

# FLUIDTECH TECHNICAL DATA SHEET

## solubles

### FLUIDTECH 320 Soluble Oil / General Purpose

#### DESCRIPTION

A general purpose water soluble cutting oil for machining and grinding. Contains mineral oil and extreme pressure additives to provide excellent lubricity and extended tool life. Use for all metal cutting operations including milling, turning, sawing, drilling, tapping and grinding. This product can be used on ferrous and nonferrous metals.

#### ADVANTAGES

- EXCELLENT SUMP LIFE • EXCELLENT LUBRICITY AND EP PROPERTIES • EXTENDS TOOL LIFE
- MILD PLEASANT ODOR • EXCELLENT CORROSION PROTECTION

#### RECOMMENDED STARTING DILUTIONS

Operation	Carbon Steels, Cast Steels	High Alloy Steels, Stainless Steels	Aircraft, Tool Steels	Copper, Aluminum
Machining- Milling, Drilling, Turning	1:20 (5.0%)	1:20 (5.0%)	1:15 (6.7%)	1:20 (5.0%)
Grinding	1:25 (4.0%)	1:25 (4.0%)	1:20 (5.0%)	1:25 (4.0%)
Reaming, Tapping, Sawing, Broaching	1:10 (10.0%)	1:10 (10.0%)	1:10 (10.0%)	1:10 (10.0%)

#### PHYSICAL PROPERTIES

Form ..... Liquid  
Color ..... Blue  
Residue ..... Oily  
Specific Gravity ..... 0.92  
Flash Point ..... None  
Odor ..... Mild  
pH @ 10% Solution. .... 9.0 - 9.3

#### REFRACTOMETER READINGS

Dilution Ratio	1:10 (10.0%)	1:15 (6.7%)	1:20 (5.0%)	1:25 (4.0%)	1:30 (3.3%)
Refractometer Reading	10.0	7.5	5.0	4.4	3.8

#### AVAILABILITY

A-FT320-05 5 Gal Pail  
A-FT320-55 55 Gal Drum  
A-FT320-275 275 Gal Tote