

SUPER SOL 747 CUTTING COOLANT



SUPER SOL 747 was developed to provide ONE product that can be used for practically all machining and grinding operations. It is designed for cutting and grinding operations on a wide variety of difficult machining alloys. This is possible due to a unique blend of extreme pressure additives, lubricity additives, and emulsifiers. Emulsions of **SUPER SOL 747** have excellent cooling, wetting and low tool wear capabilities. It has proven itself to be the most economical cutting fluid available, in terms of lowest machining cost per part. This takes into consideration the tool life and life of the coolant.

ADVANTAGES

- Versatile Performance** **SUPER SOL 747** is designed to machine or grind ferrous and nonferrous metals. It contains special inhibitors and lubricity agents to give good finish on soft metals such as aluminum alloys and also provides outstanding tool life on tough stainless steel alloys.
- Long Life:** **SUPER SOL 747** contains a safe NON-PHENOLIC preservative that prevents rancidity or bacteria spoilage. Make-up is added as required and the emulsion can be operated for long periods without dumping.
- Clean Performance:** **SUPER SOL 747** contains a special built-in cleaning action that prevents dirt and chips from building up. The residue is fluid and has excellent lubrication value to prevent sticky ways, slides, indexing heads and compound rests. Machines stay clean and productive.
- Improved Tool Life:** **SUPER SOL 747** contains a special blend of Extreme Pressure and lubricity additives that combine to provide lower operating temperatures and longer tool life.
- Corrosion Inhibition:** **SUPER SOL 747** is balanced with a special inhibitor system to prevent rusting of ferrous alloys and machines even at high dilutions of 50/1 and 60/1. It also protects aluminum and copper alloys from staining when traces of the emulsion remain on the work.

PHYSICAL PROPERTIES

Color and Form	Dark Green Liquid	Flash Point, C.O.C. ° F. 335
Specific Gravity @ 60	0.967	pH 2.5% Concentration 9.5
Weight per Gallon, lb.	8.06	pH 5.0% Concentration 9.7
Odor	Mild	

PHYSICAL PROPERTIES CONTINUED

Falex E.P. Test 10/1 Dilution – Weld Load, lbs. – 4350
20/1 Dilution – Weld Load, lbs. - 4400

Falex Wear Test

(1/2 hr. @ 500 lbs. – Pin Wt. loss, mfg.)

10/1/Dilution – 1.2 mg.

20/1 Dilution – 3.0 mg.

SUGGESTED STARTING DILUTION FOR VARIOUS MACHINING OPERATIONS

Machine Operation	High Speed Steel Tool	Carbide Tool
Turning	20/1	30/1
Boring	20/1	30/1
Planing	20/1	30/1
Face Milling	20/1	30/1
Slab Milling	20/1	30/1
Metal Slitting	20/1	30/1
Drilling	20/1	30/1
Broaching	10/1	10/1
Trepanning	10/1	--
Reaming	5/1	5/1
Power Sawing	10/1	--
Circular Sawing	10/1	10/1
Gear Hobbing	10/1	--
Gear Shaping	10/1	--
Gear Cutting	10/1	--
Gear Shaving	10/1	--