

# SOL PLUS 270

Product code: 265303101

## Multi-functional semi-synthetic soluble cutting fluid

This product is a formaldehyde free semisynthetic soluble cutting fluid that forms very stable micro emulsions and does not contain chlorinated compounds, nitrites or secondary amines. Due to its special formulation ensures a great biological resistance, not requiring the addition of biocides or fungicides.

It is an operator friendly product and protects machines from rust also is also very stable on water hardness up to 900 ppm.

## Applications

The product is suitable for:

- A wide variety of machining operations on all grades of steel, cast iron, and aluminum.
- Grinding operations when a good finish is required.
- Can be used in independent machines and centralized systems.

## Properties

- Operator friendly product
- Multi-metallic corrosion inhibition
- Long life service
- Environmentally friendly
- Does not form sticky deposits on machine surface
- Economical in use
- Formaldehyde free

## Typical Performance Data Neat Product

Typical	Value
Appearance	Oily liquid
Colour	Amber transparent
Density @ 20 °C, g/ml	1.02

## 5% Emulsion (in 20°HF)

Typical	Value
Appearance	Translucent
pH	9.5
Corrosion test IP-287	0

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

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## Mixing

Add this product to water and not vice versa, stirring enough so that the coolant is well mixed. Water hardness range must be between 50 ppm and 900 ppm and chloride content should not exceed 0.1 g/l. Before fill the tank with this product, cleaning the machine with Sol Clean is highly recommended.

It is recommended to use between from 5 to 7% for general machining.  
For severe machining and alloyed steels use from 7 to 10%.  
For grinding, from 3 to 6%.

Dilutions can be easily checked by Refractometer.  
 $\% \text{ Concentration} = \text{Refractometer Reading} \times 1.4$