

SOL 78

Product code: 265300501

Grinding and general machining soluble coolant

This product is a semi synthetic metalworking fluid which forms stable micro emulsions when mixed with water. Due to the special bacteriostatic character ensures a great biological resistance not being necessary to add biocides or fungicides. The emulsions lifetime last longer than other conventional products non-generating additional maintenance costs. The product does not produce impact on operators and protects the machine from rust. All results in an economic fluid management.

The product is suitable for a wide variety of machining operations and grinding on all grades of steel and cast iron.

The product is suitable for centralized systems and independent machines.

Benefits & Advantages

- High anticorrosive properties
- Good cooling
- Excellent service life
- Environmentally acceptable
- Does not contain nitrite or chlorine.
- Does not form sticky deposits on machine surface.
- Economical in use

Typical Performance Data Neat Product

Typical	Test Method	Value
Appearance		Clear amber liquid
Specific gravity @ 20 °C, gr/cm3		1.02
Sodium nitrite		Free
Chlorine content		Nil

Typical Performance Data – 4% emulsion (in tap water 20°HF)

Typical	Test Method	Value
Appearance		Amber translucent
pH		9.4
Corrosion test IP-287		No corrosion
Copper corrosion		Nil

All performance data on this Technical Data Sheet are indicative only and can vary during production.

SOL 78

Product code: 265300501

Mixing

This product is easy to mix. Simply pour the concentrate into water at the appropriate solution and mix. Hardness of water should be between 50 ppm and 600 ppm and chloride content not superior to 0,1 gr/lit. It is recommended to use between 4 to 7% depending on severity of application. For severe machining from 7 to 10%. For grinding operations from 3 to 6 %.

Dilutions can be easily checked by Refractometer:
% Concentration = Refractometer reading x 1,5

Storage

Soluble oils are susceptible to frost damage. Store containers indoors to protect extremes of temperature.