

# FLUIDTECH TECHNICAL DATA SHEET

## solubles

### FLUIDTECH 350 Soluble Oil / Heavy Duty

#### DESCRIPTION

A heavy duty, general purpose water-soluble machining and grinding fluid. It is chlorine free, halogen free and silicone free. Excellent for use in machining of aerospace materials including aluminum, titanium and high-nickel alloys. It is chemically designed to resist bacteria and fungus. It forms a stable emulsion that resists tramp oil contamination, and provides long-term worry-free sump life. Can be used on all ferrous and nonferrous metals.

#### ADVANTAGES

- CHLORINE FREE • HALOGEN FREE • SILOXANE/SILICONE FREE • HARD WATER STABLE • EXCELLENT SUMP LIFE
- EXCELLENT LUBRICITY AND EP PROPERTIES • EXTENDS TOOL LIFE • SUPERIOR TRAMP OIL REJECTION
- 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	11.0	8.5	6.0	5.0	4.0

#### AVAILABILITY

A-FT350-05	5 Gal Pail
A-FT350-55	55 Gal Drum
A-FT350-275	275 Gal Tote