



Soluble Light #2 Metal Working Fluid with Bactericide



Features & Benefits

- Uses low pH corrosion inhibitors
- Resist demulsification
- Excellent hard water and well water stability
- Contains bio resistant ingredients
- Effectively forms a stable emulsion for maximum cooling benefit
- Versatile can be used for many machining operations

Typical Properties

Test	Typical Result
Colour	Amber
Viscosity @ 40°C (D445) (cSt)	23
Specific Gravity @ 15.6 (D1298) (°C)	0.890
pH @ 5% in Tap Water (FLA)	8.7
Flash Point (D92) (°C)	>154

Recommended Uses

Application	Ratio (Water:Oil)
Drilling & Reaming	10:1 to 15:1
Turning & Sawing	15:1 to 30:1
Grinding	30:1 to 50:1
Milling & Boring	10:1 to 15:1

SOLUBLE 2 oil is a metal-working fluid designed to emulsify easily with water and is especially effective in the machining of ferrous metals. This formulation has an effective rust inhibitor and a bactericide to prevent disagreeable odors. In its heaviest concentrations (10 parts water to 1 part oil) it is suitable for slow-speed, medium to heavy machining operations that includes threading, tapping, drilling and broaching.

SOLUBLE 2 in lesser concentrations (20:1 or 30:1) is suitable for medium and high speed machining and gives very good results in finishing applications. The action of shearing a chip away from a metal surface generates heat. This heat needs to be removed or it will affect the finish and shorten the tool life. Proper lubricant formulations can help to reduce heat generation by reducing rubbing friction. Soluble oils have shown themselves to offer the best of both worlds.

For longer fluid life it is very important to keep the fluid clean. The fluid should be filtered to remove swarf. The pH of the emulsion must be controlled to prevent the growth of bacteria and fungi otherwise they will weaken the emulsion, causing the oil to separate and releasing objectionable smells. The pH can be adjusted with the addition of a suitable agent. If an incorrect pH causes a problem, it can be corrected by adding a bactericide or fungicide. For stable emulsion, always start by adding the oil to water, about 1 part oil to 4 parts water; then dilute the emulsion with more water to the desired strength.

DO NOT LET SOLUBLE 2 FREEZE.

Sizes and Codes

Soluble Light #2
205L / 54.2 US Gal F0018150

www.irvingoil.com/lubricants
1.800.574.5823

Supporting data available to demonstrate acceptable performance. Check with your sales associate for latest product approvals. Please note, these are typical performance indicators and can change without notice.

This data sheet replaces previous versions prior 01.20.20.

www.irvingoil.com/lubricants 1.800.574.5823