TECHNICAL DATA SHEET

CIIFROL SOLUCUT 45

High Performance Water-Soluble Cutting Fluid

PRODUCT DESCRIPTION

CIIFROL SOLUCUT 45 is a soluble emulsion type high performance bio-stable, micro emulsion type extreme pressure water soluble cutting fluid. It forms milky white emulsions when mixed with water. The emulsion formed is homogenous and does not break even during prolonged usage or shut downs. CIIFROL SOLUCUT 45 is a medium oil content product whose emulsions are suitable for operations on a wide range of ferrous alloys including high tensile steel and other difficult to machine alloys. These emulsions are also suitable for Aluminium alloys and yellow metal alloys.

APPLICATIONS

CIIFROL SOLUCUT 45 is recommended for general purpose machining operations like sawing, milling drilling and other chip forming operations, general purpose surface, cylindrical and centreless grinding operations. Solucut Extra gives excellent oil life in comparison with other conventional soluble cutting oils and also provides extended tool life and finish in general machining and grinding operations. These oils are also found to be very good even with water hardness of 400 ppm.

Recommended dilution rates:

- General machining: 5-7%
- Grinding: 3-5%
- Difficult Operations or Materials: 7-10%

Please avoid water with high Chloride content (Above 50 ppm) and high Calcium and Magnesium content (Above 500 ppm).

SPECIFICATIONS

This propriety formulation of SRN Lubricants passes PERFORMANCE STANDARD: IS 1115: 1986 (Reaffirmed 1996)

BENEFITS

- Low foaming in all water conditions to ensure continuous grinding performance
- Inhibits microbial growth to enhance coolant sump life
- Extended Protection of work piece, machine components & tool material from rust & corrosion.
- Excellent surface Finish, superior cooling properties.
- Very long emulsion life.

KEY PROPERTIES

Parameters	Typical Results
Appearance	Amber Fluid
Kinematic Viscosity @ 40 Deg C	20 - 30
Flash point Deg C (Typical)	155
pH of 5% emulsion in water (Typ)	8.5 - 9.5 Typical
Cast Iron Corrosion	Passes
Emulsion Stability	Excellent
Mineral Oil Content	18%

The information provided in this Technical Data Sheet is based on our best knowledge and experience and is intended as a general guide. The technical data represents typical values and may vary depending on product batches, operating conditions and application methods.

Users are advised to refer to the latest Technical Data Sheet and Safety Data Sheet (SDS) for applicable product information.

Users are advised to evaluate the product for suitability for their specific application and to follow recommended handling, storage and safety practices. CIIFROL accepts no responsibility for any loss, damage or injury resulting from improper, unintended or abnormal use of the product or conditions beyond its reasonable control.

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