



## SOLUBLE CUTTING OIL 46

### DESCRIPTION

Soluble Cutting Oil forms a stable milky emulsion after mixing with water. It contains a bactericide to prevent microbial growth and contamination. It is used as a coolant for general cutting of ferrous and non-ferrous metals. Soluble Cutting Oil is not recommended for use when machining cast irons, zinc alloys and brass. Always add oil to water and not vice versa.

### APPLICATION

- For general machine shop cutting operations where maximum cooling and lubricity is required in order to promote extended tool life and ensure a good surface finish. It also prevents rust on machine and machined parts which are of paramount importance in metal cutting environments.

### PERFORMANCE

Meets or exceeds:

- ISO MAB

### ADVANTAGES

- Extended tool life
- Good surface finish
- Prevents rust on machine and machined parts
- Free of boron and secondary amines

### TYPICAL PHYSICAL CHARACTERISTICS

Property	Unit	46	Method
Density @ 20°C	kg/cm	0.88	ISO 3675
Colour (Neat)		Pale Straw	Visual
Colour (Diluted)		Milky White	Visual

### RECOMMENDED MIXTURE RATIOS

Free cutting      steels,      alloy steels,      brasses,      bronzes,      aluminium alloys

Cold Sawing	20:1	25:1	30:1	15:1	8:1
Drilling	20:1	15:1	30:1	15:1	10:1
Milling	20:1	15:1	30:1	20:1	10:1
Reaming	20:1	10:1	30:1	20:1	10:1
Tapping	20:1	10:1	30:1	20:1	10:1

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