

## SOL-T

Spanjaard SOL-T is a general purpose, semi-synthetic water-extendable metal working fluid, containing performance additives, biocides, foam suppressants and metal deactivators

### APPLICATIONS

Spanjaard SOL-T was developed for machining of ferrous (steel and cast iron) and yellow metals. Spanjaard SOL-T has a wide effectiveness range and very good resistance to microbial degradation, which results in extended cutting fluid sump life when compared to conventional products.

Spanjaard SOL-T forms stable emulsions which are tolerant to hard water and does not contain sodium nitrite or phenols.

### TYPICAL PROPERTIES

Colour	Amber
Odour	Mild amine
Density, g/cc	± 1.00
pH (5% in Tap water)	9.0 – 9.4

### APPLICATION INSTRUCTIONS

#### Recommended Dilution Rates:

- Automatic machines 3%
- Turning 3%
- Milling 4%

Add Spanjaard SOL-T at the recommended concentration level to water, stirring continuously to form a clear, stable working emulsion. As with all water-based cutting fluids working life is optimised with good housekeeping and system maintenance including initial adequate machine cleaning, correct fluid dilution rates and sump level maintenance.

Routine concentration checks and proper makeup are essential to good fluid management. It is recommended the concentration levels are evaluated with a refractometer.

### Concentration/ refractometer chart.

Percentage %	Refractometer Reading
1	0,8
2	1,2
2.5	1,6
3	2,0
4	2,4
5	3,2
6	4.0
10	4,8

Maintaining the recommended concentration range of your metalworking fluid will improve the overall performance of the operation, improve productivity, extend fluid life, reduce disposal costs, and improve overall operator satisfaction.



### HANDLING AND STORAGE

Spanjaard SOL-T should be stored below 50°C. See also Material Safety Data Sheet.

### PACKAGING

5l, 20L drums.