Cutrite 3398
Premium heavy duty micro-emulsion

Description
Cutrite 3398 is a high performance micro emulsion metalworking fluid for machining and grinding of ferrous and non-ferrous alloys including cast aluminum, titanium and nickel-chromium alloys. It is ideally suited for manufacturing plants desiring a single fluid to perform well on a variety of metals and operations. The use of innovative technology allows **Cutrite 3398** to provide excellent sump life while the reliable, low maintenance qualities make it an ideal choice for individual sumps and central systems applications.

Performance Benefits
- Excellent bio resistance provides a long sump life and with no supplemental additives
- Constant emulsion particle size provides a long fluid life in both individual sumps and central systems and minimizes drag out
- Extreme pressure additives extend tool life and improve finishes.
- Low foaming in all water conditions
- Excellent machining performance on aluminum alloys in difficult operation such as roll form tapping, Mapal reaming, gun drilling, and deep hole boring.
- Excellent wetting properties reduce fluid drag-out and deliver clean machine tools and components
- Low maintenance fluid minimizes hassles such as frequent additive additions

Recommended Applications & Dilutions
Recommended for machining and grinding ferrous and cast aluminum alloys as well as titanium and nickel-chromium alloys. Consult with your account representative for questions regarding compatibility

Grinding   4% to 5%
Machining   5% to 12%

Characteristics

Properties	Unit	Test Method	Value
Appearance of Concentrate	-	Visual	Amber liquid
Appearance of Dilution	-	Visual	Translucent to milky
pH of 5% dilution	-	-	9.6 -9.9
Density @ 15°C	lbs/gal	-	8.4
Chlorine	-	-	Yes
Nitrites	-	-	No
Phenols	-	-	No

Additional Information
Concentration Control

Refractive Index Multiplier: 1.35

Refractometer Reading	% Concentration
3	3.9
4	5.5
5	6.8
6	8.1