

GreenCut® Cutting/Misting Fluid

Operational Data Sheet



Use GreenCut at 20 : 1 mix ratio

GreenCut has a superior and Safe metal-cutting capability with Safe anti-rust + anti-foam chemistry. *Protecting hands, faces, lungs, and environment, while preventing machine shop bacteria 'stink'.*

GreenCut/water mixture must be circulated in the coolant bath to balance temperatures, and also to remove all bacterial and fungus food supply in the bath -Safely. GreenCut does this by biodegrading the tramp oils and wastes on contact. (Bacteria feed and grow explosively on oils, their favorite food)

GreenCut will improve machining operations of all metals and alloys by at least 40%

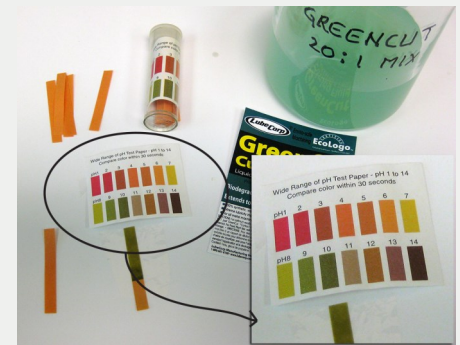
Checklist for Rust:

GreenCut has excellent built-in Rust protection, good for all metals, for up to 50:1 blend ratios. (Recommended 20 : 1 ratio).

Follow the **pH** maintenance procedure shown on the right to eliminate rust issues.



- **GreenCut is not an oil**
It works better but needs monitoring



Bi-weekly Coolant Maintenance

Check the pH of the bath using pH test paper strips for color match. **pH** should be between 9 and 10 for max. performance.

If the sample is not up to the **pH** reading add straight GreenCut, blend into the bath until the **pH** matches to pH zone.

'Standard' Coolant color sample test: Mix water and GreenCut in a clear bottle at 20:1 ratio. Use this color sample to visually measure the mix ratio in the bath.

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Hi-pressure through-tool machining with GreenCut Cutting Fluid.

Checklist for Foaming:

If Foaming occurs it will be due to soft water or to high-pressure pumping (500 psi+). Check **pH** first.

To eliminate the foaming issue add 5 ml of LubeCorp AntiFoam per 20 Liters of reservoir coolant. We recommend doing this separately from the reservoir, if possible, by using pails or an open drum and hand mix the AntiFoam into the coolant until the AntiFoam is absorbed, then add it all back into the reservoir. Up to 100 ml of AntiFoam can be premixed in a 20 L pail, enough for a 400 L reservoir.

Avoid mixing within the coolant reservoir, it tends to cause mixing problems, especially if there is free oil floating in the reservoir. (Oil and LubeCorp AntiFoam don't mix and will cause clotting, causing filter plugging, etc.)

5 ml = 1 teaspoon per 20 liter pail of pre-mixed GreenCut.

4000 : 1 mix ratio.

How do I dispose of GreenCut or How do I Avoid disposal entirely?

GreenCut Fluid is safe, non-toxic and can go directly into the sewer providing the metal shavings and crud have been filtered out and no oil is visibly floating on top of the fluid. We recommend 3 to 5 micron bag filtration. GreenCut Fluid biodegrades up to 5% of all oils on contact; use oil skimming if there is excess.

Avoid Disposal! Keep re-using the residual water/GreenCut mixture for years by treating as per the above maintenance program. One of our Clients in Oregon, USA has been doing this for 7 years without disposal and just adding the correct GreenCut mixture, using **pH** strips for preparing correct coolant mixture.

LubeCorp's customers have received direct sewer disposal approvals, based on the above, from authorities in different jurisdictions across North America.

