



Soluble Light #2

Metal Working Fluid with Bactericide

Features & benefits

- Uses low pH corrosion inhibitors
- Resists demulsification
- Excellent hard water and well water stability
- Contains bio-resistant ingredients
- Effectively forms a stable emulsion for maximum cooling benefit
- Versatile can be used for many machining operations



Typical results

| Test Method | Soluble Light #2 |
|---|------------------|
| Viscosity @ 40°C (D445), cSt | 36.0 |
| Appearance | Amber / Clear |
| Specific Gravity @ 15.6 (D4052), °C | 0.92 |
| pH (5% Tap Water Emulsion) (FLA 003) | 8.7 |
| Flash Point (D92), °C | >154 |

Recommended Uses

| Application | Ratio (Water:Oil) |
|--------------------|----------------------|
| Drilling & Reaming | 10:1 to 15:1 |
| Milling & Boring | 10:1 to 15:1 |
| Turning & Sawing | 15:1 to 30:1 |
| Grinding | 30:1 to 50:1 |

Sizes & order codes

| Size | Soluble Light #2 |
|--------------------|------------------|
| 205L / 54.2 US Gal | F0018150 |

Soluble Light #2 is a premium conventional metal-working fluid for general-purpose machining operations. It is designed to reduce heat, fight bacteria, mold and yeast extending the fluid life.

Soluble Light #2 should be added to water to ensure a stable emulsion of oil droplets in water is formed for proper protection. If water is added to the oil an inverted emulsion will form resulting in poor stability and corrosion protection.

Soluble Light #2 has effective rust inhibitors and a bactericide to prevent disagreeable odors. In its heaviest concentrations (10 parts water to 1 part oil) it is suitable for slow-speed, medium to heavy machining operations that include threading, tapping, drilling and broaching.

Soluble Light #2 in lesser concentrations (20:1 or 30:1) is suitable for medium and high-speed machining and gives very good results in finishing applications.

Soluble Light #2 should be stored at room temperature, do NOT let **Soluble Light #2** freeze.

Always consult your owner's manual for verification of fluid type and grade.
Check with sales associate for the latest product approvals and acceptable performance data.
Please note these are typical performance indicators and can change without notice.

This data sheet replaces previous versions prior to January 3, 2025.

www.irvingoil.com/lubricants • 1.800.574.5823