

**Name:** SOLUBLE OIL 100  
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### SOLUBLE OIL 100

EP Fortified Soluble Oil Forming Fluid

#### DESCRIPTION

SOLUBLE OIL 100 is a soluble oil metalworking fluid fortified with EP additives for extreme performance when it comes to forming difficult geometries. The product possesses severely hydrotreated mineral oil to provide a compromise between performance and worker safety. SOLUBLE OIL 100 forms a highly stable emulsion in both hard and soft water and due to its diluted stability is suitable for operations where fluid is recycled and constantly used rather one time through application systems.

#### FEATURES & BENEFITS

- Suitable for forming all alloys
- EP fortified for extreme die tool protection
- Coats evenly over metal surfaces
- Low odor, low mist
- Extremely stable emulsion formation
- Excellent bio-resistance for sump systems.

#### HEALTH AND SAFETY

See the most recent SDS which is available directly from ValCOOL, your local salesman, or authorized distributor. ValCOOL uses only raw materials not listed as carcinogenic by IRAC.

#### PROPERTIES

Appearance:	Amber brown fluid
Solubility:	Forms in emulsion in water
Odor:	Mild Industrial
Specific Gravity:	.90
Viscosity @ 100oF	100 SUS @ 100°F
Flash Point:	N/A
Fat %:	8%
EP Fortification:	12%

#### APPLICATION & USAGE

SOLUBLE OIL 100 can be used to punch, draw, stamp, extrude or form all alloys in all operations. As with all products, testing should be conducted to assure desired results are achieved before moving into full production.

The product can be applied in numerous ways. The product can be run as concentrated as 1:1 or diluted out to 20:1 based on the severity of the forming process. Common application for this product is sprayed or flooded; however, the product can be painted, dipped, and or brushed.