

## SOLUBLE CUTTING Oil Mineral, Semi-Synthetic, Synthetic

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### DESCRIPTION

**Sol Cut 100, Super Sol Cut 150 (Fast & Hard Water), Mineral Oil:** Long-life Conventional milky emulsion with High-performance, milky soluble fluid providing excellent batch life and lubricity. Designed for long service life and a high degree of lubricity for a range of moderate- to heavy-duty applications.

**Semi Synthetic Sol Cut-220, Semi Synthetic Sol Cut-250:** Semi-synthetic, High-performance multipurpose long-life cutting fluid. Recommended for machining a variety of ferrous and nonferrous metals.

**Synthetic Sol Cut-320, Synthetic Sol Cut-350. Fully-Synthetic:** Fully synthetic (no oil) machining and grinding metalworking fluid for operations where high surface finish, cooling and low foam are primary requirements. Highly stable to provide long service life.

### APPLICATIONS

- General machining of easy to machine steels , aluminum, and copper alloys in light to heavy duty moderate machining operations and Designed for hard water, long service life and a high degree of lubricity for a range of moderate- to heavy-duty applications .
- Semi synthetic cutting fluid is High performance, primarily recommended for machining of aluminum, aluminum alloys, steels, easier to machine stainless steels, and cast iron in milling, tuning, sawing, boring, drilling and reaming.
- Synthetic (mineral oil-free) fluid for general cutting and grinding operations of ferrous materials from light to severe duty, designed for modern machining equipment and high surface finish.

### FEATURES & BENEFITS

- Form stable emulsions and solutions, Ease of use and maintenance
- Long term inherent stability, Increases batch life and reduces unpleasant odors
- Low foaming potential, improved performance even in high pressure systems
- Resists formation of sticky residues, Improves machine cleanliness
- Reduces machine maintenance and rework of material
- Good reparability from fines, Improves filterability and surface finish
- Wide Range of applicability, Potential to consolidate products and reduce inventories
- Compatible with high performance Oil No slideway, Easy separation and removal of tramp oil.

### Soluble fluids care and maintenance advice

- Add the concentrate to the water — not water to concentrate. Use freshly mixed product only.
- Monitor and record coolant concentrations and conditions regularly, and take the necessary corrective measures in a timely manner.
- Keep systems clean by avoiding adding contaminants, remove tramp oil frequently, ensure that all leaks of hydraulic oil, gear oils and other machine-tool lubricants are attended to immediately.
- Keep coolant concentration at recommended level allowing for slide way /hydraulic oil contamination.
- Do not use water from infected sources, such as fire hose, borehole, header tank, etc.;
- Do not put clean coolant into dirty machines. Use system cleaner and follow the specified cleaning procedure.
- Do not leave machines full of coolant standing idle for long periods, particularly when contaminated with tramp oil.
- Do not prepare products in dirty or galvanized containers.
- Do not top off with water. Always use diluted emulsion.

## PROPERTIES

SPECIFICATIONS	Sol Cut 100	High Super Sol Cut 150	Semi Syn Sol Cut 220	Semi Syn Sol Cut 250	Syn Sol Cut 320	Syn Sol Cut 350
Appearance	Brown	Brown	Yellow Liquid	Brown Liquid	Dark Green	Clear amber
Diluted Appearance	Milky	Milky	Translucent	Semi Translucent	fluorescent green	Clear, transparent
Emulsion Type	Soluble	Soluble	Semi-Synthetic	Semi-Synthetic	Synthetic	Synthetic
Mineral Oil	85%	55%	50%	40%	0%	0%
pH @ 5% Emulsion	10.1	9.1	9.3	9.7	9.4	9.2
Visc @ 40°C, cSt	32	59	54	70	5	17.2
Spf Gravity @ 20°C	0.88	0.95	0.97	0.94	1.12	1.08
Pour Point, °C	-10	-42	-36	-45	-24	0

**POWERMAXX SOL CUT Series products are provided as a concentrate mixed with water before use.**

PRODUCTS	Low alloy steels/ milling, turning	Carbon/ alloy steels/ difficult machining	Aluminum machining	Cylindrical & surface grinding
SOL CUT 100	5–10%	5–10%	5–10%	3–5%
HIGH SUPER SOLCUT 150	4–6%	6–12%	6–15%	3-5%
SEMI SYN SOL CUT 230	4–8%	5–8%	4–8%	4–5%
SEMI SYN SOL CUT 250	6–8%	6–10%	6–10%	4-5%
SYN SOL CUT 320	5-6%	6-8%	6-8%	3–5%
SYN SOL CUT 350	4–6%	6–8%	6–8%	3–5%

### POWERMAXX LUBE INDIA

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