



MAGNA™ SOL-CUT OIL

MAGNA™ SOL-CUT OIL— Non-phenolic coupled solvent refined nitrites free water-soluble cutting fluid which forms a stable milky white emulsion when mixed with water, and contains biocide/fungicide to give the fluid extended service life. It also contains a non-silicone anti-foam agent.

Applications

Suitable for the majority of conventional machining operations such as turning, milling, sawing, tooling, tapping of steel and brasses.

Dilution Ratios

- | | |
|---------------------------------|----------|
| • Turning, drilling, and sawing | 5% |
| • Milling, reaming, and tapping | 5% - 10% |
| • Grinding | 3% - 8% |

Special note : It is always preferable to use di-ionized or soft water for proper miscibility.

Features & Benefits

- Forms homogenous and extremely stable milky emulsion.
- Effective biocides/fungicides allow extended service life.
- Effective lubrication and cooling properties ensure a better finish and extended tool life.
- Excellent control over foaming, rust and corrosion.

Typical Characteristics

SOL-CUT OIL	
Density @ 15°C Kg/m ³	900
Kinematic viscosity, 40°C cSt	55
Kinematic viscosity, 100°C cSt	7.6
Flash point, COC, °C	130
Pour point, °C, Max	-7
Emulsion test (5% emulsion)	stable milky
Corrosion test (5% emulsion)	Pass

Typical properties are average values only and do not constitute a specification. Minor variations that do not affect product performance are to be expected during normal manufacture, and at different blending locations. Product formulations are subject to change without notification.