

Crystal Cut 322 BAC *Synthetic Coolant Concentrate Boeing Approved BAC 5008*

FEATURES

- High Performance Cutting and Grinding
- Hydrocarbon Free
- Non-Toxic and Non-Corrosive
- Bio-Resistant, Low to No Bacteria
- Boeing Approved/ BAC 5008 Compliant
- Boron Free, Chlorine Free, Sulfur Free
- Excellent Rust and Corrosion Protection
- Low to No Foam in High Pressure Systems

GENERAL DESCRIPTION

Hangsterfer's Crystal Cut 322 BAC is a Hydrocarbon Free Coolant Concentrate and is not dependent on petroleum oil for lubricity. Traditional petroleum oils have been replaced with advanced synthetic oils and fats. The combination of synthetic oils and fats allows for increased productivity. Crystal Cut 322 BAC is formulated to meet and exceed the needs of high speed and high pressure machining and grinding. Hydrocarbon free products can greatly reduce risk of surface contamination and improve cleaning processes. The "green chemistry" lowers our dependency on petroleum oils and can help you better comply with the ever growing regulatory issues. In addition Crystal Cut 322 BAC is REACH compliant and does not contain additives of high concern such as Boron, or other very hazardous substances.

APPLICATIONS

Primary		Secondary	
Cutting	Turning	Grinding	Punching
Drilling	Thread Cutting	Honing	Sawing
Milling	Thread Milling	Piercing	Stamping

MATERIALS

Primary		Secondary	
Aluminum	Composites	Copper	Nickel Alloys
Cast Iron	Steel	Glass	Plastic
Ceramics	Stainless Steel	Molybdenum	Titanium

INSTRUCTIONS

Premix coolant before adding to the machine sump. When mixing coolant by hand, it is important to always add the concentrate to water, and then agitate. For best results, a Hangsterfer's recommended proportionator should be used. Synthetics leave very little residue resulting in very low coolant drag out, therefore daily coolant additions are often of very low concentration. Monitor the system closely for the first few days and weeks to determine the ideal concentration that should be used for daily coolant additions. For example, to maintain 6% in the machine it usually requires less than 2% concentration added daily. Avoid adding straight water or concentrate directly to the machine sump.

OPERATION	CONCENTRATION	
	%	Refractometer
General Machining	6 to 8	1.5 to 2.0
Heavy Duty Machining	8 to 12	2.0 to 3.0
Grinding	4 to 6	1.0 to 1.5
Forming and Stamping	10 to 20	2.5 to 5.0

MAINTENANCE

Crystal Cut 322 BAC is a Bio-Resistant synthetic coolant designed to prevent the growth of bacteria. Regular maintenance is required for maximum performance. Concentration should be monitored regularly with a calibrated refractometer. Tramp oils should be removed from the coolant surface regularly to prevent unwanted bacterial growth. Keep the coolant system free of cleaners, solvents, and other contaminants.

PRODUCT CHARACTERISTICS

Product Name: Crystal Cut 322 BAC		Refractive Index Multiplier = 4.0
Form	Liquid	
Color	Amber	
Odor	Mild	Free Of: Boron Chlorine Diethanolamine (DEA) Nitrite Nitrate Ozone Depleting Chemicals PCB'S Sulfur
Specific Gravity	1.01	
Viscosity: SUS @ 100°F	35	
cSt @ 40°C	2.8	
Flash Point, COC, °F/°C	Not Flammable	
Fire Point, COC, °F/°C	Not Flammable	
Pour Point, °F/°C	32 / 0	
Solubility in Water	100%	
pH @ 10%	9.5	
Chlorine	None	
Sulfur	None	

WASTE TREATMENT

If and when it is necessary to dispose of waste coolant, the amount of coolant waste can be greatly reduced by separating the water from the additives and various contaminants which accumulate through normal machining. You can often reduce your waste by more than 80%. Hangsterfer's recommends Ultra-Filtration, Chemical Treatment, and Evaporation for removal of fats, oils, greases and metals prior to disposal of the water phase. After approval by your local, state, or federal authorities, the waste water may be sewered, and the separated oils removed for recycling or disposal.

SHIPPING UNITS

Crystal Cut 322 BAC is available in 5 gallon pail, 55 gallon drum and 275 or 330 gallon Intermediate Bulk Containers (Totes). All products are distributed worldwide.

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