

# 3500TM



## FEATURES & BENEFITS

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

## PRODUCT DESCRIPTION

**APEX 3500TM** is a synthetic tube mill coolant formulated to provide excellent cooling and lubrication and leave minimal residue. Designed to resist bacteria & fungus & provide long-term, worry-free sump life. Forms a solution that resists tramp oil contamination to leave tubes and forming rolls clean. It is formulated to protect machinery, tools and parts from rust & corrosion.

## TYPICAL ANALYSIS

APPEARANCE: ..... Transparent Liquid  
 COLOR: ..... Blue  
 pH @ 5% SOLUTION: ..... 10.0  
 SPECIFIC GRAVITY: ..... 1.04  
 ODOR: ..... Mild  
 FLASH POINT: ..... None

## APPLICATION

Designed for use as a tube mill fluid for use in tube forming operations. Also recommended for machining applications including turning, milling, sawing, drilling and grinding on ferrous and nonferrous metals.

## RECOMMENDED STARTING DILUTIONS

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

## 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	2.4	1.8	1.3	1.1	0.98

## 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.

## PACKAGING

### Blue

A-3505-05	5 Gal Pail
A-3505-55	55 Gal Drum
A-3505-275	275 Gal Tote