



TECHNICAL DATA SHEET

OPTION 1[®]**Description:**

Relton's **Option 1** is a premium quality water-based tapping fluid designed for light to moderate duty metal-working applications, where the highest degree of lubrication and cooling is required. It can be used on all ferrous and non-ferrous metals except magnesium. It can be used in general machining, including sawing, drilling, milling and turning. It is ideal for grinding due to its superior wetting and cooling capabilities.

Option 1 is formulated with non-toxic ingredients and is highly recommended for use in applications where oil contamination must be avoided.

Typical Uses:

- Recommended for most machining operations, e.g. tapping, drilling, boring, threading, milling, broaching, turning, engraving, reaming, grinding, and sawing
- Recommended for light to moderate machining operations on a wide variety of metals. (Note: Do not use on magnesium because of Option 1's water content.)

Typical Inspections:

API Gravity, @ 60°F:	8.80
Specific Gravity, g/cc, @ 60°F:	1.0086
Pounds per gallon:	8.40
Viscosity @ 40°C, cst:	1.42
pH:	7.6
Boiling Point:	105°C, 221°F
VOC:	0.0 grams per liter (Rotovac stripping at 50°C)
%Volatile by Volume:	80
Vapor Pressure (mm Hg):	<5 at room temperature
Color/form:	blue-green/liquid

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Features:

- is non-toxic; does not contain 1,1,1 trichloroethane or any other ozone-depleting substance
 - resists bacterial attack
 - provides rust and corrosion protection of machine and machine parts
 - is non-staining; suitable for copper and aluminum alloys
 - has excellent wetting and cooling capabilities
 - is non-foaming
 - is non-gumming
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Option 1
2/10/97 7/22/05
04/01/08

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