



COOLANT CONTROL^{INC.}

The right chemistry...

...the right solution

Product Bulletin

Orion 1025

Synthetic Cutting and Grinding Fluid

Description

Orion 1025 is a high performance cutting and grinding fluid for ferrous alloys. This oil-rejecting fluid outperforms conventional coolants in difficult operations. **Orion 1025** provides excellent bimetallic corrosion protection to keep parts and machine tools free from in-process rust. In hard or soft water, **Orion 1025** forms a stable solution that will not foam. **Orion 1025** is a clean fluid that runs with trouble-free dependability.

Performance Benefits

- Rejects tramp oils for easy skimming
- Biostable formula extends fluid life
- Low foaming in all water conditions
- Excellent lubrication allowing for moderate machining
- Excellent corrosion protection protects parts, machines and tools
- Settles chips quickly for a clean work environment

Recommended Applications

Application	Concentration
Grinding	4% to 6%
Light Machining	4% to 6%
Medium Machining	6% to 8%

Typical Characteristics

Appearance	Clear yellow liquid
Specific Gravity @72F	1.04 to 1.07
pH (Neat)	9.80
pH (typical operating concentration)	9.0 to 9.2
Refractive Index Multiplier	2.3