



SEMI-SYNTHETIC, METALWORKING FLUID CONCENTRATE

DESCRIPTION

FOXX Blade is recommended for moderate-duty machining and grinding of ferrous metals, and some non-ferrous metals.

Metals: Cast Iron, Nodular Iron, Carbon Steels, High Speed Steel, High Alloy Steels, Stainless Steels, Aluminum

Duty Range: Light to Moderate-duty

Water Conditions: Soft to Hard

FEATURES & BENEFITS

- Designed to be used in machines and operations where long fluid life is needed, such as in large individual machine or central system reservoirs.
- Effective lubrication and cooling properties keep parts and tools cool, extend tool life and allows for high speeds and feeds that increase production
- Efficiently settles chips and grit
- Exceptional rancidity control
- Excellent corrosion control with organic and inorganic corrosion inhibitors

TYPICAL PHYSICAL AND CHEMICAL PROPERTIES

Physical state:	Liquid
Appearance and odor:	Clear, yellow/chemical
Colors available:	Undyed, pink, blue
Solubility in water:	100% Miscible
Weight, lb/gal, 60°F (15.6°C):	8.83
Specific gravity, (H2O = 1):	1.058
Boiling point, °F (°C):	210 (99)
Flash point, COC, °F (°C):	None, self extinguishing
Fire point, COC, °F (°C):	NA
Extinguishing media:	NA
Unusual fire & explosion hazards:	None
Freezing point (or pour point), °F, (°C):	32 (0)

If frozen product separates. Thaw completely and stir thoroughly before using.

pH, concentrate:	10.2
pH, 5.0% mix, typical operating conditions:	9.0
Total chlorine/chloride, wt%, calculated:	0.00/< 50 ppm
Total sulfur, wt%, calculated:	0.01
Silicones:	None

PACKAGING: 20 litre pails, 200 litre drums, and bulk containers.

RECOMMENDED STARTING DILUTIONS

FOR INDUSTRIAL USE ONLY

Recommended Starting Dilution:	5.0% (1:20)
Typical Operating Range:	5.0% (1:20) to 10% (1:10)
Refractometer Factor:	3.1

The table below demonstrates potential Refractometer readings and the concentration % derived by using the following formula: (Refractometer Reading x Refractometer Factor = Concentration %)

Refractometer Reading	1.0	1.3	1.6	1.9	2.3	2.6	2.9	3.2
Concentration %	3	4	5	6	7	8	9	10

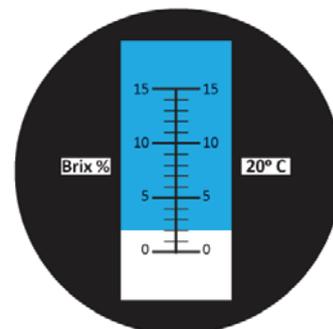
REFRACTOMETER CALIBRATION AND INSTRUCTION FOR USE

1. Ensure that the refractometer (figure 1), water and metalworking fluid are at room temperature.
2. Place a few drops of water between the plastic cover and the prism.
3. Hold the refractometer horizontally and point it at a light source.
4. Look into the eyepiece and adjust the scale-calibrating screw until the boundary line, which separates the light and dark areas of the scale are aligned to zero "0" on the scale.
5. Lift the plastic cover and dry the prism with a clean, dry cloth.
6. Place one or two drops of the metalworking fluid on the prism and close the plastic cover.
7. Read the number on the scale at the point where the boundary line separates the light and dark areas on the scale (Figure 2). For the concentration, multiply this number by the refractometer factor.

Figure 01



Figure 02



FOXX Blade to be mixed with water for use (add concentrate to water). Add no other substances to the concentrate or mix unless approved by FOXX Technical Services.

For concentration analysis, use Total Alkalinity Titration Procedure, BCG Titration Procedure, CIMCHEK™ Test Strip, or Refractometer.

EXAMPLE:
 FOXX Blade Refractometer Factor = 3.1
 Take the Refractometer Scale Reading of 1.6 (i.e. Figure 2), multiplied by the Refractometer Factor of 3.1 = 5.0% mix concentration.

