LIGHT MACHINING & GRINDING

This cost effective soluble oil formulation provides excellent rust protection and lubricity in light machining and grinding operations.

COMPOUND	% WT.
100 Pale Oil	85.0
COLA™LUBE 3418EPL	10.0
COLA™LUBE 3415EPL	5.0
TOTAL	100.0

PROCEDURE:

Combine above ingredients with agitation while warming to 120°F.

TYPICAL PROPERTIES:

Appearance	Clear Light Brown Liquid

PERFORMANCE DATA (5% in water):

Appearance	Milky Emulsion
pH	8.0
Cast Iron Block Corrosion Test	Pass
Falex® (Direct Scale)	1250lbs / 45in-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

Formula 045

Last Modified 07/14/2005

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.

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