



SOLUBLE OIL

Cutting Oil

Issue: April 2015

Product Code	Pack Size	Ctn / Qty
SOL005	5 Litre	4
SOL020	20 Litre	1



PENRITE

Description

The general-purpose, low odour soluble cutting oil designed as a coolant and lubricant during metalworking operations. It is made from hydro-treated base oils and a special blend of inhibitors, lubricity additives and emulsifiers. It forms a white emulsion and contains a bactericide.

Application

Suitable for general purpose cutting operations on low and medium tensile steels, free machining of brass bronze and cast iron. It may also be used as a grinding fluid in non-critical applications. (refer to below chart for ratio and applications). Not suitable for high tensile or stainless steel or nickel alloys.

USAGE CHART

	Aluminium & Alloys	Brass / Bronze	Copper	Iron / Cast	Steel, mild steel, low alloy steel, carbon steel
Operation					
Milling	20:1	20:1	20:1	20:1	15:1-10:1
Drilling	20:1	20:1	20:1	20:1	15:1-10:1
Boring	20:1	20:1	20:1	20:1	15:1-10:1
Reaming	20:1	20:1	20:1	20:1	15:1-10:1
Turning	20:1	20:1	20:1	20:1	15:1-10:1
Cold Sawing	30:1	20:1	20:1	15:1	NA
Threading	NA	20:1	20:1	15:1	NA

Product Benefits

- Forms highly stable emulsions.
- Helps prevent rust and corrosion.
- Low foaming.
- Resists biological degradation.
- Low odour
- Extends tool life
- Improves surface finish
- Non staining to ferrous and non ferrous alloys
- Phenol and nitrite free

Typical Data

Colour	Brown
Colour, Emulsified	Creamy White
Density at 20°C, kg/L	0.897
Viscosity, Kinematic, cSt at 40°C	39
pH @ 2% Treat	9.1

Information in this sheet is based on recent production. Minor variations to typical properties are expected in normal manufacture and do not affect product performance. An MSDS is available on request.



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