



PRODUCT DATA SHEET

GIANT SOLUCUT Soluble Cutting Oil

DESCRIPTION

GIANT SOLUCUT is a multi-functional water-soluble cutting fluid designed for long service life, low maintenance requirements and is suitable for a wide range of materials and operations. Formulated with the ideal balance between cooling and lubricity, GIANT SOLUCUT enhances tool life and surface finishes, which results in lower tool maintenance and wastages in rejected finished products.

With its inherently low foaming technology, GIANT SOLUCUT is not only designed to meet modern day machining demands of higher pressures and lower sump volumes, it also offers stable emulsions in both soft and harder waters, with excellent spontaneity. GIANT SOLUCUT contains outstanding corrosion inhibitors and biocide.

BENEFITS

- Excellent combination of cooling and lubricity for protecting tool and work piece.
- Forms very stable emulsions and can be used in both soft and harder waters with excellent spontaneity.
- Long emulsion life by rapidly separating chips or grinding dirt. Contains very effective biocide.
- Protects ferrous metals from corrosion.
- Multi-functional and can be used for a wide range of materials and operations.
- Low foaming tendency.

TYPICAL APPLICATIONS

GIANT SOLUCUT can be used for drilling, milling, reaming, sawing, threading and turning applications. It can be used on various alloys, both ferrous and non-ferrous, containing materials such as Aluminum and Copper.

OPERATION

RECOMMENDED CONCENTRATIONS, % Volume of SOLUCUT in water

Grinding	3
Light Cutting	3
Turret Lathe, Screw Machining, Milling, Reaming, Drilling	5
Broaching, Threading, Gear Cutting	10

Above recommended concentrations are general and based on common application knowledge. Required SOLUCUT concentration may vary depending on actual conditions of application and on type of material used upon (eg. low alloy steel, carbon alloy steel, aluminum, copper, etc.).

Add the concentrate to the water — not water to concentrate. Use freshly mixed product only.

GIANT SOLUCUT can also be used:

- In large presses and roll mills as a hydraulic medium, after mixing with water.
- Applied as a concentrate for protection of steel parts in covered storage where SOLUCUT absorbs moisture effectively and prevents corrosion of the metal surfaces.
- In the water cooling system of internal combustion engines where a soluble oil type rust inhibitor is recommended. The recommended concentration of oil to water for this application is 10% (volume).

SOLUCUT is not recommended for severe machining operations with extreme-pressures and high load-carrying capacities.

TYPICAL PROPERTIES

Density, kg/Litre @ 15°C	0.883
Kinematic Viscosity, cSt @ 40°C	42.6
Viscosity Index	101
Pour Point, °C	-12
Flash Point COC, °C	215