



## TECHNICAL DATA SHEET

### REL COOL #1™

Synthetic

#### Description:

Rel Cool #1 is the concentrate base for an oil-rejecting, high-performance, synthetic cutting and grinding fluid, designed to outperform conventional sulfo-chlorinated fatty solubles in heavy-duty belt and form-grinding applications and to facilitate metal-cutting operations such as sawing, drilling, tapping, milling, turning, etc.

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#### Operating Recommendations:

- For grinding operations, dilute Rel Cool #1 concentrate with water at a ratio of approximately 25 parts water to 1 of concentrate.
  - For cutting operations, dilute in the shop-determined most effective ratio in the range between 15 to 1 and 25 to 1, depending upon the difficulty of the operation.
  - Avoid contamination of the sump with extraneous oil, foreign coolants, food materials, etc.
  - Keep fluid pH range between 8.6 and 9.2 for optimum performance.
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#### Typical Inspections:

Specific Gravity, 60/60° F, (15.6° C):	1.085
Density (lb./gal):	9.04
pH Value, Neat:	9.8 (diluted at 5%, 9.0)
Acid Value (meqKOH/g):	44
Total Alkalinity (meqKOH/g):	7.0
Appearance:	Clear, light yellow

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Features:

- is stable in solution with water at all proportions
- is low foaming
- contains additives to reject, and facilitate surface removal of tramp oils
- retains mild odor, clear appearance
- does not contain:
  - a) mineral oil
  - b) phenolic biocides
  - c) chlorinated paraffins
  - d) formaldehyde-producing biocides
  - e) diethanolamine (DEA)
  - f) nitrites

REL COOL #1  
5/01/99 Updated: 07/22/05  
04/01/08

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