

## **SOLUTAC A -- CUTTING FLUID**

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**SOLUTAC A** cutting fluid is a premium quality lubricant. This water soluble cutting fluid contains extreme-pressure additives specially designed for heavy duty machining.

**SOLUTAC A** is a multifunctional cutting fluid for machining a wide range of ferrous and non-ferrous alloys. It does not stain non-ferrous alloys such as copper, aluminum, brass...

### **MAIN PROPERTIES**

**SOLUTAC A** cutting fluid...

- ☐ Has a good lubricity and excellent extreme-pressure properties that extend lifetime of cutting tools.
- ☐ Guarantees an excellent protection against rust and corrosion.
- ☐ Does not stain and corrode metals.
- ☐ Does not contains biocide.

## **PREPARATION OF SOLUTAC A SOLUTIONS**

Measure the amount of water needed and pour it into the tank to make the mixture. Then add **SOLUTAC A** slowly with vigorous stirring. The following dilutions (by volume) are recommended:

<b>OPERATIONS</b>	<b>DILUTION RATES (BY VOLUME)</b>
Milling, Boring and Drilling	10 to 15 parts of water in 1 part of <b>SOLUTAC A</b>
Turning Sawing	15 to 30 parts of water in 1 part of <b>SOLUTAC A</b>
Grinding	30 to 50 parts of water in 1 part of <b>SOLUTAC A</b>

## **TYPICAL CHARACTERISTICS OF SOLUTAC A**

Properties of fluid	ASTM Method	SOLUTAC A
Viscosity at 40°C, cSt	D445	33
Density at 15°C, kg/L	D1298	0,92
Pour Point (max.), °C	D97	-12
Flash Point (min.), °C	D92	150
Color (max)	D1500	5,0
Chlorine, % wt (max.)	D1317	None
Active sulfur, % wt (max.)	---	None
Sodium, % wt (max.)	---	0,2
Properties of emulsion	ASTM Method	SOLUTAC A
% soluble oil concentrated	---	10
% water (120 ppm hardness)	---	90
FALEX EP (kg)	---	680/795
Angular force of threading (% efficiency)	---	65
Corrosion resistance	---	excellent
Stability of emulsion (24 hours)	---	2 to 5 %

## **Available size**

	<b>205 L</b>	<b>20 L</b>
<b>Solutac A</b>	07-0786-05	07-0786-10