

280D
Precision Glass Grinding Fluid

280D is a fully synthetic glass grinding fluid for use in high-volume automated production lines. 280D features high rates of removal, rapid controlled settling, low energy consumption, and greatly extended wheel wear rates.

Note: 280D is specifically formulated to be used in coolant systems that have high volumes of acid based materials being introduced into them such as Lucor or Boric acid. Operating pH should be in the 8.8 to 9.3 range after a few days of plant operation.

Lubricity – 280D features a concentrated lubricity package for removal rates up to 40% higher than those of most competitive fluids.

Lower Power Consumption – Because of its superior lubrication package 280D cuts power requirements by substantially lowering the coefficient of friction at the wheel/glass interface, substantially reducing the amount of power needed.

Extended Wheel Life – 280D significantly extends the life of most diamond wheels while providing a high-quality finish.

Controlled Settling – 280D is formulated with an efficient settling additive package. This package allows the glass fines to settle out of solution in a controlled manner, eliminating build up in return lines and on machine parts. When it is time to clean settling tanks and automatic swarf removal equipment, the residue can be either shoveled out or simply washed out with water.

Biologically Stable – 280D provides excellent resistance to biological deterioration. Each component in the formulation is selected for its resistance to attack by bacteria and fungus. 280D uses no toxic biological control agents that may harm worker's skin or upper respiratory system.

Starting Dilutions – 280D is to be used at a dilution of 50:1 to 100:1 (2%) in water, depending on the severity of the job, wheel type, and required line speed.

Extended Sump Life – Because of new more stringent waste disposal regulations, coolants today must provide longer service life. When managed correctly, 280D can last twice as long as normal coolants. To obtain maximum life from 280D, test for suspended solids once a week. Once solids level has been determined, simple post treatment in the existing tank will clear the fluid of most unwanted glass fines and leave the fluid ready for another week of high-speed operation. To learn more about how to post treat 280D contact your Ferro representative or your distributor.

Automated Dilution Control – 280D can be diluted by several methods. Simple venturi dilution systems work well for smaller users. If more accuracy is required for high-volume users, consider using our Automated Dilution Control Station, which is accurate to one quarter of one percent.

Custom Options – 280D can be custom formulated to meet special performance requirements, such as increased line speeds, extended wheel life, or swarf removal.

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Contains No Silicone – 280D contains no silicone, diethanolnitrosamine, nitrites, phosphates, PCBs, PTBBA, mercurial, phenols, or mineral oils.

Recommended Starting Dilutions

Beveling	50:1 to 100:1
Lens Generating	30:1
Edging	75:1 to 100:1
Surface Grinding	50:1

Typical Properties

Appearance	Transparent Green Liquid
Volatile Component	Water
Freeze Point	32°F
Boiling Point	212°F
pH	9.4 - 9.8
Evaporation Rate	NA
Odor	Mild
Vapor Pressure	NA
Vapor Density	NA
Specific Gravity	1.04 - 1.05
VOC	None
Weight per Gallon	8.65 - 8.75
Solubility in Water	Infinite

Packaging and Handling – 280D is a liquid packed in non-returnable drums, Tote Bins, Pails, and Bulk. Refer to the Material Safety Data Sheet for suitable materials of construction, for handling, and storing of this product. Observe all safety precautions shown on the label and in the Material Safety Data Sheet.

Health	1
Flammability	1
Reactivity	0
Personal Protection	B

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