

Oculus Soluble Cutting Oil is formulated with carefully selected highly refined base oils and a combination of balanced mixture of emulsifier chemistries with biocide to offer advanced lubricity to machining operations by the metal-working fluid. The oil has good reserved alkalinity and low-to-medium foaming tendency.

### BENEFITS

- Stable homogeneous milky solution to provide cooling and lubrication of the material at the cutting zone.
- Permits rapid separation of chips and grinding dirt.
- Well-matched emulsion ensuring constant fluid flow to maintain effective lubricity.
- Forms stable emulsion in soft and hard water.
- Longer emulsion life due to better bacterial control.
- Low-to-moderate foaming tendency.

### APPLICATIONS

- Specially formulated for the particular requirements of mild and moderate machining operations where excessive heat is dissipated by an effective coolant with extra lubricity.
- Suitable for light machining such as drilling, planning, milling in soft and normal water conditions.
- Recommended for most grinding operations where a clean emulsion is required to rapidly settle out the grinding, metal fines.

### TYPICAL CHARACTERISTICS\*

PROPERTIES	METHODS	TYPICAL RESULTS
Density @ 15 °C, kg/L	ASTM D-4052	0.8847
K. Viscosity @ 40°C, cSt	ASTM D-445	35.30
Emulsion Stability, 24-hrs, 5% in Water	IP-263	Stable
Viscosity Index	ASTM D-2270	111
Flash Point (COC), °C	ASTM D-92	168
Pour Point, °C	ASTM D-97	-6

\* These typical characteristics mentioned are based on current mean values.



#### HEALTH & SAFETY

Guidelines for health, safety and handling are available in Material Safety Data Sheet of the product which can be obtained from Oculus Lubricant representative.



#### ENVIRONMENT PROTECTION

Take used oil to an authorized collection point. Do not discharge into drains, soil or water.



#### ADVICE

Advice on application not covered in this leaflet, may be obtained from Oculus Lubricant representative.