



## TEXAS METALCUT SOLUBLE

Quality General Purpose Water Based  
Metal-working Fluids

## PRODUCT DATA SHEET

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**Texas Petrochemical Asia Pacific Pte Ltd**

80 International Road

Singapore 629170

Tel: 65-6262 6538

Fax: 65-6262 6537

Website: [www.texaslub.com](http://www.texaslub.com)

### DESCRIPTION

Texas MetalCut Soluble is a popular general-purpose oil suitable for a wide variety of metalworking operations that demand the protection from a water-soluble lubricant, and the heat removal characteristics of a coolant. The balanced combination of a suitably chosen mineral oil and effective emulsifying agents ensure outstanding performance in many applications.

Texas MetalCut Soluble gives a stable milky emulsion over a wide range of concentrations. It provides excellent corrosion protection to machine surfaces and components being machined. It is resistant to bacteria growth and thus minimizes the occurrence of offending odor. Always add oil to water, and not water to oil. Maintain gentle agitation until all the oil had been added. Proper housekeeping and maintenance programs in the workshop will derive maximum benefits from Texas MetalCut Soluble oil.

### BENEFITS

- Emulsifies readily to form a stable emulsion
- Outstanding foam control
- Extends tool life
- Effective cooling properties
- Resists against bacterial attacks
- Excellent work finishes
- Effective general-purpose applications
- Protect against rust and corrosion

### TYPICAL APPLICATIONS

- Texas MetalCut Soluble is suitable for most general machining operations on free cutting metals where cooling is the prime requirement. Suggested oil-to-water ratios for various operations as shown below:

Operations	Oil-to-Water Ratio
Grinding	1 : 35 – 60
Cutting	
- Light Cutting	1 : 30 – 40
- Turret lathe, Screw Machining, Milling and Drilling	1 : 20
Broaching, Threading, Gear Cutting	1 : 10
General Machining (non-ferrous materials)	1 : 20 – 30
General Machining (ferrous materials)	1 : 20

### TYPICAL PROPERTIES

Appearance	Amber Fluid
Density, kg/liter @ 15°C	0.890
Color ASTM	2.5
Kinematic Viscosity, mm <sup>2</sup> /s @ 40°C	41.2
Kinematic Viscosity, mm <sup>2</sup> /s @ 100°C	7.8
Flash Point COC, °C	180
pH @ 5% dilution	9.2
Emulsion Type	Stable Milky

Typical physical and chemical characteristics do not constitute as specifications. Texas Petrochemical reserves the right to amend and change the information herein without notification as a result of continual product research and development.