



Atlantic Cool 614

Synthetic Roll Forming Fluid with Outstanding Corrosion Protection

ATLANTIC COOL 614 is an extremely safe fully-synthetic roll forming and grinding fluid developed to provide superior performance for critical machining, grinding, and roll forming applications of ferrous metals. This unique blend provides outstanding cooling and lubrication for excellent surface finish, tool life and corrosion protection. The bio-stability of this product resists depletion due to microbial action. ATLANTIC COOL 614 provides superior chip settling properties and controlled detergency to reduce tacky, gritty residues from forming during machining and grinding operations. ATLANTIC COOL 614 is highly waste treatable due to its chelant-free formulation. ATLANTIC COOL 614 resists emulsification of oil and tramp oils.

BENEFITS

- Non-amine inorganic corrosion protection that will survive a bake oven or annealing furnace up to 700°F without evaporation, discoloration, or change in performance.
- Filming inhibitor is clear and removable with direct alkaline cleaner contact, but resistant to removal from mist and incidental cleaner contact.
- Product is extremely bio-stable and odorless without DCHA, Butylamine, or other hazardous amine sources.
- EXTREMELY SAFE: Contains no hazardous listed ingredients reportable on an MSDS.

PROPERTIES

Concentrate Appearance	Clear Straw Yellow Liquid
Odor	Bland; Nil
EDTA Concentration	None
Residual Film	Fluid
pH @ 100%	9.4
Specific Gravity @ 60°F (H ₂ O=1)	1.13
Total Sulfur	None
Total Chlorine	None
Foaming	<650 Mls/ 6 Sec.
Metal Compatibility	Safe on all ferrous metals
HMIS Rating:	1,0,0
Amine Content:	None
VOC Content:	0.00-pounds / Gallon

TESTING RESULTS

- Humidity Cabinet: @ 330-Hours

95°F, 98% Humidity; 9%BV
ASTM Rating: 10 (No corrosion)

APPLICATIONS

<u>Corrosion Protection</u>	(>2-year indoor) (90 to 2-years) (30-90 days)	Ferrous Metals:	9-10% by volume
		Ferrous Metals:	5-8% by volume
		Ferrous Metals:	3-4% by volume

Minimum Lubrication Requirements

	<u>Ratio</u>	<u>Cast Iron</u>	<u>Steel</u>
Tapping, Reaming, Sawing	10:1/20:1	7%	8%
Milling, Turning	20:1/30:1	5%	6%
Grinding, Centerless, I.D and O.D.	20:1/40:1	3%	4%
Roll Forming	20:1/40:1	3%	3%

REFRACTOMETER READING

2%	0.8
4%	1.6
5%	2.0
6%	2.4
8%	3.2
10%	4.0

TITRATION

1. Measure 100 mls of the product to be tested into a beaker.
2. Add 10 drops of methyl-orange indicator to the sample.
3. Titrate slowly with standard acid solution (1.0 N Sulfuric Acid) until the first noticeable color change (this is the end point).

To calculate concentration: Mls of titrant x 0.51 = % Atlantic Cool 614

EXPOSURE CONTROLS / PERSONAL PROTECTION (CONCENTRATE)

Respiratory Protection:	None required.
Ventilation / Local Exhaust :	General room ventilation.
Ventilation / Mechanical Recommendations:	None required.
Skin Protection - Concentrate:	Vinyl or rubber protective gloves.
Eye Protection - Concentrate:	Goggles
Other Protective Equipment:	Vinyl apron (optional).

HIMS RATING / NFPA RATING

1,0,0

For Industrial and commercial use only

Atlantic Specialty Chemicals Corporation
317 Godwin Avenue Midland Park, NJ 07432 800-440-7550