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SOLUBLE OIL

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PRODUCT CODE	PACK SIZE	CARTON QTY
SOL005	5L	4
SOL020	20L	

PRODUCT BENEFITS

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

APPLICATION

Soluble Oil is 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

Operation	Aluminium & Alloy	Brass & Bronze	Copper	Iron / Cast	Steel, mild steel, low alloy steel, carbon steel
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
Boaring	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	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

PRODUCT PERFORMANCE LEVELS

TYPICAL DATA

Colour	Amber
Density at 20°C, kg/L	0.897
Viscosity, Kinematic, cSt at 40°C	39
Viscosity, Kinematic, cSt at 100°C	0
pH @ 2% Treat	9.1
Flash Point, °C	168