

# VISCOOL 6325 OC

## Product Data Sheet

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

The *unique* combination of ingredients forms a stable emulsion even in extremely hard water and provides exceptional metal working ability, tool life and long term trouble free performance.

- . . . Wide range of job applications
- . . . Superior rancidity control
- . . . Increased tool life
- . . . Nonirritating to the skin
- . . . No nitrates or phenols
- . . . Superior rust protection
- . . . High lubricity

**STABILITY** Viscool 6325 OC has superior stability in the concentrate and the emulsion form. It is resistant to moderately high conductance conditions that often results from hard water concentrating, aging or other leaching. It is stable from 1% to 100% but may vary in emulsion characteristics typically out of the typical ranges of 3 to 10%.

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

**LUBRICITY** Viscool 6325 OC has been found to have very high lubricity relative to the marketplace. It is very powerful per mil of film, but exceeds all tested products in the price range at this time.

**FOAM** Viscool 6325 OC is designed to be very low foaming without a defoamer. However, 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 OC has a low Cast Iron Chip Test breakpoint ~ 4%, 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 OC is compatible with ferrous and nonferrous metals including most aluminum, brass, copper and mixed or clad alloys. Please request testing if unusual alloys or metal composition comes to question. 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 OC 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.

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## RECOMMENDED STARTING DILUTIONS

The following are typical starting dilutions that often can be significantly 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	1:19 (5%)	1:13 (7%)	1:19 (5%)
Reaming, Light Duty Broaching	1:16 (6%)	1:11 (8%)	1:16 (6%)
I.D., O.D., Centerless Grinding	1:49 (2.0%)	1:39 (2.5%)	1:39 (2.5%)

### Typical Characteristics:

Appearance:	Amber Bright Clear concentrate Translucent to Cloudy emulsion
pH:	1:19 dilution – 8.7
Weight, Pounds per Gallon:	8.3
Residue:	Soft, oily
Flash Point, COC, °F:	>350

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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