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## Soltrend GP

### General Purpose Cutting Fluid

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#### Description; Description

Soltrend GP is a superior general purpose water miscible cutting fluid concentrate that forms a stable milky white emulsion when mixed with water.

Based on a novel formulatory approach, the product contains a highly solvent refined mineral oil, bioresistant emulsifiers and nitrite free corrosion inhibitors.

#### Applications; Applications

Soltrend GP is a conventional milky soluble cutting fluid with a wide range of applications. It is suitable for all general purpose machining operations of a variety of free cutting steels and for certain alloys of copper and of aluminium.

Emulsion Preparation - to ensure that satisfactory results can be obtained using Soltrend GP, especially when replacing a polluted fluid, it is recommended that both the sump and the lines are disinfected and cleaned prior to filling using BP System Cleaner. The system should then be thoroughly rinsed to avoid potential foaming problems.

Suggested dilution ratios vary according to application and severity of operation:

Ferrous/Nonferrous metals  
Turning, drilling and sawing 5%  
Milling, reaming and tapping 5-10%  
Grinding 3-5%

The emulsion is prepared by the simple addition of the concentrate to clean tap water under gentle agitation. Best results are obtained using a mixing device.

Emulsion Monitoring - the concentration of Soltrend GP can be checked quickly and easily by using a pocket refractometer and by correlating its reading with the relevant concentration-refractometer graph.

#### Main Benefits; Main Benefits

- Excellent corrosion protection
- Effective resistance to bacterial degradation
- No added phenol, chlorine or nitrite
- Cost effective

- Good dilution stability even in hard waters
- High oil content provides good machining performance and a high degree of residual corrosion protection
- Low odour - pleasant to work with

#### Storage; Storage

All packages should be stored under cover. Where outside storage is unavoidable drums should be laid horizontally to avoid the possible ingress of water and the obliteration  
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of drum markings. Products should not be stored above 60°C, exposed to hot sun or freezing conditions.; of drum markings. Products should not be stored above 60°C, exposed to hot sun or freezing conditions.

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## Health, Safety and Environment; Health, Safety and Environment

Health, safety and environmental information is provided for this product in the Materials Safety Data Sheet. This gives details of potential hazards, precautions and First Aid measures, together with environmental effects and disposal of used products.; Health, safety and environmental information is provided for this product in the Materials Safety Data Sheet. This gives details of potential hazards, precautions and First Aid measures, together with environmental effects and disposal of used products.

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## Typical Characteristics; Typical Characteristics

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| Test Methods; Test Methods | Units; Units | Grade ;: Grade : |
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Soltrend GP

### Concentrate

Appearance amber

Density at 15°C ISO3675/ASTMD1298 kg/m<sup>3</sup> 930

Kinematic Viscosity at 40°C ISO3105/ASTMD445 mm<sup>2</sup>/s 50

Mineral Oil Content % 73

### Dilution

Dilution Appearance milky

pH value (5% dil) 9.4

Herbert Corrosion Test IP 125 0/0-0  
(4.0% dil)

Filter Paper Corrosion Test IP 287 % Nil  
(3.5% dil)

Refractometer Ratio 1.0

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*The above figures are typical of those obtained with normal production tolerance and do not constitute a specification.; The above figures are typical of those obtained with normal production tolerance and do not constitute a specification.*

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