

## WATER SOLUBLE OIL

### Typical Properties

Appearance	Yellow/Amber
Appearance of 5% Emulsion	Opaque, white
Viscosity, cSt	
At 40 °C	65.0
Viscosity, SUS	
AT 100 °F	346
Emulsifiers, %wt.	14.0
Flash Point, (COC) Deg°F	300*
Gravity, API @ 60 °F	26.0
Specific Gravity @ 60 °F	0.8984
Density, lbs/gallon	7.48

\* water plus formulated oil has approximate boiling point of 190°F

The values shown are typical of current production. Some are controlled in the manufacturing process, while others are not. All of them may vary within tolerable ranges.

Water Soluble Oil Coolant is a water-soluble concentrate formulated from a blend of highly refined mineral oil, emulsifiers/stabilizers and rust inhibitors to form a stable emulsion with low foaming tendencies, when mixed with a normal quality water. The formed emulsion is non corrosive, non-staining, and will help keep machines, tools, grinding wheels and the work piece clean and free of gummy deposits. The residual film deposit offers in-use protection of the work piece. For general machining, typical concentration strength (water : concentrate) in service is 20:1 but ratios should be adjusted to meet particular cutting or system applications.

### APPLICATIONS

Recommended as a general purpose emulsifiable oil for machining operations on ferrous and many non-ferrous metals where cooling is the primary objective but lubricity and rust protection are also necessary. Product can also be used to manufacture fire resistant hydraulic fluids to meet specific customer system requirements.