Veedol

POWERING PERFORMANCE



VEEDOL **SOLUCUT**

WATER MISCIBLE METAL WORKING FLUID BORON FREE

BUILT IN LUBRICITY ENHANCER

Performance Features & Benefits

Nitrite, Boron & Triazine Biocide free
Free from hazardous chemical, reduced risk of operators health & safety.

Chlorine, Sulphur and phosphorous-free
Make it environmentally friendly, low disposal cost.

Excellent Emulsion Stability
Tolerant to difficult diluent water with hardness upto 500 ppm.

Excellent Metal Passivation
It provide good corrosion protection for Aluminium and non-ferrous metals.

Excellent Field Performance
Soft foaming in salt water.

Corrosion Inhibition
Corrosion protection for ferrous provide excellent tool life and surface finish.

Materials

- **Ferrous alloys**
- **Aluminium alloys**
- **Copper and yellow metal alloys**
- **Oil-resistant plastics & non-ferrous materials**

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

Typical Recommended Concentrations

General machining	5 - 7%
Thread cutting and forming	6 - 8%
Deep hole drilling and boring	8 - 10%
Reaming	8 - 12%
Grinding	3 - 5 %

The concentrations vary depending on the type of machining operations.

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.

Product Management

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



Typical Properties

Appearance	Amber Liquid
Stability (0°C/Ambient/50°C)	Passes
Emulsion Type @ 5% in tap water	Milky
Cast Iron Corrosion IP 287, 5.0 % in 200 ppm	Passes
pH @ 5% in deionized water	9.5
Defoam in 50 ppm water	Nil in 60 seconds
Refractometer Factor	1.0

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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Veedol Solucut – Key Differentiators

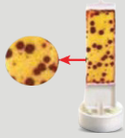
Market General Soluble Cutting Oil	Veedol Solucut

CORROSION RESISTANCE PERFORMANCE

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



MICROBIAL GROWTH



Microbial growth observed due to unstable biocides



Veedol Solucut has very less or no microbial growth due to presence of stable biocides

EMULSION STABILITY – EMULSION FORMATION IN 400 PPM HARD WATER



Oil separation observed



Highly stable emulsion

Veedol Solucut has excellent emulsion stability thereby providing longer sump life in comparison to market general product

MULTI METAL CORROSION PROTECTION



Staining observed on Aluminium due to weaker additive composition



High performance additives prevent staining on Aluminium

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

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 information on this product is available in the Material Safety Data Sheet (MSDS) as a guide to the precautions and safe handling of this product and its disposal. For further information, we recommend you review the MSDS. If handled correctly, there are no special precautions suggested.

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