



FISKE BROTHERS REFINING COMPANY

NEWARK, NEW JERSEY 07105 • TOLEDO, OHIO 43605

FISKE'S HP-76

HP-76 is a synthetic, water soluble fluid recommended for grinding as well as machining. **HP-76** is recommended for both ferrous and non-ferrous metals as well as for the exotic types of metals so widely used today. **HP-76** can produce transparent dispersions at any dilution giving machine operators visibility of the work.

Outstanding features of HP-76 are:

- Low foaming properties
- Exceptional high film strength and excellent anti-weld properties
- Completely stable, once diluted it will not separate
- Highly transparent at any dilution
- Possesses inherent cleaning properties that keep both the machine and work clean and free of gumming and sticking

Suggested dilution ratios are listed below:

<u>Operations</u>	<u>Starting Dilution Parts Water to HP-76</u>
Turning, Facing, & Shaping	15 to 1
Milling, Planing, Reaming, Boring, & Sawing	10 to 1
Drilling	20 to 1
Tapping Broaching (light), & Stamping	5 to 1
Grinding	50 to 1

When mixing **HP-76** with water, the hardness of the water will have some effect on the clarity of the solution. Water testing over 5 grains is considered hard. As an example, Toledo city water tests 60 ppm or 3.5 grains per gallon whereas Detroit city water tests 100 ppm or 5.8 grains per gallon.

To obtain a translucent solution, the following table is a guide when mixing HP-76 with hard water:

<u>Dilution</u>	<u>Maximum water hardness</u>
10:1	400 ppm or 23 grains per gallon
20:1	200 ppm or 12 grains per gallon
30:1	133 ppm or 8 grains per gallon
40:1	100 ppm or 6 grains per gallon
50:1	80 ppm or 5 grains per gallon

Water hardness exceeding the above table should be subjected to water softening treatment before mixing with water soluble compounds.

(Over)

TYPICAL CHARACTERISTICS:

Viscosity @ 100°F., SUS/cSt	34/2.4
Flash Point °F./°C.	None
Fire Point °F. /°C.	None
API Gravity	6.0
Sulfur	No
Chlorine	No
Synthetic	Yes
Fatty Material	Yes
Color	Straw

HP-76 is available in the following:

<u>Packaging Available</u>	<u>Part Number</u>
Ctn. 4/1 gallon jugs	F0534-056
5 gallon pail	F0534-060
55 gallon drum	F0534-062