

SOL PLUS CV

Product code: 265304001

Biostable soluble metal working fluid

This product is a high-performance coolant containing maximum levels of lubricity additives combined with other multi-functional components providing the biostatic characteristics. When introduced to water, the concentrate produces a transparent micro fine emulsion of high stability and film strength.

The additive levels 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 and tool life.

Benefits & Advantages

- Operator acceptability
- Excellent service life
- Environmentally acceptable
- Does not contain nitrite or chlorine
- Does not form sticky deposits on machine surface
- Specially formulated for Aluminium and Aerospace materials resulting in stain free operation
- Very good finishing as a result of a formulation containing special additives for perfect finishing
- Economical in use

Possesses excellent lubricating and coolant properties with micro fine nature of the emulsion improving penetration of the fluid into critical tool/chip interface resulting in superior finish on components and extended tool life.

The product is suitable for a wide variety of machining operations:

- Aluminum: boring, reaming, broaching, threading

The superior lubricity characteristics of the product ensure that excellent finish and tool life is achieved even on the arduous machining operations and materials. It is formulated to meet the exacting demands of modern production engineering techniques.

Typical Performance Data - Neat Product

Typical	Value
Appearance	Amber liquid
Specific gravity @ 20 °C, gr/cm3	0.96
Sodium nitrite	Free
Chlorine content	Nil

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Typical Performance Data – 5% emulsion (in tap water 15 HF)

Typical	Value
Appearance	Slightly translucent
pH	9.1
Corrosion test, IP-287	No corrosion
Copper corrosion	No corrosion
Aluminium corrosion	No corrosion

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

Mixing

The 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 400 ppm and chloride content not over 0,1 gr/liter.

It is recommended between 3-10% depending on severity of application. For normal machining 3-6%. For aluminium reaming, broaching and threading 5-10%.

Dilutions can be easily checked by refractometer.
% concentration = refractometer reading x 1