

# SOL PLUS 214 CU

Product code: 265302901

## Grinding and general machining soluble lubricant

This product is a semi-synthetic metalworking fluid, which forms very stable micro emulsions when mixed with water. Due to the special formulation, it has a great biological resistance and it's not necessary to add biocides or fungicides.

The product does not impact operators and protects the machine from rust.

It is suitable for a wide variety of machining and grinding operations on all types of steel, cast iron, yellow metals and aluminium.

The product is suitable for both centralized systems and independent machines.

## Benefits & Advantages

- High corrosion protection properties
- Good cooling
- Excellent service life
- Does not form sticky deposits on machine surface
- Economical in use
- Environmentally acceptable

## Typical Performance Data - Neat Product

Typical	Value
Appearance	Amber liquid
Specific gravity @ 20 °C, gr/cm <sup>3</sup>	1.02 ± 0.02
Sodium nitrite	Free

## Typical performance data - 5% emulsion (in tap water 150 ppm)

Typical	Value
Appearance	Amber translucent
pH	9.4 ± 0.2
Corrosion test, IP-287	Nil
Foam	Low

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

## Mixing

The product is easy to mix. Pour the concentrate into water at the appropriate solution and mix. Hardness of water should be between 100 ppm and 500 ppm and chloride content below 0,1 gr/lit.

It is recommended to use in concentration between 5 to 7% depending on severity of application. For severe machining from 7 to 10%. For grinding operations from 3 to 5 %.

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## In operation check

Dilutions can be easily checked by Refractometer.  
% Concentration = Refractometer reading x 1.43

## Storage

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