

# PIRANHA H.D. SOLUBLE OIL S-45

PREMIUM HEAVY DUTY SOLUBLE OIL FOR DIFFICULT TO MACHINE METALS



A PRODUCT OF LUBRICATING SPECIALTIES COMPANY

## Product Description



**H.D. SOLUBLE OIL S-45** is a carefully balanced blend of high quality mineral oil combined with an effective emulsifier, sulfur-chlorine anti-weld additive (EP) and fatty oils for additional lubricity. Used as an emulsion, this product combines the good cooling characteristics of conventional water

soluble oils with the high load carrying properties of an active cutting oil. This permits its use where extreme pressure requirements and machining operations are too severe for conventional soluble oils. Additionally, this soluble oil is free of nitrites and phenols and foam inhibited to permit its use in high speed metal cutting operations.

## Features & Benefits:

- Excellent cooling ability.
- High EP permits machining tough to cut steels.
- Smooth work finish provided by lubricity additive.
- Increased tool life through balanced additive package.
- Forms stable emulsion even with hard water.
- Foam inhibited. Safe to use - nitrite-free and phenol-free.
- Wide cutting range - from easy to machine to difficult to machine metals.
- Economical.
- Dyed blue

## Typical Test Data

TEST	ASTM	S-45	Refractometer vs. Dilution Graph														
Gravity, °API	D-4052	17.4	<table border="1"> <caption>Refractometer vs. Dilution Graph Data</caption> <thead> <tr> <th>Dilution</th> <th>Refractometer Reading</th> </tr> </thead> <tbody> <tr> <td>5:1</td> <td>20</td> </tr> <tr> <td>10:1</td> <td>10</td> </tr> <tr> <td>20:1</td> <td>5</td> </tr> <tr> <td>30:1</td> <td>3</td> </tr> <tr> <td>40:1</td> <td>2</td> </tr> <tr> <td>50:1</td> <td>2</td> </tr> </tbody> </table>	Dilution	Refractometer Reading	5:1	20	10:1	10	20:1	5	30:1	3	40:1	2	50:1	2
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5:1	20																
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50:1	2																
Appearance	----	Bright															
Color	----	Blue															
Viscosity: cSt. @ 40°C.	D-445	43.4															
Active Sulfur, Wt.%	----	0.5															
Chlorine, Wt.%	----	2.0															
Cold Test @ 40°F.	----	No Separation															
Emulsibility	----	Pass															
Emulsion Stability	----	Pass															
Foaming	D-892	Pass															
pH, 5% In DI Water	----	9.0															

\* CONTAINS HIGH PERFORMANCE ADDITIVE CHEMISTRY.  
VALUES SHOWN HERE ARE TYPICAL AND MAY VARY.

## Applications & Uses:

- For cutting difficult to machine ferrous metals of all types.
- Recommended for use in surface broaching, pipe threading, plain threading and tapping of ferrous metals with machinability rating between 60-100.
- Recommended water to oil ratio 5:1 through 10:1 depending on machinability rating.
- Also used in milling, boring and turning, plain drilling, sawing and thread and form grinding of ferrous metals with machinability rating between 30-100. Recommended water to oil ratio 10:1 through 20:1 depending on machinability rating.
- Commonly used in plain grinding operations at ratios between 40:1 through 50:1.
- NOT suitable for cutting copper or its alloys as the EP properties will tarnish these metals. Can be used on aluminum.

**NOTE: NEVER USE SOLUBLE OIL EMULSIONS FOR CUTTING MAGNESIUM. HOT MAGNESIUM AND WATER ARE A FIRE HAZARD.**

## TECHNICAL PRODUCT INFORMATION

PRODUCT CODE: 39006

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