



QUALIPRO LUBRICANTS

Protect - Clean - Cool

Soluble Cutting Oil

QP Soluble Oil is a quality soluble cutting oil manufactured from a mixture of special base oils and emulsifying agents to produce a fluid with maximum cooling ability, excellent lubricity and anti-weld properties, very stable emulsifying agents to provide good resistance to bacterial growth.

Typical properties

Specific Gravity @ 15 oC	0.890
Apperance	Clear/Brown
Kinematic Viscosity mm ² /s @ 40oC	34
Flash point oC	170
Corrosion Test IP 287 @ 20:1	Pass
Emulsion Test	Pass

Applications

QP soluble cutting oil is used for wide range of carbon steel machining operations. Suitable for light machining such as drilling, planning, milling in soft in normal water conditions, it can also be used for grinding where a clean emulsion is required to rapidly settle-out the grinding metal fines.

Water Dilution Guide (Parts water to Parts oil)

OPERATION DILUTION	RATIO
DRILLING	10:1 to 15:1
GRINDING	30:1 to 50:1
REAM/BORE	10:1 to 15:1
SAWING	10:1 to 15:1
MILLING	10:1 to 15:1

General practice is to add the soluble oil to the water.