

Technical Data



Performance you can trust

TRI-Logic® HPX

Maximum life, chlorine free, EP cutting fluid for aluminium and its alloys

Product Overview

ROCOL® TRI-Logic HPX is a premium quality, chlorine free, EP, water mix cutting fluid designed to be used as part of the Rocol TRI-Logic system.

TRI-Logic HPX is formulated from a unique blend of specially selected additives to maximise in-sump life.

TRI-Logic HPX is designed for heavy duty machining operations on a wide variety of metals such as steel, stainless steel, aluminium and its alloys.

The combination of lubricity and extreme pressure additives in TRI-Logic HPX prevents built-up edge, extend tool life and promote excellent surface finish.

The Rocol TRI-Logic system is a revolutionary approach to maximising cutting fluid sump life, minimising fluid disposal and reducing costs. For optimum performance the TRI-Logic cutting fluids should be used with TRI-Logic VG68 slideway oil and, where applicable, TRI-Logic RTD tapping fluid.

Features and Benefits

- TRI-Logic HPX has excellent inherent stability providing a long and predictable sump life.
- TRI-Logic HPX provides excellent residual corrosion protection.
- TRI-Logic HPX gives maximum cutting performance on steel, stainless, aluminium and its alloys.
- TRI-Logic HPX prevents built-up edge and extends tool life particularly on roll tapping.
- TRI-Logic HPX promotes excellent surface finish.
- TRI-Logic HPX is chlorine free and is suitable for use in hard and soft water areas.
- The performance of TRI-Logic HPX is optimised for use in the TRI-Logic system.

Directions for Storage and Use

- TRI-Logic HPX should be used between 15:1 and 30:1 depending on the material being machined, the severity of operation and the water hardness.
- To ensure dilution accuracy, it is preferable to use a Rocol Automatic Fluid Mixer. For manual mixing, add the concentrate to the water at the recommended dilution ratio, stirring continuously.
- It is advisable to use the appropriate Rocol ULTRAGUARD® Machine Tool Care product at fluid changeovers. Optimum fluid life is obtained by adequate initial machine cleaning, correct dilution control and regular maintenance of the fluid, particularly prior to weekends and shutdown periods.
- For optimum performance the TRI-Logic system should be fully utilized.
- TRI-Logic HPX should be stored in a cool, well ventilated area, between +5°C and +30°C, in the original container.
- If stored in accordance with the above guidelines, shelf life is 1 year from date of manufacture.

Typical Applications

- Heavy duty machining operations on a wide variety of metals such as steel, stainless steel, aluminium and its alloys.

Pack Sizes

Pack Size	Part Code
200L	51979

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FM 12448



EMS 67596



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Property	Test Method	Result
Appearance:		
Concentrate	N/A	Clear amber liquid
Mixed with water	N/A	White emulsion
Odour	N/A	Mild
pH	N/A	8.6 at 25:1 dilution
Density at 20°C	N/A	0.97 g/cm ³

Refractometer Calibration:

Dilution Ratio	5:1	10:1	15:1	20:1	25:1	30:1	35:1
Refractometer Reading	14.2	8.5	5.5	4.2	3.5	3.1	2.4

Values quoted above are typical and do not constitute a specification.

Safety Data Sheets

Safety data sheets are available for download from our website www.rocol.com or may be obtained from your usual ROCOL contact.

The information in this publication is based on our experience and reports from customers. There are many factors outside our control or knowledge which affect the use and performance of our products, for which reason it is given without responsibility.

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