



# SYN-COOL 2560-RL

## SYNTHETIC METALWORKING FLUID

**SYN-COOL 2560-RL** is a heavy duty, full synthetic metal cutting, machining & grinding fluid for ALL metals. 2560 is free of Sulfur, Chlorine, Phosphorous and Nitrite. Provides extremely high lubricity in metalworking applications. Provides bright non-staining finish on aluminum.

2560 provides extra tool life where high temperature can be experienced, bright finish and long solution sump life. It offers excellent rust protection, tramp oil rejection, low foam properties and microbial resistance.

Unique biodegradable synthetic solution based on synthetic polymer additives and anti wear additives. 2560 is employee friendly and does not support bacterial growth.

### Features & Benefits

- Easily filtered and maintained for extended sump life.
- Employee friendly, milder operating PH of 9.0-9.9
- Environmentally safe: contains no chlorine, nitrites, sulfur, phosphorous.
- Resistant to bacteria, eliminating odors and employee complaints.
- Provides excellent corrosion protection.
- Non Foaming

### Typical Processing

Clean coolant sump with alkaline detergent, Purge Cleaner  
Rinse sump with fresh water.

Determine level of sump in gallons and add % by volume of #2560 into sump and circulate into solution. Keep sump free of debris. Filter as necessary.

**DILUTION RATIOS RECOMMENDED:** Bandsaw: 2-10%, Surface Grinding  
1.0-6.0 % Turning & Milling 4.0-10% Drilling & Tapping 4.0-10%  
Rust Inhibitor 2.0-5 %



## Product Bulletin

Product Name: SYN-COOL 2560-RL  
Product Code: 2530029  
Revision Date: June 17, 2025

### Specifications

pH	9.9
Prod._Type	Liquid
Spec.Grav	1.05
LBS./GAL	8.76
FOAM 0=low 9=high	2
Shelf life years:	10
Freeze information	Not damaged by freezing

### Packaging

Container Type	POLY
Net Units	480
Tare Wt.	25
Gross Wt.	505
Dot_Name	Not Regulated by D. O. T.
DOT Hazzard	Not Regulated
Tariff ID	N/A

### Use parameters

Concentration Range	1-20% by Vol
Range	Ambient
Time Range	N/A
Agitation	Circulate

### Other information

It is important that the **OSHA DATA, "Material Safety Data Sheet"** be carefully read and reviewed with the users of this product. OSHA data is required to be posted in the work area by law.

### Waste Disposal

Remove Fats, Oils, Grease and Metals

### Holding Tank Materials of Construction

Steel, Stainless or Poly.



# Holding Tank Materials of Construction

## **Refractance:**

20% = 7.0 (deg. Brix)

15% = 5.25

10% = 3.5

5% = 1.75

3% = 1.0

## **Ph:**

Target A Ph Of 9.0-9.9

Ask A Torch Rep For Assistance with Ph Adjustment.

## **Titration:**

1) Take A 10 MI Sample

2) Add 5-7drops Of Bromo Blue Indicator (or Equivalent Total Alkalinity Indicator)

3) Titrate With 0.1n Acid

4) The # Of Mls Required to Achieve A Color Change Multiplied By A Factor Of 0.725 = % By Volume

## **Operating Guidelines And Solution Maintenance:**

- 1) Keep Solution Free of Contaminating Oils Leaking from Machine Seals or from Metals.
  1. (Note: Floating Layers of Oils Can Trap Odors and Create Bacteria or Fungus in The Solution.
- 2) Monitor Ph Of Solution and Keep In Range. (Note: A Low Ph Can Cause Rust, Bacteria, Fungus, Odors)
- 3) Filter Solutions to Remove Metal Fines and Other Contaminants When Possible.
- 4) Maintaining Circulation on The Coolant Sump Is Highly Recommended for Best Solution Life.
- 5) If Bacteria, Fungus and Related Odors Are a Problem, Identify the Source and Try to Minimize Contaminant. Treat The Bath for Bacteria with Materials Such As "omadine", "bioban", "kathon", Hospital Strength Lysol, or Other Suitable Bacteria Control Materials.
- 6) Periodic Purging and Cleaning of the Coolant Sump Is Necessary. Products Such As Power Clean Aps-1033, Hds-1022, Crm-3 Are Ideal for Purging the Coolant Sumps. Small Amounts of Chlorine Bleach (2-3 Oz/gallon) Along with The Cleaner Is Ideal for Cleaning Also.
  - A) Dump Coolant Sump.
  - B) Remove And Rinse Mud, Metal Fines and Any Sludge from Tank Bottom.
  - C) Circulating Cleaning Solution in Sump System to Clean Lines and Pump At 2-5% By Volume For
    - 1- 4 Hours (or As Needed).
  - D) Rinse Sump.
  - E) Recharge System with Coolant.

## **Typical Site Monitoring Controls: ( 8-2016):**

- 1) Refractance For % By Volume
- 2) Ph
- 3) Chlorides
- 4) Bacteria Count / Fungus



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## Our People. Your Problem Solvers.

For more information on this process,  
please call us at 203.756.5521 or email: [techservice@hubbardhall.com](mailto:techservice@hubbardhall.com)

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