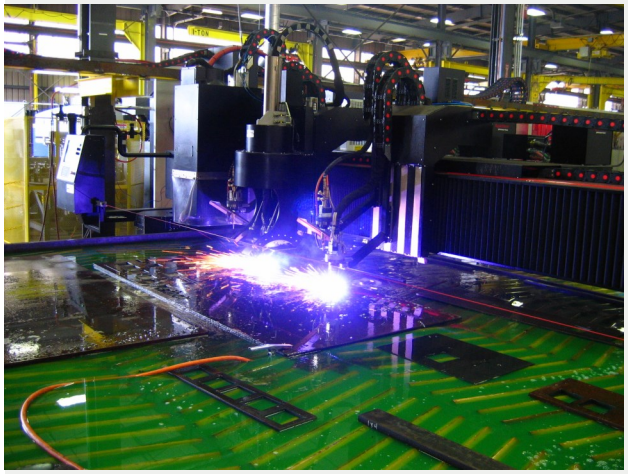
# GreenCut® *Plasma Arc Water-Table Fluid*

## Data Sheet

LubeCorp® Manufacturing Inc.
ISO 9001:2008



GreenCut *Plasma* is a SAFE cutting fluid specifically designed for *Plasma* Arc Cutting Tables.

- Contains anti-rust, anti-foam, and anti-bacterial chemistry.
- Does not thermally degrade. No change-outs required.
- *Protects hands, faces, lungs, and the environment.*

**Use GreenCut at 20 : 1 mix ratio**
(Control with **pH** strips (between 9—10)

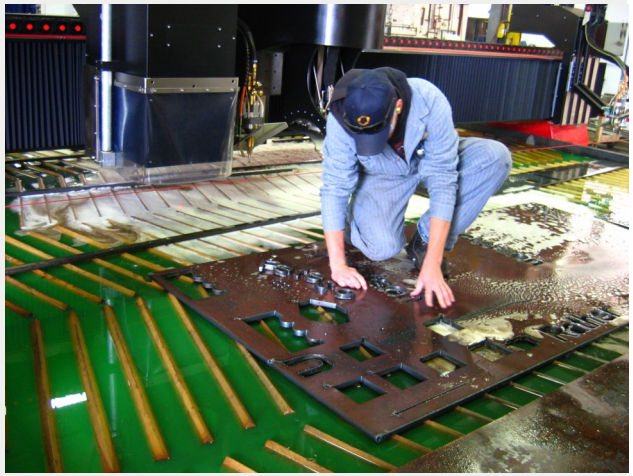
**NOTE:** Be sure to have the GreenCut Plasma fluid in direct contact (no air gap) with the metal being cut to improve Plasma torch cutting finish.

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

Plasma Arc Cutting removes metal by using a constricted arc to melt a localized workpiece, and removing the molten material with a high-velocity jet of ionized gas from the orifice. Plasma Arcs operate at 10,000$^0$C -14,000$^0$C (18,000$^0$F-**25,000$^0$F**).


**GreenCut *Plasma* Fluid needs to circulate in the table while operating** to prevent hot spotting, to provide rust protection, and for biodegrading oils and wastes with the GreenCut Plasma Fluid at the molecular level.

GreenCut *Plasma* Fluid will biodegrade the 'tramp-oils' that wash into the water table from the Plasma cut metal sheet on contact: eliminating all 'stink', anaerobic bacterial formation, and fungal growth.



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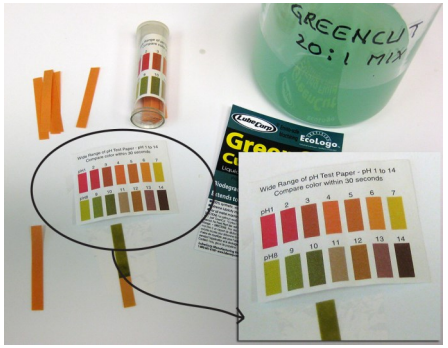
**GreenCut *Plasma* Fluid rarely needs change-out**. Based on over 13 years experience with Plasma Arc Water-Tables, when utilising proper **pH** maintenance and pump circulation of the fluid, including filtration as required; GreenCut *Plasma* Fluid results in significant operational savings.

Metal cuttings and burn-off material (slag) will sink to the bottom of the tables and will need cleaning out periodically. GreenCut *Plasma* Fluid can be saved, filtered and re-used when properly maintained.




Bi-weekly Coolant Maintenance

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

If the fluid is not up to the correct **pH** reading add straight GreenCut *Plasma* Fluid and blend into the tank by pumping until the table **pH** is between 9 and 10.

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

**As the table starts to run low**, (checked by removing all air from the table bladder) add GreenCut *Plasma* Fluid to the table at full strength to obtain correct **pH** reading (done while pumping the table fluid-mix nonstop).

Reason:
More GreenCut *Plasma* Fluid than water leaves during operation due to GreenCut's polar attraction to all metals (Prevents rust).

**Originally Approved by:**
Environment Canada
**under the Environmental Choice Program**

**Checklist for Rust or Foaming:**

If **Rust** appears, follow maintenance procedure to correct the **pH** and/or the color of the Table.

If **Foaming** occurs it is due to soft water or high-pressure pump (500 psi+). Check **pH**. Add LubeCorp Anti-Foam at 1 : 4000 ratio to Table (5 ml per 20 liters) 5 ml = 1 teaspoon.