

FORCE SOLUBE CUTTING OIL

DESCRIPTION

FORCE SOLUBE is a metalworking fluid that can dissolve in water so as to form a very stable emulsion when mixed with water at different levels of viscosity. Emulsion stability is not affected by hard water ions and by the fact that oil is not frothy then makes a high ideal of the FORCE SOLUBE provides superior cooling for a wide range of metalworking processes.

APPLICATION

FORCE SOLUBE is recommended for light duty cutting up to rough on all types of non-ferrous metals and ferrous metals except magnesium. It would be beneficial in cutting, sawing, making holes, milling and refining the hole. It is ideal for heavy duty machine due to the nature of effective wetting and conditioning. Comparison of dilution with water is a typical range for the general machine 1:10 and 1:40 for heavy duty machine.

BENEFITS

- Protects against rust and corrosion.
- No foaming.
- Willingness perfect wetting and cooling.
- Holding down the attack of bacteria that can cause rancidity.

STORAGE

The product should be stored inside (5-40°C) for no more than 1 year and be protected from freezing.

TYPICAL RESULT

Characteristics	Test Method	Force Solube Cutting Oil
Density at 15°C, kg/l	ASTM D - 4052	0.884
Appearance	Visual	Amber Fluid
Kinematic Viscosity at 40°C, cSt at 100°C, cSt	ASTM D - 445 ASTM D - 445	36 7.35
Flash Point, ° C	ASTM D - 92	172
Emulsion Type	Visual	Danse White