

# 3500



## Features & Benefits

- Non-Foaming
- Excellent Sump Life
- Extends Tool and Wheel Life
- Superior Tramp Oil Rejection
- No Sulfur, Phosphorous, Chlorine or Other Halogens
- Good Corrosion Protection

## PRODUCT DESCRIPTION

**APEX 3500** is a high-speed, semi synthetic turning and grinding fluid chemically designed to resist bacteria and fungus. Forms a translucent blue micro-emulsion providing a clear view of the work piece. Protects the machine from rust and corrosion.

## TYPICAL ANALYSIS

APPEARANCE: ..... Translucent Blue Liquid  
 pH @ 10% SOLUTION: ..... 9.8  
 SPECIFIC GRAVITY: ..... 1.06  
 ODOR: ..... Mild  
 FLASH POINT: ..... None

## APPLICATION

Recommended for turning, milling, drilling, sawing, and grinding on both ferrous and non-ferrous metals. Can be used as a tube mill fluid for use in pipe upsetter and pipe threading operations. Also an excellent hydrostatic testing fluid.

## RECOMMENDED STARTING DILUTIONS

Operation	Carbon Steels, Cast Steels	High Alloy Steels, Stainless Steels	Aircraft, Tool Steels	Copper, Aluminum
Machining-Milling Drilling, Turning	1:20 (5.0%)	1:20 (5.0%)	1:15 (6.7%)	1:20 (5.0%)
Grinding	1:20 (4.0%)	1:20 (4.0%)	1:20 (5.0%)	1:25 (4.0%)
Reaming, Tapping, Sawing, Broaching	1:10 (10%)	1:10 (10.0%)	1:10 (10.0%)	1:10 (10%)

## REFRACTOMETER READINGS

Dilution Ratio	1:10 (10.0%)	1:15 (6.7%)	1:20 (5.0%)	1:25 (4.0%)	1:30 (3.3%)
Refractometer Reading	2.7	2.4	1.6	1.2	1.1

## PACKAGING

A-3500-14 1 Gallon (4/Case)  
 A-3500-05 5 Gal Pail  
 A-3500-55 55 Gal Drum  
 A-3500-275 275 Gal Tote

Undyed  
 A-3501-05 5 Gal Pail  
 A-3501-55 55 Gal Drum  
 A-3501-275 275 Gal Tote

## NOTES

- Use Ashburn Machine Cleaner for quick and thorough pre-cleaning of machine tools and coolant systems.
- Consult Ashburn prior to use on metals or applications not recommended.
- Unless recommended by Ashburn, this product should not be mixed with metalworking fluid additives.



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