

Soluble Cutting Oil

Water Soluble Metalworking Fluid

DESCRIPTION

Nemco Soluble Cutting Oil is a general-purpose soluble oil with an emulsifier package which contains no phenolic or cresylic components. Soluble Cutting Oil forms a stable white emulsion when mixed with water, and exhibits low to moderate foaming tendency with strong corrosion protection. This product can be mixed with water at ratios of 3% to 10%, oil, even with hard water.

Note that the Oil should always be added to the water for proper blending and emulsion consistency.

Nemco Soluble Cutting Oil can be used on ferrous and most non-ferrous materials, including mild steels, stainless steels, hardened steels and not aluminum alloys. For use in light to moderate duty machining and grinding applications, such as milling, drilling, cut tapping, reaming, boring and surface grinding.

Advantages

- Strong corrosion resistance
- Excellent emulsion stability
- Low to moderate foaming tendency
- Odor free

Typical Characteristics – Soluble Cutting Oil

Test	Performance
Appearance	Clear (amber)
Stability (24 hours) 40°C ~4°C	Clear, stable Clear, stable
Bloom at 5% in tap water	Good
Strike at 5% in tap water	>10 inversions
Appearance at 5% in tap water	Milky
pH at 3% in tap water	9.0
Mod. IP263 emulsion stability at 5% 24 hours at 40°C Tap (% oil/% cream) 200 ppm (% oil/% cream) 400 ppm (% oil/% cream)	0/Trace 0/Trace Trace/0.1
Mod. IP287 CI chip rust test at 5% in 200 ppm	40% rust

Physical characteristics shown in the table are typical and may vary slightly.