steel	****	Reaming	8-10%
Copper/brass	****	Sawing	5-7%
Cast iron	*****	Drilling	10-12%
Ferrous Materials	****	Grinding	4-6%

**TYPICAL PHYSICAL PROPERTIES**

Appearance	Yellow liquid
Emulsion Type	True Solution
Foaming Tendency @ 5% emulsion in 50ppm water	Nil foam after 5 seconds
Specific Gravity at 20°C	1.080 typical
pH @ 5%	9.3 typical
Refractometer Factor	2.5
IP 287 Corrosion Break Point, % Volume:	2.5
Reichert Lubricity Characteristics at 10% dilution;	
Noise Reduction (metres)	27
Load Bearing Capacity (Kg/mm2)	1.45

**PACK SIZES**

Primegrind XL is packed in IBC, 205 litre and 20 litre drums

**PRODUCT MANAGEMENT**

Teklube advise the use of automated mixing systems. If mixing manually, always add the concentrate to the water with maximum agitation, if water is added to the concentrate, the emulsions may prove unstable. Avoid mixing with very cold concentrate or water. Check emulsion strength using a calibrated refractometer.

**PRODUCT MANAGEMENT**

The working concentration should be carefully controlled and monitored on a daily basis as higher and lower working concentrations have health and safety implications. Machines should be cleaned out regularly. Fluid and particulate contaminants should be kept to a minimum. This is important especially in terms of bacterial control and is in line with the latest advice from government and professional sources. Detailed reference sources are quoted in the msds sheet.

