

# Power Up Soluble Cutting Fluid

## Product Description:

Power Up SOLUBLE OIL is a soluble oil concentrate. This product was designed to be extended with water for the machining and grinding of virtually all metals except magnesium. It forms a milky white emulsion that does not readily decompose.

Designed for use in metalworking applications such as all CNC milling, turning, drilling, tapping and grinding.

Power Up SOLUBLE OIL is also suitable for light-duty stamping operations. Suggested mixture: 1:3 to 1:10 based upon results obtained from the mixture.

## Applications / Benefits:

1. Increased production resulting from longer tool life and reduced downtime for tool changes
2. Improved surface finish, closer tolerances and reduced formation of built-up edge resulting in fewer rejects
3. Excellent lubricity Cooler work pieces and increased feed rates possible for reduced operating costs
4. Broad multi-purpose capability Suitability for a wide range of severe machining operations on difficult steels
5. Light transparent colour and Provides a clear view of the tool and work piece

## Typical Characteristics:

Appearance - concentrate	Brown Clear Liquid
Appearance - dilution	Opaque White
Odor	Bland
Residual Film	Soft, Fluid
Specific Gravity @ 60°F	0.919 ± 0.01
API Gravity	22.5
Lbs/Gallon	7.65 ± 0.1
Flash Point - COC	355°F/179°C

## CONCENTRATION

CONCENTRATION	4% (1:25)	5% (1:20)	6% (1:17)	7% (1:14)	8% (1:12)	9% (1:11)	10% (1:10)
REFRACTOMETER READING	4.4	5.4	7.0	8.0	9.0	10.2	11.4

(An optical refractometer may be used for determining concentration)