



Product Information

SOLUBLE OIL

Codes: SOL005, SOL020, SOL205

Issue: January 2010

The general-purpose, low odour soluble cutting oil designed as a coolant and lubricant during metalworking operations. It is made from hydrotreated base oils and a special blend of inhibitors, lubricity additives and emulsifiers. It forms a white emulsion and contains a bactericide.

APPLICATION

Suitable for general purpose cutting operations on low and medium tensile steels, free machining of brass bronze and cast iron. It may also be used as a grinding fluid in non-critical applications. (refer to below chart for ratio and applications). Not suitable for tensile or stainless steel or nickel alloys.

USAGE CHART

Metal	Aluminium and alloys	Brass/ Bronze	Copper	Iron/ Cast	Steel/ mild, low alloy carbon
Operation					
Milling	20:1	20:1	20:1	20:1	15:1-10:1
Drilling	20:1	20:1	20:1	20:1	15:1-10:1
Boring	20:1	20:1	20:1	20:1	15:1-10:1
Reaming	20:1	20:1	20:1	20:1	15:1-10:1
Turning	20:1	20:1	20:1	20:1	15:1-10:1
Cold Sawing	30:1	20:1	20:1	15:1	NA
Threading	NA	20:1	20:1	15:1	NA

BENEFITS

- Forms highly stable emulsions.
- Helps prevent rust and corrosion.
- Low foaming.
- Resists biological degradation.
- Low odour
- Extends tool life
- Improves surface finish
- Non staining to ferrous and non ferrous alloys
- Phenol and nitrite free

Typical Properties

Density at 15°C, kg/L	0.897
Viscosity, Kinematic, cSt at 40°C	39
Colour	Brown
Colour, Emulsified	Creamy White
pH @ 2% Treat	9.1

Penrite Oil Company Pty Ltd
ABN 25 005 001 525
Ph: 1300 PENRITE (1300 736 748)
Int: 61 3 980 1 0877
Email: penrite@penriteoil.com
www.penriteoil.com.au

Environment, Health and Safety
Information is available by request on this product in the Penrite Material Safety Data Sheet. Information in this sheet is based on the most current information available. Minor variations to typical properties not affecting the performance of the product are to be expected in normal manufacture.
Issued January 2010