



SOLUBLE OIL XD

SOLUBLE OIL XD is a water-soluble metal cutting fluid containing rust and foam inhibitors and an emulsifier that effectively stabilizes the fluid in soft or hard water. It contains no nitrite or phenol and is safe to use in high-speed cutting operations. It is non-staining towards yellow metals.

SOLUBLE XD contains an effective and low-odor bactericide at combating microorganisms (both yeast and bacteria) in sumps and reservoirs. **SOLUBLE OIL XD** is effective at combating microorganisms even when it is used at high water to oil ratio of 25:1. It is more concentrated when used at lower water content levels (dilutions of 20:1, 10:1 etc).

SOLUBLE OIL XD is recommended for use in cutting of ferrous and nonferrous metals. This fluid is recommended for use in milling, boring and turning operations on nonferrous and ferrous metals with machinability rating of 50-100. Approximate water to oil ratio is 30:1 for aluminum and copper, 10:1 for copper alloys, and 15:1 for ferrous metals. It is used for such machining operations as planing and shaping, plain drilling and sawing of nonferrous

and ferrous metals with machinability rating 30-100. Approximate water to oil ratio-30:1 for aluminum and copper; 10:1 for copper alloys and 20:1 for ferrous metals.

SOLUBLE OIL XD is used for plain grinding operations of ferrous and nonferrous metals at water to oil ratio of 40:1 to 50:1. Other uses include, rust preventative for automotive radiators to 40:1 ratio and as rust preventative in water hydraulic systems at 10:1 ratio.

BENEFITS:

- EFFECTIVE BIOCIDES
- FORMS STABLE EMULSIONS
- FOAM INHIBITED
- RUST INHIBITED FOR PROTECTION OF MACHINE PARTS AND WORKPIECE
- SAFE TO USE, NITRITE FREE AND PHENOL FREE

TYPICAL CHARACTERISTICS

Grade	XD
Product Code	16904
API Gravity (ASTM D-1298)	28.1
Specific gravity	0.887
Color, ASTM D 1500	L3.0
Viscosity (ASTM D-445):	
cSt @ 40°C	23.2
cSt @ 100°C	4.45
Viscosity Index	101
Pour Point (ASTM D-97) °F (°C)	+10 (-12)
Flash Point (ASTM D-92) °F (°C)	395 (203)
Emulsion Stability, 24 hr	
A. 5% oil in distilled water	Slight ring - no oil
B. 5% oil in 340 ppm hardness	Slight ring - no oil
Copper strip	1A

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