

## VISCOOL 6325 N

### Value Performance Coolant

## Product Data Sheet

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**VISCOOL 6325 N** is a coolant formulated for a wide variety of metalworking operations including machining and grinding operations on both ferrous and most non-ferrous metals.

**STABILITY:** Viscool 6325 N has superior stability in the concentrate and the emulsion form. It is resistant to moderately high conductance conditions that often results from hard water, aging or other leaching.

**BIORESISTANCE:** Viscool 6325 N has been formulated selecting highly biostable components that provide synergy that enhances and reduces the biocide present.

**LUBRICITY:** Viscool 6325 N has been found to have very high lubricity relative to the composition.

**FOAM:** Viscool 6325 N is designed to be very low foaming without a defoamer. A small amount of defoamer is present for charge-up conditions. It has been tested under shear conditions and does not degrade or shear.

**RUST PROTECTION:** Viscool 6325 N has a low Cast Iron Chip Test breakpoint @ 3%, it forms a very thin impervious film that cleans easily and protects ferrous and nonferrous metal from oxidation, stain and rust.

**METAL COMPATIBILITY:** Viscool 6325 N is compatible with ferrous and nonferrous metals including most aluminum, brass, copper and mixed or clad alloys. It is designed using minimal leaching components to avoid leaching stain or alteration of metal surfaces. It contains metal deactivators to provide a secondary seal behind the boundary layer film. This minimizes migration of parts or machine components into the metalworking, machine, or other fluids in the process.

**TRAMP OIL REJECTION:** Viscool 6325 N readily rejects tramp oil with transient absorption of less than 2%, and separates to less than 1% rag layer plus absorbed oil. It does not significantly strip RP or lubricity additives from the emulsion or migrate into the tramp oil phase and be removed.

#### RECOMMENDED STARTING DILUTIONS

The following are typical starting dilutions that can be reduced on verifying effectiveness of this high performance coolant.

Operations	Carbon Steels Cast Steels	High Alloy Steels Stainless Steels	Non-Ferrous Alum., Brass and Copper
Milling, Drilling, Turning, Sawing	1:13 (7%)	1:12 (8%)	1:13 (7%)
Reaming and Broaching	1:7 (12%)	1:7 (12%)	1:9 (10%)
I.D., O.D., Centerless Grinding	1:19 (5%)	1:19 (5%)	1:19 (5%)

#### Typical Characteristics:

Appearance:	Amber Clear Concentrate/ Translucent Emulsion
pH 5%:	9.2
Weight, Pounds per Gallon:	8.602
Residue:	Soft, oily

#### Refractometer Readings:

1:5.6 (15%)	1:9 (10%)	1:15 (6%)	1:19 (5%)	1:32 (3%)
7.4	5.1	3.2	2.75	1.8

Avoid prolonged skin contact with concentrate. Use eye protection. Product becomes viscous at cold temperatures. Allow to warm to room temperature before mixing. Coolant should always be added to water. Do not add water to concentrate.

Available in 5 gallon pails, 55 gallon drums, and bulk quantities.

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