



Product Description:

Veedol Solucut FE Pro is a low oil containing working fluid developed for general purpose machining and grinding applications. It forms an ultra-stable microemulsion which gives excellent workpiece visibility and clean machining experience, especially on cast iron.

Veedol Solucut FE Pro, an operator friendly product, due to its special formulation ensures a great resistance to bacterial and fungal growth, and protects machines from rust, also is also very stable on water hardness ranging from 50 to 400ppm. It is not suitable for non-ferrous metals.

Features/Benefits:

- **Special semi-synthetic formulation** provides enhanced performance and better coolant life compared to conventional soluble oils, reduces maintenance and operational costs.
- **Unique lubricity and extreme pressure package** provides excellent lubrication and cooling, minimizes tool wear, and extends tool life.
- **Highly effective biocides** resist microbial degradation of emulsion, ensuring long-term stability and effectiveness of cutting fluid. Prevents rancidity and unpleasant odors, maintaining a healthier working environment.
- **Good compatibility with water** ranging from 40-500ppm hardness.

Application:

- Ideal for high-precision machining operations in automotive and aerospace industry.
- Machining of Cast Iron and SG Iron.
- Most ferrous alloys from low, medium carbon steel to forged steel.
- Oil-resistant plastics and other non-ferrous materials such as free cutting Aluminum.
- Not suitable for Non-ferrous metals.

Recommended concentration:

- | | |
|---------------------------------|---------|
| • General Machining | 5 - 6% |
| • Thread cutting and forming | 6 – 8% |
| • Deep hole drilling and boring | 8 - 10% |
| • Reaming | 8 - 10% |
| • Grinding | 3 – 5 % |



PRODUCT DATA SHEET

Typical Properties:

Appearance	Pink liquid
Oil content	Approx 19%
Stability (0°C/Ambient/50°C)	Passes
Emulsion Type @ 5% in tap water	Pinkish Translucent
Cast Iron Corrosion IP 287, 2.5 % in 200 ppm	Passes
pH @ 5% in deionized water	9.5
Defoam in 50 ppm water	Nil in 60 seconds
Refractometer Factor	1.50
Note: Refractometer Reading should be between 4 to 5 markings	

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

PRODUCT MANAGEMENT AND HANDLING OF METALWORKING FLUIDS:

PRODUCT MIXING

Always add the concentrate to the water. If water is added to the concentrate, the emulsions may prove unstable. TWOCIL advises the use of automated mixing systems. If mixing is done manually, ensure vigorous agitation. Avoid mixing very cold concentrate or water.

PRODUCT MANAGEMENT

The working fluid concentration should be carefully controlled and monitored daily as higher and lower working concentrations have health and safety implications. Check and record emulsion strength regularly using a calibrated refractometer. Machines should be cleaned regularly. Fluid and particulate contaminants should be kept to a minimum. This is important, especially in terms of bacterial control.

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 AND SAFETY

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.