



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