

PRODUCT DATA SHEET

DAVID WEBER OIL CO.

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Gibraltar Water Soluble Oil

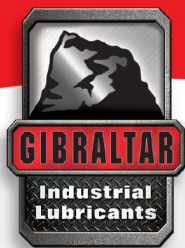
Soluble Oil Concentrate for Metalworking

Gibraltar Water Soluble Oil is a premium soluble oil concentrate designed for metalworking. It is suitable for virtually all metals, except magnesium, and is mixed with water for machining and grinding operations.

Gibraltar Water Soluble Oil can be used in all metalworking applications, such as CNC milling, turning, drilling, tapping and grinding. It's low-foam and pleasant odor formulation produce a product that is easy to use and operator-friendly. Free from heavy metals and other controlled compounds, it is long lasting and effective.

Gibraltar Water Soluble Oil provides the following benefits:

- Sulfur, Chlorine and Phos free
- Low foaming
- Excellent corrosion inhibition
- Long lasting and operator friendly
- Hard water stable
- Produces excellent surface finishes



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MIXING AND CONCENTRATIONS

Concentration	4%	5%	6%	7%	8%	9%	10%
Dilution Ratio	1:25	1:20	1:17	1:14	1:12	1:11	1:10
Refractometer Reading	4.8	6.0	7.2	8.4	9.6	10.8	12.0

When mixing coolant, it is best to use an automatic proportioner which accurately and thoroughly mixes coolant. To maintain recommended concentration, make-up or top-off should be added at one-half of the desired concentration. Never add concentrate directly to the machine; this could cause inverted emulsions.

<u>Applications</u>	<u>Concentration</u>	<u>Ratio</u>	<u>Refractometer</u>
Milling, Drilling, Turning	5%	1:20	6.0
Centerless, ID, OD, Surface Grinding	4%	1:25	4.8
Tapping, Sawing, Reaming	10%	1:10	12.0

TYPICAL PROPERTIES

Appearance - Concentrate	Dark Amber
Appearance - Dilution	Opaque White
Residual Film	Soft, Fluid
pH @ 5%	9.0 +/- 0.2
Specific Gravity	0.90 +/- 0.03
Lbs./Gal	7.5 +/- 0.1
Flash Point, COC, F	355