



Document
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TDS149

SUBJECT: OIL SPECIFICATIONS

ENVIRONMENTAL & QUALITY MANUAL
(in accordance with ISO 9001 & 14001)

PRODUCT DATA SHEET

SOLUBLE LO

Description

SOLUBLE LO is a semi-synthetic, low oil containing, water extendible cutting fluid. It is manufactured with biocides, foam suppressants and performance additives. This product is free from sodium nitrite and phenols.

Applications

SOLUBLE LO may be considered for use on steels, cast iron, yellow metals and some aluminium alloys. The low oil content allows for some grinding applications, supplying some lubricity where required. This product contains metal passivators for copper and brass ally machining.

- Automatic machines 4.0%
- Turning 4.0%
- Milling 5.0%
- Grinding 2.0%

Technical Data

Appearance Pale amber fluid
Density @ 20°C g/ml 1.01
pH Value @ 5% 9.9
Odor Neutral
Emulsion @5% / tap water Translucent

Overview

This product has a translucent emulsion. Always add the product to water while agitating at the recommended concentration level to produce a clear, stable, working emulsion.

Maintaining the recommended concentration range for your metalworking fluid will improve the overall performance of the operation, improve productivity, extend fluid life, reduce disposal costs, and improve overall operator satisfaction.

Routine concentration checks along with proper makeup are essential to good fluid management. It is recommended the concentration levels are evaluated with a refractometer.

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Refractometer readings – concentration % Brix.

Percentage %	Refractometer Reading
2.0	0.7
2.5	1.0
3.0	1.2
4.0	1.5
5.0	2.0
6.0	2.3

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