



# SOLUBLE OIL HD 295-B

## (Heavy Duty Soluble Oil)

**SOLUBLE OIL HD 295-B** is a red, water-soluble, bio-resistant, heavy-duty cutting fluid used for all metals except magnesium where good cooling is desired. It incorporates specialized extreme pressure agents, rust and foam inhibitors and effective emulsifiers that stabilize the fluid in soft or hard water. It contains no nitrite or phenol and is safe to use in high-speed cutting operations.

**SOLUBLE OIL HD 295-B** is recommended for use in light or heavy duty cutting of ferrous and nonferrous metals. It is especially recommended for use in milling, boring and turning operations on nonferrous and ferrous metals with machinability ratings less than 50. For cutting operations the dilution is 5:1 to 30:1 depending upon the metal and its machinability rating

**SOLUBLE OIL HD 295-B** is used for plain grinding operations of ferrous and nonferrous metals at water to oil ratio of 7:1 to 60:1.

**SOLUBLE HD 295-B** contains an effective bactericide at combating microorganisms in sumps and reservoirs. It is most effective at combating microorganisms when it is used at water to oil ratio of 20:1 or lower.

### BENEFITS:

- DYED RED
- FORMS STABLE EMULSION
- FOAM & RUST INHIBITED
- HEAVY DUTY EP FOR SEVERE MACHINING OPERATIONS
- SAFE TO USE, NITRITE FREE AND PHENOL FREE
- NON STAINING

## TYPICAL CHARACTERISTICS

Grade	HD 295-B
Product Code	16903
API Gravity (ASTM D-1298)	21.8
Specific gravity	0.923
Color	Red
Viscosity (ASTM D-445):	
cSt @ 40°C	50.2
cSt @ 100°C	6.0
SUS @ 100°F	261
Viscosity Index	40
Pour Point (ASTM D-97) °F (°C)	-20 (-29)
Flash Point (ASTM D-92) °F (°C)	285 (141)
Inactive Sulfur, %	0.5
Chlorine, %	13.
Emulsion Stability, 24 hr	
A. 5% oil in distilled water	Slight ring - no oil
B. 5% oil in 400 ppm CaCO <sub>3</sub>	1 ml Cream cuff – no oil
Sulfur, Wt. %	0.55

The above data is subject to usual manufacturing variation. For more information and availability, call 1-800-442-LUBE.  
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