

Full Synthetic Metalworking Fluid **Unicool 4117**



**Industry proven
High performance
Synthetic Metalworking
Fluid**

Unicool 4117 is a metalworking fluid designed for grinding and machining of steel and non-ferrous metals. This product has very good fines settling characteristics which prevent build up on grinding wheels. **Unicool 4117** is low foaming, making it good for high pressure applications. It is unaffected by hard water and has excellent heat reduction properties. A special corrosion inhibitor package provides protection against rust and corrosion on metal. By controlling concentration between 5% and 10% performance characteristics can be optimized.

Features

- ♦ For Ferrous & Non-ferrous Metals
- ♦ Low Foaming
- ♦ Unaffected by hard water
- ♦ Superior corrosion inhibitor
- ♦ Excellent Heat Reduction Properties
- ♦ Good Fines Settling Characteristics



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Concentration Control Table

%	Refractometer Brix Reading
10	4.0
9	3.6
8	3.2
7	2.8
6	2.4
5	2.0
4	1.6
3	1.2
2	.05
1	.04
Refractometer Multiplication Factor	2.5

Form	Liquid
Color	Clear Pale Yellow
Odor	Mild
Specific Gravity	1.06
Density	8.8 lb/gal
Soluble in Water	Miscible
pH of Concentrate	9.4
Freeze/Thaw Stability	Stable; Mix after freezing
Shelf Life	1year



Usage Instructions: Before adding to the machine sump, premix the coolant by adding concentrated coolant to water in desired proportions and agitate until uniform. If desired concentration is unknown, begin with a concentration of 6% and perform trials until ideal concentration is determined. When adding make-up, avoid adding straight water or concentrated coolant to the sump. Add premix at a concentration approximately 1/4th the desired running concentration. Example: If running concentration is 6%, add make-up at a concentration of 1.5%

Maintenance: Regular maintenance is required in order to ensure optimal performance of Unicool ZP 23 Concentration should be monitored regularly with a refractometer and maintained between 5% and 10%. Tramp oils should be removed from coolant frequently to reduce likelihood of biological growth. Prevent contamination with cleaners or solvents.



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