

SOL TB 2

Product code: 265305101

Grinding and general machining EP soluble coolant

This product is a semi-synthetic metalworking fluid which forms very stable micro emulsions when mixed with water. Thanks to the special formulation ensures a great biological stability it is not necessary to add biocides or fungicides. It is a biostatic product with EP properties achieving long life and non-generating additional maintenance costs. The product does not produce impact on operators and protects the machine from rust.

It is suitable for a wide variety of machining operations and grinding on all grades of steel, brass, aluminium, copper, bronze and cast iron. The product is suitable for centralized systems and independent machines.

Benefits & Advantages

- High anticorrosive properties
- Good cooling
- Excellent service life
- Environmentally acceptable
- Good EP properties
- Does not form sticky deposits on machine surface
- Economical in use
- Multi metals

Typical Performance Data - Neat Product

Typical	Value
Appearance	Amber Liquid
Specific gravity @ 20 °C, gr/cm3	0.99
Sodium nitrite	Free

Typical Performance Data – 5% emulsion (in tap water 150°HF)

Typical	Value
Appearance	Amber translucent
pH	9.3 ± 0.2
Corrosion test IP-287	No corrosion
Copper corrosion	Nil
Aluminium corrosion	Nil

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

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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 500 ppm and chloride content not superior to 0,1 gr/l. It is recommended to use between 4 to 7% depending on severity of application. For severe machining from 7 to 10%. For grinding operations from 3 to 5 %.

Dilutions can be easily checked by Refractometer:

% Concentration = Refractometer reading x 1.2

Storage

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