



# CoolSpar®

**dye and perfume free synthetic cutting fluid**

CoolSpar is a general purpose, multi duty, synthetic chemical coolant for most metals on most operations performed by the metalworking industry today.



Providing Quality Maintenance and Chemical Specialty Solutions with Unparalleled Customer Service



Spartan Chemical Company, Inc.  
 1110 Spartan Drive  
 Maumee, OH 43537  
 1-800-537-8990  
 www.spartanchemical.com

**NITRITE FREE:**

Nitrite is a known contributor to the formation of nitrosamines (a suspected cancer-causing agent or carcinogen). Since safety is always a major concern, CoolSpar was formulated without nitrite providing maximum performance and worker safety.

**SAFE TO THE ENVIRONMENT/OPERATOR FRIENDLY:**

CoolSpar does not contain nitrites, nitrates, phenols, creosols, harsh alkalis, phosphates, chlorine, sulfur, heavy metals, PCB's, PTBB's, MEA, DEA, or any other raw material considered hazardous to the environment or to the individual. Since CoolSpar does not contain nitrites, there will be no formation of nitrosamines which OSHA has deemed a possible carcinogen. Operators like the clear color which provides excellent work visibility. CoolSpar is odorless and does not give off any offensive fumes or fragrance.

**EXTENDS TOOL LIFE & IMPROVES SURFACE FINISH:**

Specialy formulated for use in heavy duty operations on hard-to-machine metals such Inconel, Hastelloy, Titanium and Stainless Steel, CoolSpar substantially increases tool life and surface finish on these hard-to-machine metals. In addition, CoolSpar provides excellent results on the light-to-medium duty type operations such as turning, milling, spot facing, and the other more moderate operations on the more common metals such as steel, brass, aluminum, cast iron, etc.

**SUPERIOR WETTING & DETERGENCY:**

Low foaming, high wetting CoolSpar quickly penetrates to the point of cut providing a cooler, cleaner, smoke-free operation.

**COMPLETELY WATER RESOLUBLE RESIDUE:**

CoolSpar was formulated without oil to leave a completely water resoluble film on the machine and parts. No sticky, gummy, tacky or concrete-like residue to tie up machines and create excessive maintenance costs.

**EXCELLENT RANCIDITY CONTROL:**

Formulated with high quality, bacterial-resistant raw materials, CoolSpar provides excellent rancidity and odor control.

**MULTI-METAL SAFE:**

CoolSpar contains a multitude of superior corrosion inhibitors to provide corrosion and stain protection on cast iron, steel, aluminum, brass, copper and most modern alloys machined today.

**REJECTS TRAMP OIL:**

Employing state-of-the-art formulation techniques, CoolSpar rejects tramp oil emulsification for ease of removal through skimming. By frequently removing the tramp oil from CoolSpar you remove the home for bacteria and keep the coolant fresh and sweet smelling.

**EXCELLENT FILTERABILITY:**

CoolSpar works extremely well with diatomaceous earth, positive media, cyclonic and settling type filtration units.

**WHERE TO SELL:**

A number of large metalworking facilities such as General Motors, Ford, Chrysler, etc. either have in place or will have in the near future a number of restrictions on chemical compositions for a coolant that they use in their facilities. Among these restrictions are ingredients such as phenols, creosols, nitrates, nitrites, PCB's, PTBB's, MEA, DEA and butyls. This means if a coolant contains one or more of these compounds it could not be sold to these large facilities. This also includes job shops that would sub-job any part that would be sold directly to these larger facilities. CoolSpar was formulated free of all of these restricted ingredients and provides you with a perfect product to sell to these larger corporations today and in the foreseeable future.

CoolSpar was formulated with EPA and OSHA standards in mind as they stand today as well as what we believe will happen in the foreseeable future. There is no chemical ingredient in

CoolSpar which must be labeled on the MSDS as hazardous nor is there any ingredient in CoolSpar that would be considered prohibitive to enter into most sanitary sewer systems.

CoolSpar is the ideal product for these large corporations for their single machines as well as their multi-gallon central systems. CoolSpar is unsurpassed in providing tool life, surface finish, and overall economy to these large users as well as to the small tool and die shops.

CoolSpar can be diluted 2:1 to be used as a spray on or brush on tapping compound. Many tapping compounds contain chlorinated solvents to improve the tap life. CoolSpar is solvent-free, chlorine-free and provides a much safer tapping compound for any metalworking facility. When CoolSpar is diluted 10:1 it makes an excellent rust preventative dip or spray for inside storage of machined parts, tools and for the machine itself.

**DIRECTIONS FOR USE:**

A concentrate designed to be diluted with water, CoolSpar forms a clear solution in a wide range of water temperatures and hardnesses.

1. To insure a uniform solution, mix CoolSpar with water at the appropriate concentrations in a separate container. (Refer to Recommended Starting Concentration Chart.)
2. Agitate solution until thoroughly mixed.
3. Add the mixed coolant to the cleaned sump.
4. **Makeup:** When adding makeup to the machine, add CoolSpar at 1/2 to 2/3 the concentration desired in the machine. For example, startup of 10:1 requires 20:1 makeup. Always add **diluted** solution as makeup; never plain water.

NOTE: To prevent any white discoloration when using CoolSpar on galvanized parts, be sure concentration is 20:1 or stronger.



PACKAGING	
298765	330-gallon totes
298760	275-gallon totes
298755	55-gallon drum
298705	5-gallon pail

Label copy is provided in English, Spanish and French. Secondary labels are also available.

GUARANTEE: Spartan's modern manufacturing and laboratory control insure uniform quality. If dissatisfied with performance of product, any unused portion may be returned for credit within one year of the date of manufacture. Use product as directed and read all precautionary statements.



Product available worldwide. For institutional and industrial use only.

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**CoolSpar Dilution Ratio vs. Refractive Index\***

5-1	6.4
10-1	3.2
15-1	2.1
20-1	1.5
25-1	1.2
30-1	1.0
35-1	0.8
40-1	0.7
50-1	0.5

\*American Instrument Model 10440 Industrial Fluid Tester

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Be sure to read all Directions, Precautionary and First Aid Statements on product labels before use of this or any IPG/Spartan product. Material Safety Data Sheets for all IPG/Spartan products are available from your authorized IPG/Spartan distributor.

**Formula for determining Total Volume by Gallons**

$$\frac{\text{Width x Length x Height (in inches)}}{231} = \text{Total Sump Capacity in Gallons}$$

**RECOMMENDED STARTING CONCENTRATION (parts water to parts CoolSpar)**

	Gray Cast Iron	Ductile Iron	Brass Alloys	Mild Steel	Stainless Steel	Aluminum Alloys	Copper Alloys
GENERAL TURNING	25-1	20-1	20-1	20-1	15 to 20-1	20-1	20-1
BORING	15-1	15-1	20-1	20-1	15-1	15-1	15-1
PLANING SPOT FACING	20-1	20-1	20-1	20-1	15-1	15-1	15-1
GENERAL MILLING	20 to 25-1	20-1	20-1	20-1	15 to 20-1	20-1	20-1
DRILLING	10 to 15-1	10-1	10-1	10-1	10-1	10-1	10-1
TAPPING / REAMING	10-1	10-1	10-1	10-1	10-1	10-1	10-1
GEAR CUTTING HOBBING	10-1	10-1	10-1	10-1	10-1	10-1	10-1
SAWING	20-1	15-1	10-1	10-1	10-1	15-1	15-1

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