

SOL PLUS 105 FV

Product code: 265302201

General machining soluble coolant

This product is a biostatic metalworking fluid which forms milky transparent emulsion when mixed with water. The levels of additives incorporated ensure that when the product is used at the recommended concentration, a superior performance compared with conventional emulsions will be achieved in terms of finish, tool and sump life and rust control.

This product has been developed for the extremely demanding applications in most types of machining operations where water based products are required. The product is formulated from selected materials which will not support sump bacteria, which normally cause separation in conventional soluble oil emulsions, smell problems and corrosion of components and machine tools.

The product is suitable for a wide variety of machining operations, turning, milling, drilling, tapping and sawing on ferrous metals. It is formulated to meet the exacting demands of modern production engineering technologies. It can be used also for some types of aluminium.

The swarf settling and excellent corrosion properties of the product ensure longer sump life.

Benefits & Advantages

- Does not form sticky deposits on machine surface
- Good swarf settling properties
- Does not encourage bacteria growth, thus giving long fluid life free from foul odors
- Operator friendly
- Environmentally acceptable
- Does not contain nitrite, chlorine or phenols
- Excellent service life
- Economical in use

Typical Performance Data

| Typical | Test Method | Value |
|---|-------------|-------------------|
| Appearance of concentrate | | Clear brown fluid |
| Specific gravity @ 20 °C, g/cm ³ | | 0,99 |
| Sodium nitrite | | Free |
| Chlorine content | | Nil |

Typical performance data –5% emulsion (in tap water 20^oHF)

| Typical | Test Method | Value |
|----------------------------------|-------------|----------------|
| Appearance | | Milky emulsion |
| pH | | 9,1 |
| 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.

SOL PLUS 105 FV

Product code: 265302201

Mixing

The product is recommended for water from 200 to 500 ppm and chloride below 0,1 gr/l. In preparing emulsions always add the soluble oil to water, simply pour the concentrate into water at the appropriate solution and mix.

It is recommended between 3 -10% depending on severity of application. For normal machining 4 - 6%.

Dilutions can be easily checked by Refractometer;

% Concentration = Refractometer reading x 1,2

Storage

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