

# SOL PLUS 10

Product code: 265302001

## Biostatic soluble coolant

This product is a biostatic metalworking fluid, developed for the extremely demanding application in most types of machining operations which require water-based solutions. The product is formulated from selected materials which will not support sump bacteria, which are the cause of separation of conventional emulsions, smell problems and corrosion of components and machine tools.

It is suitable for a wide variety of machining operations, turning, milling, boring, tapping, sawing, on ferrous metals, cast iron, steel and its alloys and aluminium. It is formulated to meet the exacting demands of modern production engineering techniques.

## Benefits & Advantages

- Does not form sticky deposits on machine surface
- Good swarf settling properties
- Eliminates bacteria growth
- Operator friendly
- Environmentally acceptable
- Does not contain nitride, chlorine or phenols
- Excellent service life
- Economical in use

## Typical Performance Data - Neat Product

Typical	Value
Appearance	Clear amber liquid
Colour	Transparent
Density @ 20 °C, gr/cm <sup>3</sup>	0.95
Sodium nitrite content	Free
Chlorine Content	Nil

## Typical performance data - 5% emulsion (in tap water 20 HF)

Typical	Value
Appearance	Milky Emulsion
pH	9.2
Corrosion Test IP-287	No corrosion
Corrosion Test IP-125 (Herbert)	0

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

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## Mixing

Recommended for water from 5 to 400 ppm and chloride below 0.1 gr/l. It is recommended between 3 - 10% depending on severity of application. For normal machining 4 - 6%. For stainless steel 7-8%. Please keep concentration minimum at 5% when cast iron is machined.

## In service strength control

Dilutions can be easily checked by refractometer:  
% Concentration = Direct refractometer reading