

GREENCUT® PLASMA ARC WATER-TABLE FLUID

GREENCUT HAS A SUPERIOR METAL-CUTTING CAPABILITY WITH SAFE ANTI-RUST + ANTI-FOAM CHEMISTRY.

HOW IT WORKS

GreenCut Plasma is a premium cutting fluid, explicitly designed for Plasma Arc Cutting Tables. This unique fluid guarantees safety and efficiency in the high-temperature conditions inherent to Plasma Arc Cutting, which operates at temperatures between 10,000°C and 14,000°C (18,000°F and 25,000°F).

GreenCut is not just an alternative to oil but works even better. However, it requires regular monitoring. It boasts superior rust protection, suitable for all metals. Although a 20:1 ratio is recommended, GreenCut can be effective at up to 50:1 blend ratios.

Mixing & Usage:

- Prepare a mixture using GreenCut Plasma at a 20:1 ratio with water.
- Use pH strips to maintain and ensure a pH balance between 9 and 10.
- **Keep the fluid in circulation within the table during operation to prevent hot spotting**, provide rust protection, and ensure effective biodegradation of oils and wastes.

Coolant Maintenance:

- Check the pH level bi-weekly using pH test paper strips, aiming for a pH between 9 and 10.
- If the pH is not within this range, add GreenCut Plasma Fluid directly and circulate until the desired pH is achieved.
- For a visual measure of the mix ratio, combine water and GreenCut Plasma in a clear bottle at a 20:1 ratio and use this color sample.

Refill Procedure:

- As the fluid level decreases, top up with GreenCut Plasma Fluid at full strength, ensuring the fluid is continuously pumped. This compensates for the fluid's polar attraction to metals which prevents rust.

Periodic Maintenance:

- Metal cuttings and other residues will settle at the bottom and require periodic cleaning. The GreenCut Plasma Fluid can be saved, filtered, and reused when maintained properly.

Troubleshooting:

- For rust issues, adjust the pH and/or the color.
- If foaming is observed due to soft water or a high-pressure pump (500 psi+), check the pH and add LubeCorp Anti-Foam at a 1:4000 ratio to the table (5 ml per 20 liters or 1 teaspoon).

Note: Ensure the GreenCut Plasma fluid is in direct contact (no air gap) with the metal being cut to optimize the Plasma torch cutting finish.

PROTECTING HANDS, FACES, LUNGS, AND ENVIRONMENT, WHILE PREVENTING MACHINE SHOP BACTERIA 'STINK.'

Have questions? Reach us at: www.lubecorp.com

