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SUBJECT: OIL SPECIFICATIONS

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

SOLUBLE 300

Description

SOLUBLE 300 is a semi-synthetic water extendible cutting fluid. It is formulated with biocides, foam suppressants and extreme pressure additives, and it is free from sodium nitrite and phenols.

Application Dilution Rate Guideline

- Automatic machines 3.0%
- Drilling 10.0%
- Turning 3.0%
- Sawing 5.0%
- Milling 4.0%
- Broaching 5.0%
- Thread cutting 5.0%

Directions for Use

SOLUBLE 300 may be considered for use on steels and cast iron and will provide protection for stored and semi-finished components against corrosion.

Technical Data

Appearance Blue fluid
Density @ 20°C g/ml 1.01
pH Value @ 5% 9.5
Odour Neutral

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Overview

SOLUBLE 300 is biostable, carefully formulated with selected components with a wide range of effectiveness, ensuring a long service life when compared to conventional products.

Biostable technology ensures a long problem-free service life. This results in lower disposal costs and reduced downtime.

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. Concentrated mixtures of **SOLUBLE 300** should be avoided as this may lead to slight skin irritation to machine operators.

Refractometer Reading

Percentage %	Reading
100:1	0.8
100:2	1.6
100:2.5	2.0
100:3	2.4
100:4	3.2
100:5	4.0

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Experienced personnel from our Technical Division are available for discussion on all aspects. Recommendations are given in good faith but without warranty. It is the user's responsibility to determine the suitability for his/her own use.

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