



Trusol GP and EP are soluble cutting oils designed to act as coolants and lubricants during metal cutting operations and provide optimum surface finishes and dimensional accuracy to the work piece. They are nitrite free and present minimal health hazards.

The range consists of Trusol GP (general purpose) and Trusol EP (extreme pressure). They are formulated on paraffinic base stocks, emulsifying agents, anti rust and anti corrosion additives and, in the case of Trusol EP, an extreme pressure additive. They form stable oil-in-water emulsions that are resistant to bacterial growth and consequent rancidity. They are used at oil/water ratios of 1:8 to 1:50 depending upon the type and severity of the machining operation.

RECOMMENDED FOR

Trusol GP is a general purpose, broad spectrum, cutting oil which forms a pale green milky emulsion with water. It is suitable for cutting operations on low and medium tensile steels, free machining brass and bronze and cast iron. It is also used as a grinding fluid, particularly where component finish is a high priority.

Trusol EP is an extreme pressure, heavy duty, cutting oil which forms a milky emulsion of high lubricity with water. It is suitable for heavy duty machining such as tapping and threading of high carbon, alloy and stainless steels.

BENEFITS

- Phenol, cresol, nitrite free.
- Mix readily with water.
- Good emulsion stability and fluid life.
- Resistant towards rust and corrosion.
- Good wetting and heat transfer properties.
- Built-in resistance to biological degradation.
- Low foaming tendency.
- Disposable through conventional acid splitting techniques.
- Good concentrate shelf stability.

TYPICAL CHARACTERISTICS

Product Code	1704	1703
	Trusol GP	Trusol EP
Density at 15°C, kg/L	0.906	0.945
Colour, Neat Emulsion	Green Pale Green	Medium Brown White
pH, Concentrate 5.0% dilution 10.0% dilution	10.1 9.4 9.6	10.9 9.5 9.3
Viscosity, cSt at 40°C	31.5	40.00
Rust Test	Pass	Pass



APPLICATIONS

Table shows which product or products may be used and the dilution in water to be used.

METAL	Aluminium & Alloys	Brasses & Bronzes	Copper	Cast & Wrought Iron; Nodular	Nickel; Nickel Alloys; Monels; Iconels; Nimonic	Steels, Mild; Low Alloy; Low Carbon	Steels- Medium Tensile	Steels- High Tensile; High Cr.; Ni. Alloy	Stainless Steel; Heat Resistant
MILLING	GP; EP 5%	GP; EP 5%	GP; EP 5%	EP; GP 5%	EP 5 - 10%	EP 5%	EP 5%	EP 8 - 10%	EP 8 - 10%
DRILLING	GP; EP 5%	GP; EP 5%	GP; EP 5%	EP; GP 5%	EP 5 - 10%	EP 5%	EP 5%	EP 8 - 10%	EP 8 - 10%
BORING	GP; EP 5%	EP 5%	GP; EP 5%	EP; GP 5%	EP 5 - 10%	EP 5%	EP 5%	EP 8 - 10%	EP 8 - 10%
REAMING	EP 5 - 10%	EP 5%	EP 5%	EP 5 - 10%	EP 5 - 10%	EP 5 - 10%	EP 5-10%	EP 8 - 10%	EP 8 - 10%
TURNING - Capstan Turret; - Multi Lathe	GP; EP 5%	EP 5%	GP; EP 5%	GP; EP 5%	EP 5 - 10%	GP; EP 5%	EP 5%	EP 8 - 10%	EP 8 - 10%
BROACHING	EP 5 - 10%	EP 5 - 10%	EP 5 - 10%	EP 5 - 10%	EP 5 - 10%	GP; EP 5 - 10%	EP 5-10%	EP 5 - 10%	EP 8 - 10%
GRINDING - Plain; - Centre-less; - Surface	EP 5%	GP EP 5%	GP; EP 5%	GP; EP 5%	GP; EP 5%	EP 5 %	EP 5%	EP 5%	EP 5%
COLD SAWING	GP; EP 5%	GP; EP 5%	GP; EP 5%	GP; EP 5%	EP 5%	GP; EP 5%	EP 5%	EP 5%	EP 5%
THREADING	EP 5%	EP 5 - 10%	EP 5%	EP 5%	EP 5 - 10%	GP; EP 5%	EP 5%	EP 8 - 10%	EP 8 - 10%
GEAR CUTTING - Shaving; - Planing; - Hobbing; - Shaping.	EP 5 - 10%	EP 5 - 10%	EP 5 - 10%	EP 5 - 10%	EP 8 - 10%	EP 8 - 10%	EP 8 - 10%	EP 10%	EP 10%



PACK SIZES

20L

ENVIRONMENT, HEALTH AND SAFETY

Users should consult the MSDS, follow the precautions outlined and comply with all laws and regulations concerning its use and disposal. Used packaging material should not be incinerated or exposed to flame. After use, protect your environment. Do not pollute drains, soil or water with used product.

OTHER INFORMATION

For further information on Caltex products and services call the Lubelink Advisory Service on 1300 364 169 between 8.00am and 6.00pm (EST) Monday to Friday.

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