

T.C. 1059

Grinding Coolant

DESCRIPTION

T.C. 1059 is a semi-synthetic water extendible grinding concentrate.

PROPERTIES

The low working pH and non-staining E.P. additives make this grinding fluid ideally suited for use on nonferrous and most ferrous metals. T.C. 1059 mixes with either hard or soft water to produce transparent, light green solutions, which keep machines, coolant lines, and working parts free and clean. The transparent solution permits the operator to view metal removal on very fine machine operations. T.C. 1059 products a fine finish on both machining and grinding applications. It is non-toxic, and non-irritating to the skin.

It gives excellent rust protection on machines and work pieces and imparts a thin protective film, which prevents galvanic rust or white bloom corrosion on aluminum. Finished parts upon drying can be painted or welded, thereby eliminating the need for power washing or de-greasing. Heavy chips settle to the bottom of the tank, very lightly float on top of the coolant tank and can be skimmed off, further extending life coolant. The solution can be titrated (ratio of water to concentrate in coolant tank).

The E.P. agents added to T.C. 1059 increase wheel life and workpiece finish by reducing the cutting forces at the wheel-workpiece interface. Improvements in microfinish can be made by varying water-coolant mixtures. Almost all narrow-contact grinding operations can be performed with T.C. 1059.

This material is excellent for use with aluminum oxide or silicon carbide grinding wheels. Vitrified resinoid, shellac and rubber abrasive binders are unaffected by water mixtures of T.C. 1059.

USE DILUTIONS

General Machining	40 parts water to 1 part coolant
General Grinding	50 parts water to 1 part coolant
Drilling & Tapping	15 parts water to 1 part coolant
Milling & Reaming	30 parts water to 1 part coolant
Tube Drawing	18 parts water to 1 part coolant