



PRODUCT DATA

PICOFORCE 5191

Semi-synthetic Machining Coolant

GENERAL DESCRIPTION:

PICOFORCE 5191 is a multipurpose, low oil, high lubricity, and biostable semi-synthetic coolant for machining ferrous and non-ferrous metals.

PICOFORCE 5191 is multi-metal engineered for moderate to severe machining of aluminum and other alloys and is fortified with special additives to protect from staining and corrosion, especially on sensitive alloys such as 6061, 7075, 2024, 1100, and cast.

PICOFORCE 5191 is designed to deliver exceptional performance, improved tool life, and run cool on parts and tools, even at high speeds, while reducing coolant consumption and costs.

PICOFORCE 5191 is a clean-running micro-emulsion offering excellent machining and part finish, enhanced metal wetting, long sump life, and eliminates odors and the use of tank side additives when maintained at recommended concentrations.

PICOFORCE 5191 extreme pressure and boundary lubricant additives combine the lubricity of a soluble oil with the cleanliness of a synthetic coolant all in "one" product.

PICOFORCE 5191 provides low-to-non misting qualities, is non-tacky, has excellent stability for extended use, and is easily maintained, recyclable, and waste treatable.

PRODUCT FEATURES AND BENEFITS:

- Non-tacky
- Excellent tool life
- Low make-up rate
- Excellent pH control
- Excellent tramp oil rejection
- Easy to maintain and control
- Eliminates tank side additives
- Eliminates odors and cleaning
- Clean running, operator friendly
- Low foaming and hard water stable
- Reduces waste, disposal, and fluid costs
- Excellent corrosion protection, non-staining
- Excellent part finish on steels and soft metals
- Biologically resistant to bacteria, fungi and yeast
- Excellent machinability on ferrous and aluminum alloys
- Outstanding lubricity to handle severe machining on tough alloys

RECOMMENDED DILUTIONS: * (When making dilutions, always add concentrate solution to water.)

Machining: 4.00 - 10.00% (1:25 to 1:10)
Grinding: 2.00 - 4.00% (1:50 to 1:25)
Cut-off / Sawing: 4.00 - 10.00% (1:25 to 1:10)

Brix Refractive Index Factor: 1.6 e.g., Brix Refractometer Reading x 1.6 = % PICOFORCE 5191

* NOTE: Calibrate Brix refractometer with in-house water to 0.0 reading before use. For in-use systems, sample use solution on delivery side of machine to minimize system contaminants. Determine concentration by type and gauge of metal, process, and application.

TYPICAL PHYSICAL AND CHEMICAL PROPERTIES:

Appearance and Odor: Clear, amber liquid with mild odor
Weight / Gallon: 8.57 lbs. / gal. @ 77°F (25°C)
pH (as is): 10.2

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Pico Chemical Corporation

Phone 708 757-4910 • Fax 708 757-4940

e-mail info@picochemical.com • www.picochemical.com

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