



Industrial Oils, Fluids & Lubricants

# Technical Data Sheet (TDS)

## Soluble Oil 2500

### Product Description

Soluble Oil 2500 is a heavy duty water soluble oil for industrial metalworking machining operations. This product is manufactured with extreme pressure and anti-weld additives for improved performance and antibacterial additive for extended sump life.

### Features and Benefits

Soluble Oil 2500 forms a stable emulsion for superior rust protection. Safe to use on all metals except magnesium. Excellent cooling properties to promote good finishes and extend tool life. Economical for machining applications with a high volume of carryout loss.

### Applications

Soluble Oil 2500 is recommended for heavy duty metalworking applications of both ferrous and non-ferrous metals. Machining applications may include cutting, drilling, tapping, threading, sawing, milling, automatic screw machines, and grinding. Do **NOT** use for machining magnesium. Consult your account manager or our technical support team for questions regarding compatibility.

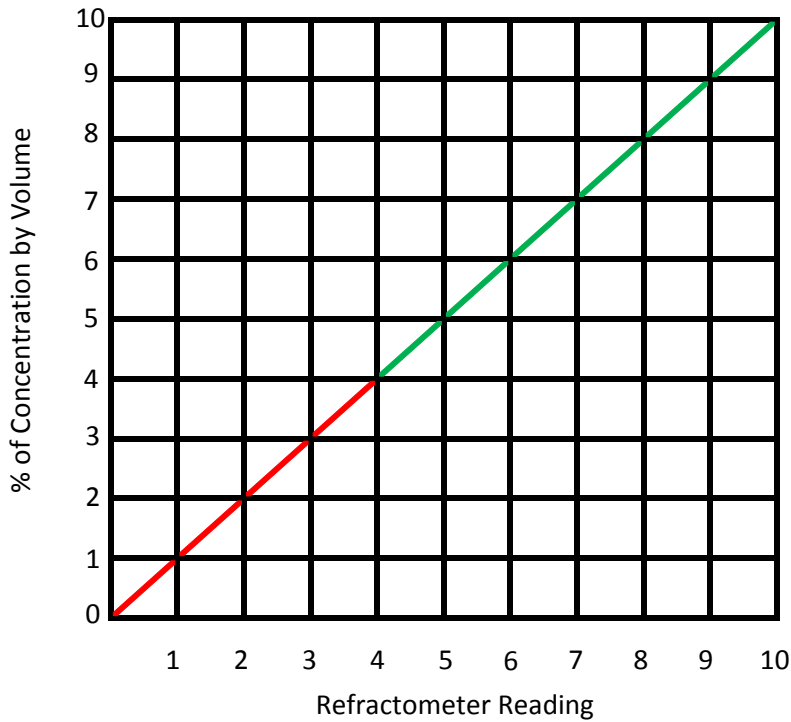
### Typical Properties




<u>Property</u>	<u>Specifications</u>
API Base Oil Category	Napthenic
Appearance	Brown
Density lb/gal.	7.918
Specific Gravity	0.951
Viscosity @ 40 C (cSt)	>68
Pour Point, F	< 0
Flash Point (COC) F	>330
Chlorine, wt %	9 - 10
Sulfur, wt %	0
Lubricity wt. %	0

All reasonable care has been taken to ensure that the information contained in this publication is accurate as of the date of printing. However, variations that do not affect performance are to be expected during normal manufacturing. The Safety Data Sheet (SDS) must be consulted for appropriate information regarding the safe handling, storage, and disposal of a product.

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Refractometer Factor % Brix = 1.0



-  Dilution is too weak. Add 1 part concentrate with 10 parts water to increase concentration.
-  Dilution is in correct range.
-  Dilution is too strong. Add 1 part concentrate with 40 parts water to reduce concentration.

### Recommended Metalworking Concentrations

Light Duty.....4%-6%

Medium Duty.....6%-8%

Heavy Duty.....8%-10%

### Mixing Instructions

Using premixed coolant as makeup will improve coolant performance and reduce coolant purchases. The makup solution you select should balance the water evaporation rate with the coolant carryout rate.

**Always add the concentrate to the water and mix thoroughly for maximum performance and extended coolant life.**