

Product Description

Soluble Cutting Oil EP is a heavy duty, high EP, soluble oil which forms a highly stable, semi translucent emulsion when mixed with water. .

Product Features & Benefits

Soluble Cutting Oil EP is formulated from solvent refined mineral oil and specialized, high performance extreme pressure (EP) additives. For overall performance **Soluble Cutting Oil EP** contains emulsifiers, corrosion inhibitors, and extreme pressure lubricants. It can be used on a range of metal types inclusive of yellow metals. It contains a very effective biocide package which protects the in-use emulsion from both bacteria and fungus.

Soluble Cutting Oil EP provides excellent emulsion stability in hard water up to 400ppm (expressed as calcium carbonate).

Soluble Cutting Oil EP

- *Has excellent wetting characteristics*
- *maximises tool life and provides an excellent surface finish*
- *Contains a fungicide and biocide to reduce spoilage and odours.*
- *Good corrosion inhibition to maintain a rust free environment for machine tools and finished parts.*

Application Information

Soluble Cutting Oil EP is a concentrate and must be mixed with water for use. To mix add the Soluble Cutting Oil EP concentrate to water with mixing to form a stable milky emulsion. The dilute working solution should contain between 5 and 15% of the concentrate depending on the severity of the operation to be performed.

Typical Characteristics

Appearance of Concentrate	Brown Oil
5% Emulsion Appearance	Milky white
Density @20°C of Concentrate	0.91

Recommended Dilutions for Specified Applications

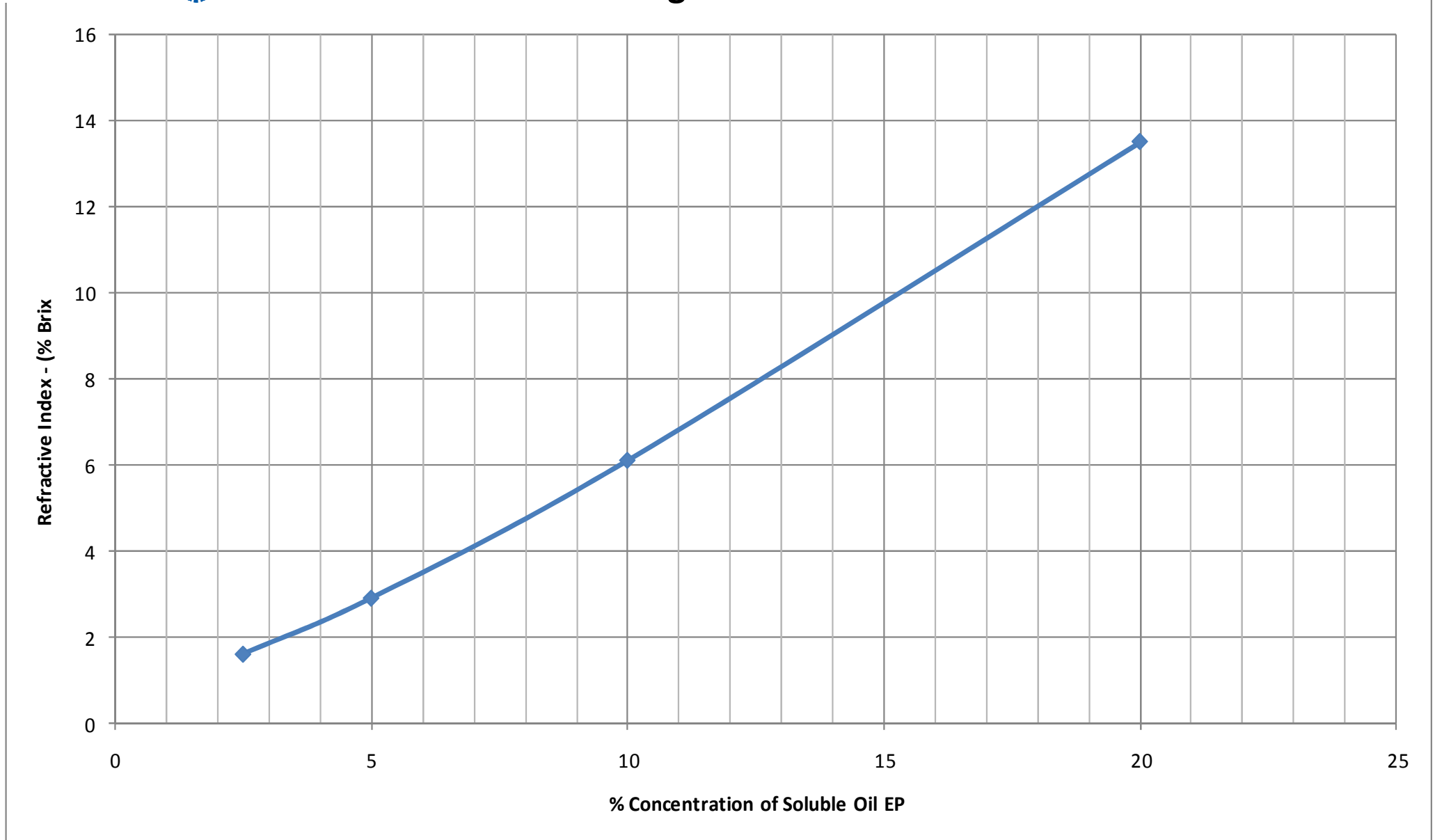
	Ferrous	Non Ferrous	Alloy
Tapping	5% to 7%	5% to 7%	5% to 10%
Broaching/Gear Hobbing	5% to 7%	5% to 7%	5% to 10%
Threading	5% to 7%	5% to 7%	5% to 10%
Deep Hole drilling/ Gun Drilling	5% to 7%	5% to 7%	5% to 10%
Stamping	5% to 10%	5% to 10%	
Grinding	3% to 5%	3% to 5%	
Sawing	5% to 7%	5% to 7%	
Milling	5% to 7%	5% to 7%	
Reaming	5% to 7%	5% to 7%	
Turning/Boring	5% to 7%	5% to 7%	
Drilling	5% to 7%	5% to 7%	
Screw Machining	5% to 7%	5% to 7%	

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Soluble Cutting Oil EP - RI v %Conc



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