

## TECHNICAL DATA SHEET

# XP 2000

Code 7470

## Premium Semi Synthetic Metal Working Coolant

### DESCRIPTION

**Callington XP 2000** is a high-performance, chlorine free, extreme pressure semi synthetic metal working coolant. It has been formulated for use in soft water as well as hard waters, and exhibits extremely low foam and excellent stability under a wide range of conditions.

### APPLICATION

**Callington XP 2000** is designed for use in most metalworking applications and is equally suitable for use in large centralised coolant systems and for small individual coolant sumps. It can be used across a wide range of machining applications, including milling, drilling, tapping, reaming, broaching, high speed grinding and creep feed grinding.

**Callington XP 2000** is suitable for use with the latest technology high speed machining centres and flexible machining systems, where a range of machining operations are performed on a variety of different metals. It provides excellent machining performance on **steel, cast iron, copper alloys, and on difficult alloys such as stainless steel and nickel alloys, titanium and high silicon aluminium**. It is low foaming and ideal for high pressure, high volume coolant flow applications and maximises the benefits of through tool coolant delivery systems.

### BENEFITS

- Excellent surface finish and extended tool life, even in difficult operations.
- Suitable for a wide range of materials and machining operations.
- Very low foaming, even in high pressure systems over 150 bar.
- Exceptional product stability and long coolant life.
- Excellent corrosion protection, non staining.
- Non aggressive to paints and compatible with seals commonly used in machines.

### RECOMMENDED DILUTIONS

Material	Cast Iron	Low Tensile Steel	High Tensile Steel	Stainless Steel	Non Ferrous	Low Alloy Aluminium	High Alloy Aluminium	Titanium
<b>Operation</b>								
Grinding	3.5%	3.5%	3.5%	3.5%	3.5%	5%	5%	4%
Boring	3.5%	4%	5%	5%	5%	5%	7%	6%
Drilling								
Milling								
Sawing	4%	7%	7%	7%	8%	6%	7%	6%
Tapping								
Threading								
Turning								
Broaching	8%	7%	12%	12%	7%	10%	10%	10%

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**TYPICAL DATA** (note: data is typical and does not constitute a specification).

Concentrate	Test Method	Typical Result
Appearance	Visual	Clear, Amber Fluid
Density	DIN 51757/ASTM D1298	0.94
Emulsion		
Appearance	Visual	Milky White
pH5%	DIN 51361/ASTM E70-97	9.15
Refractometer Factor		1.1

**STORAGE**

Keep container closed, prevent exposure to frost, and prevent water ingress. Store in cool, dry conditions, and avoid direct sunlight. Indoor storage is preferable.

**SHELF LIFE**

The shelf-life of the product when stored under appropriate storage conditions is 12 months from the date of manufacture

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