

SOL 355

Product code: 265300101

Biostable aluminum metalworking fluid

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

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 and tool life.

It possesses excellent lubricating and coolant properties with 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.

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

- on ferrous metals: turning, milling, tapping
- on aluminum: boring, reaming, broaching, threading

The superior lubricity characteristic 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.

Benefits & Advantages

- Operator acceptability
- Ideal rationalization product
- Excellent service life
- Environmentally acceptable
- Does not contain nitrite or chlorine
- Does not form sticky deposits on machine surface
- Multi-metallic corrosion inhibition, i.e., Aluminum, Copper, Brass, Steel
- Economical in use

Typical Performance Data Neat Product

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

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Typical Performance Data – 5% emulsion (in tap water 20°HF)

Typical	Value
Appearance	Slightly transparent liquid
pH	9.1
Corrosion test IP-287	No corrosion
Copper and aluminium corrosion	No corrosion

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

Mixing

This product is easy to mix. 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 3-6%. For aluminum reaming, broaching and threading 5-10%.

Dilutions can be easily checked by Refractometer:

% Concentration = Refractometer Reading x 1

Storage

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