

HEAVY DUTY MACHINING & DRAWING

This soluble oil formulation is designed for heavy duty machining and drawing for use on stainless steel, ferrous and non-ferrous metals such as aluminum.

<u>COMPOUND</u>	<u>% WT.</u>
100 Paraffinic Oil	60.0
COLA™ LUBE 3418EPL	20.0
Chlorinated Paraffin (42%)	<u>20.0</u>
TOTAL	100.0

PROCEDURE:

Combine all ingredients with agitation while warming to 50°C.

TYPICAL PROPERTIES:

Appearance Clear Dark Brown

PERFORMANCE DATA (5% in water):

Appearance Milky Liquid
pH 8.5
Falex (Direct Scale) 2750lbs / 60in-lbs

USE DILUTION:

Grinding 1-2% in water
Light Machining 3-5% in water
Moderate Machining 5-7% in water
Heavy Machining 8-10% in water

Last Modified 07/14/2005

Formula 043

WARRANTY

Colonial Chemical guarantees that its products meet published specifications. No other warranties or guarantees are expressed or implied because the use of this material is beyond the control of Colonial Chemical.