



VEEDOL SOLUCUT MULTI METAL SYNTH

SYNTHETIC TYPE CARBIDE GRINDING FLUID

BUILT IN LUBRICITY ENHANCER

Product Description

Veedol Solucut Multi Metal Synth is a low foaming, synthetic grinding fluid with long service life. It is a specialized product designed to minimize the uptake of cobalt from high cobalt alloys. Veedol Solucut Multi Metal Synth gives clear solutions which provides excellent workpiece visibility.

Product Mixing

TWOCIL advises the use of automated mixing systems. If mixing manually, always add the concentrate to the water with maximum agitation. If water is added to the concentrate, the emulsions may prove unstable. Avoid mixing with very cold concentrate or water.

Performance Features & Benefits



Designed to minimize the uptake of cobalt from high cobalt alloys.



Designed for low foaming.



Excellent Field Performance

Good compatibility with waters of 50 – 400 ppm (Calcium carbonate) hardness.



Ideal Choice for

High and low-pressure CNC systems.

Product Management

The working concentrations should be carefully controlled and monitored daily as higher & lower working concentrations will have performance, health and safety implications.



Application

It is recommended for grinding applications of,
• Hi Cobalt alloys • Tungsten carbides

Typical Recommended Concentrations

- » Grinding 5 - 8%
- » It is essential that the minimum concentration is closely observed
- » Below 5% the inhibitory effect of the additives is reduced and dissolved cobalt levels may increase

Please follow equipment manufacturer's recommendations for performance level and viscosity grade.

Typical Properties

Appearance	Amber Liquid
Stability (0°C/Ambient/50°C)	Passes
Emulsion Type @ 5% in tap water	Clear Pale Amber Solution
Cast Iron Corrosion IP 287, 5.0 % in 200 ppm	Passes
pH @ 5% in deionized water	9.1
Defoam in 50 ppm water	Nil in 30 seconds
Refractometer Factor	1.20

The above typical properties are those obtained with normal production tolerance and do not constitute as specification. Variations that do not affect product performance are to be expected during normal manufacturing processes and at different blending locations. The information contained herein is subject to change without notice.



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Fluid Maintenance



Poor or incorrect emulsion preparation may lead to instability and could considerably shorten the life of the emulsion.

Prior to making any fresh emulsion, it is highly recommended to use compatible system cleaner for purging the machine tool coolant system.

Storage



Store inside the warehouse, ideally between 10°C and 30°C.

Shelf life is 12 months from date of manufacture.

All packages should be stored under cover. It should not be exposed to direct sunlight, intense cold and extreme temperature fluctuations. Where outside storage is unavoidable, drums should be laid horizontally or properly covered to avoid the possible ingress of water and damage to drum markings.

Health, Safety and Environment



The product should be handled carefully. Special care should be taken when spraying, as misted product greatly increases the risk of fire. Use only in a well-ventilated area away from sources of ignition including static discharge. For further information, we recommend you refer to the MSDS. Do not discharge the used product into drains, soil, or water. Take care to protect the environment.

Veedol Solucut Multi Metal Synth – Key Differentiators

Market General Synthetic Grade

Veedol Solucut Multi Metal Synth

CORROSION RESISTANCE PERFORMANCE

Veedol Solucut Multi Metal Synth provides excellent corrosion resistance on ferrous metal and alloys as compared to market general product



1%



3%



1%



3%

COBALT LEACHING



Cobalt Leaching Layer Formed



Tight Emulsion

Veedol Multi Metal Synth is designed to minimize uptake of cobalt From high cobalt alloys to give a tight emulsion