



5400 WSF



FEATURES & BENEFITS

- Provides Long Sump Life
- Does Not Contain Chlorine or Sulphur
- Low Foaming in All Water Conditions
- Superior Rust & Corrosion Protection. Protects Both Ferrous & Nonferrous Metals
- Excellent Stability in Hard & Soft Water Applications to Ensure Minimal Residue Build-Up
- Rejects Tramp Oils to the Surface
- Very Low Carry Off Reduces Coolant Consumption
- Prevents Bimetallic Corrosion & is Safe to Use in Equipment with Most Copper, Brass, Bronze & Aluminum Components

PRODUCT DESCRIPTION

APEX 5400 WSF is a biostatic, water soluble cutting fluid that provides greatly extended sump life for long-term performance in central systems and individual machine tools. Designed for light to moderate duty applications on both ferrous and nonferrous materials. Provides excellent cooling at the tool/chip interface, and very little carry off on parts.

APEX 5400 WSF runs extremely clean, has superior oil rejecting capabilities and is very low foaming. Prevents corrosion on ferrous and most nonferrous metals.

TYPICAL ANALYSIS

APPEARANCE: Clear Liquid
 pH @ 5% SOLUTION: 9.1
 SPECIFIC GRAVITY: 1.03
 ODOR: Mild
 FLASH POINT: None

APPLICATION

Recommended for turning, milling and grinding. 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%)

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	4.3	2.9	2.2	1.7	1.4

PACKAGING

Undyed

A-5400-05	5 Gal Pail
A-5400-55	55 Gal Drum
A-5400-275	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.