

## Syntilo 9954

Synthetic coolant

### Description

Syntilo™ 9954 is a synthetic coolant which has been developed for use as a grinding and heavy duty machining fluid for ferrous metals. Syntilo 9954 has been engineered for the high feed and speed of today's machining operations.

Syntilo 9954 performs exceptionally well as a replacement for neat cutting oil in applications such as gun-drilling, gearhobbing and broaching. It can be used in both single sump machines as well as central systems.

### Applications

Syntilo 9954 is recommended for honing, milling, turning, boring, drilling, tapping, gear hobbing and broaching on all ferrous alloys. This product is also recommended for various grinding operations.

	Cast Iron	Low-Medium Alloyed Steel	High Alloyed - Stainless Steel	Aluminium Alloys	Titanium Alloys	Tungsten Carbide
Grinding	√	√√	√√			
Milling, Turning (general machining)	√	√√	√√		√	
Drilling	√	√	√		√	
Reaming, Tapping	√	√√	√√		√	
Broaching	√	√√	√√			

### Advantages

- Provides superior machining performance on difficult alloys such as inconel and titanium
- Low foaming in all water conditions
- Inhibits microbial growth to extend fluid life in central systems and individual sumps
- Rejects tramp oil to the surface of the fluid for easy removal
- Chlorine, phenol and nitrite free for environmental compliance
- Superior lubrication package allows for replacement of conventional neat oil technology.

## Typical Characteristics

Name	Method	Units	Syntilo 9954
CONCENTRATE			
Appearance	Visual	-	Transparent Yellow
Density at 15°C	ASTM D1298	kg/m <sup>3</sup>	1060 - 1080
Mineral Oil Content	Calculated	Vol %	0
SOLUTION			
Appearance	Visual	-	Transparent
pH (5%)	ASTM E70-97	-	8.3- 8.8
Factor Refractometer	-	-	1.4

The above figures are typical of those obtained with normal production tolerance and do not constitute a specification.

## Recommended Concentrations

Grinding:	4 - 6%
General Machining:	4 - 10%
Broaching:	10 - 15%
Water range:	0 - 300 ppm CaCO <sub>3</sub>

## Storage

All packages should be stored under cover. Where outside storage is unavoidable drums should be laid horizontally to avoid the possible ingress of water and the obliteration of drum markings.

Products should not be stored above 60°C, exposed to hot sun or freezing conditions.

## Castrol Syntilo 9954

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