



**PRODUCT DATA SHEET**

**Product Description:**

Veedol Solucut is a specialized soluble cutting oil designed to form stable milky emulsion when mixed with water. Essential in metalworking processes, it provides both cooling and lubrication to enhance machining performance and tool life.

Veedol Solucut is free from added Boron additives, Triazine, Chlorine/Sulfur EP additives, Sodium Nitrite, Phenolic couplers Nonyl phenol and NP ethoxylate and coloring dyes.

**Features/Benefits:**

- **Forms stable emulsion** when mixed with water, providing consistent cooling and lubrication. Controls foaming in soft water.
- **Versatile Compatibility** makes it suitable for a wide range of metals, including ferrous and non-ferrous materials, prevents staining and corrosion on non-ferrous metals.
- **Enhanced lubrication** ensures smooth cutting action for high-quality surface finishes.
- **Good compatibility with water** ranging up to 500ppm hardness.

**Application:**

- Ideal for high-precision machining operations in automotive and aerospace industry.
- Machining of ferrous alloys.
- Suitable for aluminium alloys, copper and yellow metal alloys.
- Oil-resistant plastics and other non-ferrous materials.

**Recommended concentration:**

- |                              |         |
|------------------------------|---------|
| • General Machining          | 5 - 7%  |
| • Thread cutting and forming | 6 – 8%  |
| • Deep hole drilling         | 8 - 10% |
| • Reaming                    | 8 - 12% |



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**Typical Properties:**

Appearance	Amber liquid
Stability (0°C/Ambient/50°C)	Passes
Emulsion Type @ 5% in tap water	Milky white emulsion
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	1.50

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.