

6580



## FEATURES & BENEFITS

- Neutral pH Prevents Staining of Aerospace Alloys & Non-Irritating to Machine Operators
- Increased Lubricity vs Conventional Synthetic Coolants
- Excellent Stability in Hard & Soft Water Applications to Ensure Minimal Residue Build-Up
- Quickly Rejects Tramp Oils to the Surface
- Very Low Carry Off Reduces Coolant Consumption
- Low Foaming in All Water Conditions
- Prevents Bimetallic Corrosion & is Safe to Use in Equipment with Most Copper, Brass, Bronze & Aluminum Components

## PACKAGING

### Blue

A-6580-05	5 Gal Pail
A-6580-55	55 Gal Drum
A-6580-275	275 Gal Tote

## PRODUCT DESCRIPTION

**APEX 6580** is a high lubricity, heavy-duty synthetic coolant designed for difficult machining applications on aerospace aluminum and other aerospace alloys. Formulated with a neutral pH, it prevents staining of aluminum and is non-irritating to machine operators.

It is fortified with a special blend of high viscosity index polymer lubricants. These polymers remain soluble in water until activated by the heat of friction during machining and grinding. This results in coolant with excellent lubricity at the tool/chip interface, yet with very little carry off on parts.

The **APEX 6580** performs like a semi-synthetic, but runs extremely clean, has superior oil rejecting capabilities and is very low foaming. It leaves a soft fluid residue that protects the machine tool and parts. This protective film will not interfere with heat treating or welding. Prevents corrosion on ferrous and most nonferrous metals.

## TYPICAL ANALYSIS

APPEARANCE:	Blue Liquid
pH @ 5% SOLUTION:	7.85
SPECIFIC GRAVITY:	1.07
ODOR:	Mild
FLASH POINT:	None
CHLORINE:	None
PHENOLS:	None
NITRITES:	None

## APPLICATION

Recommended for grinding, turning, & milling. For use on both ferrous and non-ferrous metals. Safe to use on most copper, brass, bronze & aluminum components.

## 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	1:25 (4.0%)	1:25 (4.0%)	1:20 (5.0%)	1:25 (4.0%)
Reaming, Tapping, Sawing, Broaching	1:10 (10%)	1:10 (10%)	1:10 (10%)	1:10 (10%)

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## 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	3.5	3.0	2.5	2.0	1.5

## 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.