



Sol Plus 270

Multi-functional semi-synthetic soluble cutting fluid

Description

Sol Plus 270 is a formaldehyde free semisynthetic soluble cutting fluid that forms very stable micro emulsions and does not contain chlorinated compounds, nitrites or secondary amines.

Applications

Sol Plus 270 is suitable for:

- A wide variety of machining operations on all grades of steel, cast iron, brass, copper, bronze and aluminium.
- Grinding operations when a good finishing is required.

- Can be used in independent machines and centralized system.

Properties

- Operator friendly product
- Multi-metallic corrosion inhibition
- Long life service
- Environmentally friendly
- Does not form sticky deposits on machine surface
- Economical in use
- Formaldehyde free

Typical performance data

	270
Appearance	Oily liquid
Colour	Amber transparent
Density @ 20 °C, g/ml	1.02
Emulsion appearance (5% in 20°HF water)	Translucent
pH (emulsion at 5% after 24 hours)	9.5
Corrosion test IP-287 (5% in 20°HF water)	0

Mixing

Add Sol Plus 270 to water and not vice versa, stirring enough so that the coolant is well mixed. Water hardness range must be between 50 ppm and 900 ppm and chloride content should not exceed 0,1 g/l.

Before filling the tank with Sol Plus 270, cleaning the machine with Sol Clean is highly recommended.

Sol Plus 270 is recommended to use between from 5 to 7% for general machining.

For severe machining and alloyed steels use from 7 to 10%.

For grinding, from 3 to 6%.

Dilutions can be easily checked by Refractometer:

$$\% \text{ Concentration} = \text{Refractometer Reading} \times 1,4$$

Note: Soluble oils are susceptible to frost damage. Store containers indoors to protect extremes of temperature.

All performance data on this Technical Data Sheet are indicative only and can vary during production

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