



Chemical Division

## TECHNICAL DATA SHEET REL SAW™

Semi-Synthetic  
Band-Saw-Fluid Concentrate

### Description:

Rel Saw is a high quality semi-synthetic sawing fluid, which exhibits excellent bio-stable properties without the use of biocides and/or fungicides. The product does not contain chlorinated additives, phosphorus, DEA (diethanolamine), or nitrites. As it contains no biocides, no phenolic and/or formaldehyde compounds are found within this product.

### Typical Uses:

- Formulated specifically for sawing operations with dilution rates ranging from 10:1 to 20:1.
- Does not contain chlorine, sulfur, or silicone.
- Safe for all ferrous & non-ferrous metals (except magnesium).

### Typical Inspections:

Flash Point (COC) °F:	330°F
Specific Gravity, 60/60F:	1.02
Density (lb./gal):	8.5
pH Value, 5% emulsion:	9.2
Acid Value (meqKOH/g):	3.4
Total Alkalinity (meqHCL/g):	8.4
Appearance:	Clear Amber Fluid

Operating Recommendations:

- For sawing operations in carbon steels, malleable iron, or cast iron, dilute concentrate with soft or deionized water in the range of 10:1 to 20:1.
  - For sawing operations in tool steel and high-speed alloys, dilute concentrate with soft or deionized water in the range of 10:1 to 15:1.
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Features:

- Improves blade life.
- Is stable over a wide variety of water conditions.
- Reduces machine wear.
- Designed to entrain a slight amount (1-2% vol.) of tramp oil for additional lubricity. Excess tramp oil freely floats to the surface for easy skimming and removal.
- Promotes cleaner running machines compared to soluble oils.
- Has long emulsion life.
- Contains rust and corrosion inhibitors.
- Fortified with boundary lubricants.

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5/01/99 07/22/05 04/1/08

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