

8000



## FEATURES & BENEFITS

- Heavy Duty Performance in Difficult Machining Operations, Including Aluminum
- Provides Extended Tool Life & Improved Surface Finishes
- Prevents Staining of Aluminum Parts & Provides Corrosion Protection for Machines
- Chlorine-Free & Sulfur-Free for Compliance Where these Materials May Be Restricted
- Exceptionally Clean - Machine Surfaces & Parts Remain Clean
- Non-Foaming in Soft Water
- Resists Microbial Attack to Prevent Rancid Odors, Extend Sump Life & Promote Trouble-Free Performance

## PACKAGING

A-8000-24	1 Gallon (4/Case)
A-8000-05	5 Gal Pail
A-8000-55	55 Gal Drum
A-8000-275	275 Gal Tote

## PRODUCT DESCRIPTION

**APEX 8000** is a microemulsion machining fluid for moderate to severe machining and grinding. Excellent for use in difficult machining of aerospace alloys. **APEX 8000** is chlorine-free, yet it overcomes the difficulties normally associated with machining aluminum such as chip welding, tool wear, poor surface finish and staining. It contains lubrication additives that work in synergy to enhance surface finish and extend fluid life beyond the capabilities of traditional aluminum machining fluids. This product is non-foaming in applications with operating pressures over 1000 psi. By resisting microbial attack, **APEX 8000** increases fluid sump life.

## TYPICAL ANALYSIS

APPEARANCE:	Clear Amber Liquid
pH @ 5% SOLUTION:	9.50
SPECIFIC GRAVITY @ 60°F:	0.98
ODOR:	Mild
CHLORINE:	None
NITRITE:	None
PHENOL:	None
PHOSPHORUS:	Yes
SULFUR:	None

## APPLICATION

Recommended for machining and grinding on both ferrous and non-ferrous metals including cast iron and aluminum, titanium and copper alloys.

## 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%)	1:20 (5.0%)	1:20 (5.0%)
Grinding	1:25 (4.0%)	1:20 (5.0%)	1:20 (5.0%)	1:20 (5.0%)
Reaming, Tapping, Sawing, Broaching	1:15 (6.7%)	1:10 (10%)	1:10 (10%)	1:15 (6.7%)

## 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	6.5	4.7	3.9	3.4	2.4

## 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.