

# **Vulsol 2500 S**

## **Synthetic Metalworking Fluid**

(Formerly Elfcool S 2500)

### **DESCRIPTION**

**VULSOL 2500 S** is a full synthetic coolant formulated for general machining and grinding of ferrous metals and its alloys.

**VULSOL 2500 S** is an economical synthetic coolant offering high value with the following advantages:

- Produces a clear solution in all types of makeup water
- Provides long sump life
- Resistant to biological growth
- Contains no nitrites, phenols, mineral oil or heavy metals
- Formulated with a strong rust inhibitor package
- Provides good lubricity and extreme pressure protection
- Prevents welding of chips to the cutting tool
- Rapid heat dispersal helps provide long tool life and part size control
- Low foaming fluid can be used in high speed machining and grinding operations
- Provides excellent visibility of the work piece
- Easier to treat for disposal since it contains no petroleum products

### **APPLICATION**

**VULSOL 2500 S** is recommended for the machining and grinding of ferrous metals and its alloys. Operations include milling, turning, drilling, boring, and threading. **VULSOL 2500 S** also performs well on OD and ID grinding operations including center-less and surface grinding.

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## VULSOL 2500 S

### MIXING RATIOS

The standard dilution ratio of water to concentrate is 20:1. **VULSOL 2500 S** may be mixed satisfactorily from 10:1 to 25:1, depending upon the type and severity of the operation. For grinding operations, 25 to 30 parts water to 1 part **VULSOL 2500 S** is recommended. The concentration should be adjusted as necessary to maximize performance.

### TYPICAL SPECIFICATIONS

Appearance	Clear Liquid
Odor	Mild Amine Type
Specific Gravity @ 60°/60°F	1.03
Density @ 60°F, #/gallon	8.57
Sulfur, % wt.	Nil
Chlorine, % wt.	Nil
pH @ 1:9 Solution	9.0
Refractive Index, ° Brix,	
15.0%	5.3
10.0%	3.4
5.0%	1.7
3.5%	1.0

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