

PRATT ALUMAX 89

NEW TECHNOLOGY METALWORKING FLUID FOR ALL METALS

▶ PRODUCT DESCRIPTION

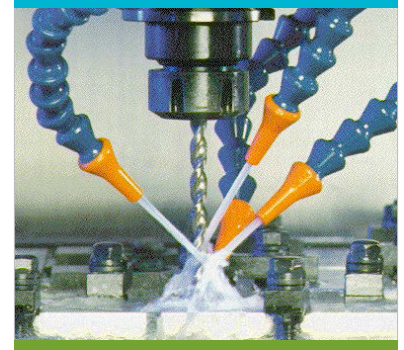
Pratt Alumax 89 is an enhanced technology that Chemtool Incorporated has introduced to the aerospace metalworking industry. Pratt Alumax 89 is like no other metalworking fluid on the market today. Pratt Alumax 89 is manufactured using a proprietary process that incorporates into the product many unique characteristics which promote very high productivity and minimal downtime for the end user.

Pratt Alumax 89 is formulated utilizing a blend of preformed emulsions of very small and stable particle size (average particle size of one micron). This small particle size provides a very durable and uniform lubricant film (based upon synthetic boundary lubricants), enhanced cooling, a very clean running fluid, and exceptional hard water stability. The incorporation of this leading edge PAO technology enables Pratt Alumax 89 to exhibit superior lubrication comparable to existing synthetic and semi-synthetic technologies, including the advantages of superior surface cleanliness, improved deposit control and outstanding hydrolytic stability.

▶ FEATURED BENEFITS

- The biostable chemistry maintains the pH eliminating objectionable odors.
- Excellent corrosion protection for all tooling, equipment, and parts.
- Exceptional lubricant film for improved tool life based upon the products synthetic technologies.
- Extremely small particle size for superior wetting.
- Excellent hard water stability.
- Very low reportable VOC's for operator acceptance.
- High degree of cleanliness.
- Higher viscosity polymeric additives offer improved boundary lubrication without heavy oil content limiting coolant carry-off and providing a cleaner machine interior.
- High flash point polymeric additives eliminate mist and evaporation that reduces coolant cost and promotes a healthy work environment.
- Proven history of being operator safe.
- Tramp oil rejection eliminates a source for bacteria and rancid odors that reduces sump change outs, disposal costs, and machine downtime.
- Meets Pratt and Whitney PMC 9287 Rev. C.

APPLICATION



COMPATIBLE METALS

Inconel
Titanium
Magnesium
Carbon Steel
Tool Steel
Stainless Steel
Light-Duty Aluminum
Bronze
Copper
Brass
Cobalt Base Alloys

MACHINING CAPABILITIES

Milling
Turning
Sawing
Drilling
Reaming
Tapping
OD/ID/Centerless Grinding
Burnishing
Light Duty Hobbing & Broaching

HIGH PRESSURE COOLANT CAPABILITY

Yes

ALL METAL SAFE

Yes

REFRACT INDEX

2.9





TYPICAL PROPERTIES

Fluid Type	New technology metalworking fluid with polymeric additives
Appearance	White, translucent emulsion
Odor	Mild odor
Specific Gravity, 60°F (15.6°C)	1.002-1.035
Weight, lb/gal., 60°F (15.6°C)	8.54
pH (10% dilution)	9.40 - 9.60
Biostability	Excellent

PRODUCT APPLICATION / USAGE

Pratt Alumax 89 is recommended for general purpose machining of ferrous and non-ferrous alloys.

Operation	Carbon Steels, Cast Iron Alloys	High Alloy Steels	Aluminum Alloys
Milling, Drilling, Turning	8%	8 – 12%	7 – 12%
Reaming, Light Duty Broaching, Milling, Tapping, Sawing	7 – 10%	8 – 14%	7 – 14%
Grinding: I.D., O.D.	6 – 8%	7 – 10%	7 – 10%

MIXING DATA

Pratt Alumax 89 metalworking fluid is to be mixed with water for use. Always add product concentrate to the water, not water to product concentrate. Add with mild agitation. Product concentration can easily be monitored by refractometer.

Concentration	15.0%	12.0%	9.0%	6.0%	3.0%
Refractometer Reading	5.0	4.0	3.0	2.0	1.0

PRODUCT CODE

27023G0PRA

HEALTH AND SAFETY

For health and safety guidance, please refer to the Chemtool SDS (Safety Data Sheets).