



### 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 ..... | 5 U.S. gallon (18.9 L) |
| Item SC-10-55G..... | 55 U.S. gallon (208 L) |

#### 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

