



ATLANTIC SOLUBLE CUTTING OILS

Chlorine-Free High-Performance Metal Working Fluid

DESCRIPTION

ATLANTIC SOLUBLE CUTTING OIL is a long-life, bio stable, chlorine-free high-performance metal working fluid. When mixed with water the emulsion formed has a milky appearance. It is formulated with high levels of lubricity additives to provide excellent performance in arduous machining operations.

APPLICATIONS

ATLANTIC SOLUBLE CUTTING OIL is recommended for machining aluminum, steels and yellow metals. It can be used in individual machine sumps and in centralized coolant systems.

Recommended dilutions for Turning, Drilling, Sawing, Milling, Reaming, Deep Hole Boring: 5-10%.

PROPERTIES

ATLANTIC SOLUBLE CUTTING OIL is a high-performance, chlorine-free product suitable for machining a wide range of metals. It provides the flexibility for product rationalization and is particularly suitable for machining aluminum alloys used in the automotive industry. It is formulated to provide long service life and to resist bacterial growth to help reduce smells associated with bacterial degradation.

PERFORMANCE FEATURES AND BENEFITS

- Outstanding machining performance on aluminum, non-ferrous metals and ferrous metals, including stainless steels
- Wide multi-metal machining range
- Stable in a wide range of diluent water qualities
- Oil content protects machined components, machine fittings and fixtures
- Highly resistant to bacterial degradation

TYPICAL TECHNICAL PROPERTIES

PRODUCT CODE	IL-MWF-02-25004
Appearance	Amber Liquid
Specific Gravity @ 20°C , ASTM D1298, g/mL	0.95
Kinematic Viscosity at 40°C, mm²/s, ASTM D445	30-40
Viscosity Index, ASTM D2270	50 (naphthenic)
Emulsion Type	Milky
pH @ 3% Emulsion	9.1
Corrosion test (IP 287) Breakpoint %	3.0
Refractometer Correction Factor	1.0
Pour Point, °C, ASTM D97, max	-15
Flash Point(COC), °C, ASTM D92, min	174
Sulphated Ash, ASTM D874, %wt	1.5
Conradson Carbon Residue, CCR	2
Erosion after dilution 20:1 30:1	 0/2-3 0/2-3

Note: These characteristics are typical of current production. While future production will conform to Atlantic's specification, variations in these characteristics may occur.

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* supersedes all previous versions

Packing: 4L, 5L, 18L, 20L, 25L, 200L, 205L, 208L, 210L