TECHNICAL DATA SHEET

ORIANT- SOL CUT
(GENERAL PURPOSE SOLUBLE CUTTING OIL)

Description and Application:

ORIANT SOL CUT is a general-purpose soluble cutting fluid which on dilution with water forms a milky stable emulsion, the boundary properties afforded by the high oil content not only provides good machining performance but the ability to leave fluid corrosion inhibiting oil residues.

It is suitable for all general-purpose machining operations –drilling, milling, turning, and sawing of a variety of medium tensile steels and certain alloys of aluminum and copper.

Recommendation:

Ferrous/ Nonferrous metals.

Turning, drilling, sawing	5-7%
Milling, reaming	5-8%

Main Benefits:

- Very easily miscible with water
- Outstanding emulsion stability even when hard water is used for the diluents.
- Very good machine tool lubrication due to high oil content.
- Good resistance to bacterial degradation.
- Compatible with good quality paints used on machine tools.

Typical Properties:

Sr. No	Test Parameters	Test Method	Typical Value
1	Appearance	Visual	C&B
2	Density @ 15°C gm/cm3	ASTM D 4052	0.93
3	Viscosity @ 40°C (CSt)	ASTM D 445	50
4	Mineral Oil Content % Dilution	-	80
5	PH (5% Dilution)	-	8.8
6	Filter Paper Corrosion Test (3%)	IP 287	0/0
7	Flash Point, °C, COC	ASTM D 92	180+