

## PRODUCT DATA SHEET

# RYE BIOGRIND

**DESCRIPTION** Rye Biogrind is a biostable, nitrite free grinding base formulated to give a clear translucent solution when mixed with water. This formulation is designed to offer extreme wetting out characteristics and shows excellent wheel flushing capabilities, without foam, even under the most aggressive grinding operations. Suitable for most grinding operations including cylindrical, centreless and some creepfeed types.

**APPLICATION** General machining of ferrous and non ferrous metals.

**USUAGE RATE** 6 - 8% depending on application and water hardness.  
Refractometer correction factor x 1.65

**ADVANTAGES**

1. Excellent wheel flushing characteristics.
2. Zero scum in hard water, low foam in soft water.
3. Long sump life.
4. Excellent corrosion protection.
5. Good lubrication for a quality finish.

**TYPICAL DATA**

Appearance	: Clear amber viscous liquid
Odour	: Mild
Sp gravity @ 15°C	: 1.04 - 1.055
pH@5%in water (200ppm CaCO <sub>3</sub> )	: 9.5
Miscibility in water	: Complete to give a clear translucent solution
Corrosion breakpoint IP287 200ppm CaCO <sub>3</sub>	: 70:1 clear paper

**STORAGE** Store away from extremes of heat and cold.

**DISPOSAL** Dispose of in accordance with statutory regulations.