

SOL PLUS 402 VDA

Product code: 265303401

General machining metalworking fluid

This product is a formaldehyde free universal high-performance water soluble cutting fluid, high stability and excellent performance in adverse environments, humidity and pollution.

It forms stable milky emulsions, low foaming, with EP and lubricating characteristics and anticorrosive properties.

It incorporates additives that ensure, when used in the recommended concentration, a superior performance compared with conventional emulsions in terms of finishing and tool life.

This product provides good lubrication and coolant properties due to its microfine nature of the emulsion, improving penetration of the fluid into critical tool/chip interface resulting in superior finish on components and extended tool life.

It is recommended for aluminium machining, including threading and MAPAL reaming operations. It is also a suitable for steels and nonferrous metals machining.

For all type of CNC, transfer and metalworking machines.

Properties

- Coolant universal application
- Excellent lubricant and EP characteristics
- Good service life
- Environmentally acceptable
- Does not contain nitrite, boron, amines or chlorine
- Does not form sticky deposits on machine surface
- Suitable for systems with tendency to biological pollution
- Multi metal
- Formaldehyde free

Typical Performance Data Neat Product

Typical	Value
Appearance	Amber liquid
Density @ 20 °C, g/ml	0.96
Pour Point, °C	-5

Typical Performance Data 5% Emulsion (in tap water 200 ppm)

Typical	Value
Appearance	Milky translucent
pH	9.3
Corrosion test IP-287	No corrosion
Corrosion Aluminium	No corrosion
Corrosion Copper	No corrosion

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

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Mixing

The product is easy to mix. Simply pour the concentrate into water at the appropriate solution and mix. It is recommended between 6 -10% depending on severity of application. Recommended for water from 50 to 500 ppm and chloride below 0.1 gr/l.

Dilutions can be easily checked by Refractometer:
 $\% \text{ Concentration} = \text{Refractometer Reading} \times 1.1$

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