



Soluble Oil D

Efficient performance general purpose soluble oil

Product Data Sheet

Product description

Soluble Oil D is an efficient performance general purpose soluble oil, formulated with selected base oils, coupling agents and a high level of emulsifiers. It forms a very stable emulsion even when mixed with relatively hard water.

Soluble Oil D is formulated with significant levels of detergency agents and reserve alkalinity, low foaming tendencies and biocides to help combat the wide spectrum of bacteria found in sumps and reservoirs.

Customer benefits

- Detergency performance keeps grinding wheels free of grit and rapidly settles fines while also assisting with chip flushing, keeping the workpiece clean and increasing wheel service life
- Low foam tendency contributes to high-speed operating performance
- Good cooling and lubricity help reduce heat and friction and contribute to improved dimensional accuracy and surface finish
- Robust base oil and high reserve alkalinity contributes to reduced acid formation and assists in machine rust protection
- Balanced base oil, emulsifier and coupling agent formulation helps maintain stable, long-life emulsion performance
- High level of reserve alkalinity and effective biocide agent improves the emulsion's resistance to bacterial degradation

Applications

- Light machining such as drilling, planing, milling, sawing and turning operations on a variety of carbon and alloy steels ranging from soft to medium hardness, particularly where carbide tip tooling is being used
- Recommended for grinding operations where very clean emulsions are typically required to permit rapid settling of fines

Product highlights:

- Rapid flushing and fine settlement
- Low foaming tendency
- High alkalinity formulation

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Warning: Water-containing metalworking fluids such as soluble oil emulsions should never be used for machining operations on magnesium or magnesium-containing alloys as a fire or explosion hazard may exist.

Dilution

- General machining: 5 - 10 %
- Grinding: 5 %
- Soluble Oil D forms a milky white emulsion when mixed with water
- For use in water with total hardness up to 200 mg/L
- Always add oil to water (not water to oil)
- Refractometer factor is 1.1 (i.e., a refractometer reading of 1°Brix represents an emulsion strength of 1.1 %)

Typical test data

SOLUBLE OIL D	TEST METHODS	RESULTS
TEST		
Product Code		000786
Appearance (in neat form)	Visual	Dark Red
Density, 15 °C, kg/l	ASTM D1298	0.893
pH at 5 % dilution	-	9.4
Corrosion Protection Break point, %	IP 287	4
Dilution		
General machining		5 - 10 %
Grinding		5 %

The information given in the typical data does not constitute a specification but is an indication based on current production and can be affected by allowable production tolerances. The right to make modifications is reserved. This supersedes all previous editions and information contained in them.



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continued

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Health, safety, storage and environmental Based on current available information, this product is not expected to produce adverse effects on health when used for the intended application and in accordance with the recommendations provided in the Material Safety Data Sheet (MSDS). MSDS's are available upon request through your local sales office, or via the Internet. This product should not be used for purposes other than its intended use. When disposing of used product, take care to protect the environment and follow local legislation.

For more information, go to www.chevronlubricants.com

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