SO-COOL MM CUTTING FLUID

Water miscible, oil based cutting fluid

APPLICATION

SO-COOL MM CUTTING FLUID is a superior water miscible, oil based cutting fluid designed for general purpose machining on ferrous and non-ferrous metals. Suitable for a wide range of machining applications, such as general milling, drilling, turning, sawing, machining, rolling and grinding.

Not recommended for more arduous operations on stainless steel.

SO-COOL MM CUTTING FLUID is specially designed for use at higher temperatures and is particularly suitable for heavier general purpose machining operations such as surface and cylindrical grinding, rolling and general heavy machining.

Specially formulated for use in both hard and soft water areas and is easily disposed of using conventional techniques.

ADVANTAGES / BENEFITS

- **Environmentally improved - does NOT contain formaldehyde, boron or chlorinated additives**
- **Based on highly refined mineral oils**
- **High degree of machine tool lubrication**
- **Ideal for a wide range of machining operations**
- **Low odour**
- **Low unit cost**

MACHINE CLEANING

To optimise service life, the machine should be flushed thoroughly using a system cleaning fluid prior to recharging with fresh fluid.

STORAGE

Minimum Storage Life: 6 months if stored indoors in unopened, original containers at ambient temperatures. Soluble oil concentrates may be damaged by frost.

FLUID MONITORING

As with all modern cutting fluids, concentration control is of paramount importance, therefore regular check by use of a refractometer is recommended for this product. It should be noted that the individual product refractometer correction factor should always be used to ensure accuracy.

COMPONENT PROTECTION

Following manufacturing operations Cromwell recommends the use of our fully compatible cleaners and corrosion preventives to clean and protect your components. Please refer to data sheets, or contact your local Cromwell Area Manager to discuss your requirements.

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APPLICATION CONCENTRATION

To ensure the optimum corrosion protection, and lifetime of the emulsion, we recommend the following concentration range:

General machining, sawing etc **5 – 8%**
Grinding **3 – 4%**
(surface, cylindrical, centreless)

However, the ultimate concentration must also be compatible with the materials involved and the machining operation.

MIXING TEMPERATURE

The optimum mixing temperature for water and concentrate is 15 – 20°C.

Our Application Specialists will be pleased to advise you regarding specific applications.

Changes in colour and slight sedimentations in the water-miscible cutting fluid concentrate have no adversely effect on the quality or the performance of the product.

TECHNICAL DATA

Characteristics	Unit	Result	Test Method
Appearance: Concentrate Emulsion		 Clear brown Opaque white	
Specific gravity at 15.6°C		0.935	IP160
Low temperature stability test at -2°C		Stable	
pH value, 5% emulsion		9.2	
Corrosion filterchip	%	2.5 break point	IP287
Refractometer correction factor		0.9	

Note: Refractometer Reading x Correction Factor = Actual Concentration

AVAILABLE PACK SIZES

Grade Name	Pack Size	Part Number
SO-COOL MM CUTTING FLUID	20ltr	SOL-740-5340F
	205ltr	SOL-740-5341M

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