



**Soluble Cutting Oil SC-10™**

*Fully formulated water soluble cutting oil designed to reduce surface temperatures and extend tool life in a wide range of metalworking operations – Contains biocide to combat organism formation in machine reservoirs and sumps*

**Key Features & Benefits**

- Extends tool life over conventional soluble oils
- Contains industry level biocide to reduce rancidity problems
- Provides smoother finishes
- Enhances cutting ability
- Protects work, tools and equipment from rust and corrosion
- Excellent cooling properties
- Forms a stable emulsion
- Provides process visibility (becomes milky white in appearance once emulsified with water)
- Can be used in a wide range of machining operations
- Contains multiple metalworking technologies, including ionic bonding agents and metal film strength reducers
- Contains **Muscle Metal Treatment MT-10®** technology for lubricity enhancement and friction-reducing properties

**Directions for Use**

Reduce **SC-10™** with water to the desired emulsion ratio depending on the operation.

**Technical Data**

Appearance .....	Dark amber liquid
Odor .....	Strong
pH .....	9.0 D1287
Initial boiling point .....	257°F (125°C) D1120
Flash point .....	305.6°F (152°C) D93
Specific gravity @ 60°F.....	0.9383 D1298
Lbs per gal (U.S).....	~ 7.826
Viscosity @ 40°C .....	40.09 cSt D445
Viscosity @ 100°C .....	6.39 cSt D445
Solubility .....	Dispersible in water

*The above properties are typical values and do not constitute a product specification.*

**Container Availability**

Item SC-10-128.....	1 U.S. gallon (3.8 L)
Item SC-10-5G .....	37 lbs net wt / pail
Item SC-10-55G.....	410 lbs net wt / drum

**Typical Applications & Emulsion Ratios**

- Light machining of soft to medium hardness steel  
Typical emulsion ~ 20:1
- Grinding operations requiring excellent cooling and a lower ratio  
Typical emulsion ~ 40:1

