



## Semi-Synthetic Cutting Fluid for Heavy Duty/Severe Machining

KOOLRite 2365 is a new generation semi-synthetic, chemical emulsion that uses advanced cutting fluid technology to provide a new level of machining performance. KOOLRite 2365 outperforms heavy duty chlorinated soluble oils, semi-synthetics, and newer polymer-based synthetic coolants with a machining performance not seen in any competitive coolant.

KOOLRite 2365 is designed for heavy duty/severe machining operations on all metals with excellent performance on tough aerospace alloys where high finish important. It has proven performance on metals with less than 15% machinability and high nickel alloys.

KOOLRite 2365 is formulated with JTM's unique **BioArmor Technology** which gives outstanding control of bacteria without the use of bactericides. BioArmor stops sump odors, gives you exceptionally long sump life and a clean, comfortable, safe work environment for machine operators.



*Multi-metal capability. Outstanding results on stainless and high nickel alloys.*

KOOLRite 2365 will reject tramp oils, allowing clean coolant to be delivered to the chip/tool interface keeping your machine tool clean with a minimum of residual film, while providing excellent corrosion control.

### KOOLRite 2365 ADVANTAGES

Non foaming even in high pressure coolant applications

Excellent for aluminum machining

Leaves a light oil film for excellent corrosion inhibition on machines and parts

Kind to paint, seals and machine components

Allows machining to very high finishes

Guaranteed long sump life due to excellent biological resistance. Reduces coolant consumption

Lower annual disposal costs

Does not contain phenols, nitrites, chlorine, bactericides or DCHA

### Applications

KOOLRite 2365 is recommended for turning, milling, drilling, and grinding. It is particularly well suited to NC and CNC machines and machining centers. Excellent for sawing applications.

## Unique BioArmor™ Technology



**BioArmor Technology** means built-in resistance to bacterial growth without the use of bactericides. Only KOOLRite has it!



*KOOLRite Formulation Does Not Support Bacterial Growth*



*Competitive Coolant Teems with Bacteria*

### THE KOOLRite CHALLENGE:

**KOOLRite 2365** will improve your machining performance or we will refund your money.

## Recommended Starting Dilutions

Operations	Iron & Carbon Steel	High Alloy & Stainless Steels	Tool Steels	Aluminum	Copper Alloys
Grinding	4% to 5%	4% to 6%	5% to 6%	5% to 7%	4% to 5%
Milling, Drilling, Turning, Cut-off, Sawing, Screw Machining	5% to 7%	7% to 8%	6% to 8%	5% to 7%	5% to 7%
Tapping, Reaming, Broaching and Form Milling	5% to 7%	8% to 12%	8% to 10%	8% to 10%	5% to 7%

## Directions for Use

The sump life of this coolant, as with any other coolant, will be greatly enhanced if charged to a clean system. You can utilize JTM's Sump Cleaner to disinfect your sump. KOOLRite 2365 can be metered through automatic dispensing systems available from JTM. Contact your representative regarding cleaning procedures and dispensers. **Always add the KOOLRite 2365 concentrate to the water** and not the water to the concentrate. Proper maintenance by removing tramp oils is beneficial for extended coolant life. The concentration can be monitored by refractive index.

Refractive Index .....1.71 (Refractive reading x 1.71 = % of concentration of dilution)

## Product Data

### Appearance:

Concentrate           Amber  
10% Dilution       Milky

**pH (concentrate):** 8.91

**pH (10% dilution):** 8.30

**Density (lbs/gal):** 8.42

## Recommended Metals

Aluminum Alloys	Cast Iron
Nodular Iron	Carbon Steel
Tool Steel	High Alloy Steel
Stainless Steel	Titanium
High Ni Steel	Copper Alloys



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Material Safety Data Sheets are available for all products. All reasonable care has been taken to ensure that the above information is accurate as of the date of printing.

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