



# Product Data Sheet



## 502 Soluble Oil

### *Soluble Oil with BacteriaStat*

**502 Soluble Oil** is an economical, highly effective oil-based coolant for metalworking applications. This versatile product provides excellent performance in cooling and lubricating the tool to work in high-speed, ferrous and non-ferrous metal cutting and grinding applications.

**502 Soluble Oil** mixes readily with water to form stable emulsions and is formulated to provide outstanding rust preventative properties. This product is enhanced with a bactericide to prevent coolant souring during use. **502 Soluble Oil** will maximize performance over a spectrum of pressures and temperatures when machining easy to difficult metals under harsh conditions. The recommended mix ratio is 20:1.

#### Product Features:

- Readily mixes with water to form stable emulsions
- Bactericide prevents the buildup of fungi and bacteria
- Use one fluid for both ferrous and non-ferrous metals

#### Customer Benefits:

- Multi-purposed and able to handle a variety of metal cutting applications
- Provides excellent physical lubricity for the cutting operation as well as the machine tool.
- Minimizes chance for seizure and has anti-weld properties to protect your machinery.

#### Applications:

- For use as a coolant and lubricant in metal cutting operations





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## Typical Properties

### 502 Soluble Oil

Product Number	502	Test Method
API	29.08	-
Specific Gravity	0.8812	ASTM 4052
Lbs./Gal	7.339	-
Density	0.8807	-
Flash Point °C	186	ASTM D92
Pour Point °C	-18	ASTM D97
Color	<1.0	ASTM D1500
Viscosity@100°C cSt	6.021	ASTM D445
Viscosity@40°C cSt	36.53	ASTM D445
Viscosity Index (VI)	109	ASTM D2270

These properties are typical of the current production. Variations that do not affect product performance are to be expected depending on blending and manufacturing locations. The information above is subject to change without notice.

#### Health and Safety:

This product is unlikely to have any adverse health implications or safety hazards when used for its intended application. Avoid contact with skin, use resistant gloves when handling used oil. If skin comes in contact wash immediately with soap and water. For complete information on safe handling and product characteristics please refer to the Material Safety Data Sheet (MSDS) found on our website.

[www.royalmfg.com](http://www.royalmfg.com) or call (918)-584-2671.

#### Packaging options:



55 Gal. Drums



275/330 Gal Totes



>2000 Gal Bulk

