



Solucut HDMM

Semi Synthetic Soluble Cutting Oil

TECHNICAL DATA SHEET

Product Description:

Veedol Solucut HDMM is premium semi synthetic soluble oil which requires minimal maintenance in even the most demanding fluid management systems.

Veedol Solucut HDMM is high quality universal soluble oil compatible with multi metals including aluminum, steel alloys, cast iron and yellow metals.

The high levels of both chemical and mechanical lubricity in Veedol Solucut HDMM handle the tough machining and grinding jobs.

The stable and predictable performance of Veedol Solucut HDMM makes it a first choice for high-quality, consistent parts manufacturing.

Features/Benefits:

- Very stable formula provides long operational life with consistent performance.
- Extremely hard water tolerant.
- Very wide application range. Suitable for both grinding and machining.
- Fine particle size emulsion reduces carryoff and facilitates getting the fluid to the point of cut.
- In high-speed turning and milling, Veedol Solucut HDMM has the right balance of cooling and lubrication to provide good tool life and surface finishes.
- Protects machine and tool surfaces while also preventing sticky ways, chucks, tool holders and fixtures.
- Coolant is easily removed with water, working solution or aqueous cleaners.
- Easy recycling or disposal with conventional techniques and equipment.

Recommended Concentrations:

Light duty machining and grinding.5%
Moderate duty machining.	5-7%
Heavy duty machining.	7-10%

MIXING INSTRUCTIONS

- Emulsions work best if they are mixed with room temperature treated water and by adding the Oil to the water; NEVER DO THE REVERSE.
- Using premixed coolant as topup will substantially improve coolant performance and give cost savings.

The specific topup concentration selected for your situation should balance the water evaporation rate with the coolant carry out rate.



Solucut HDMM

Semi Synthetic Soluble Cutting Oil

TECHNICAL DATA SHEET

Application:

Veedol Solucut HDMM has broad application in machining and grinding on a wide range of materials.

Typical Properties:

Appearance	Clear Brown Liquid
Odour	Mild
Emulsion Type	
Tap water	Translucent to slight milky
400 ppm water	Translucent to slight milky
Stability (0°C/Ambient/50°C)	Clear Stable
Dispersion	Excellent
pH @ 5% in tap water	9.0 – 10.0
Refractometer Factor	1.2

Properties mentioned above are typical only and minor variations which do not affect the product performances, are to be expected in normal manufacturing.