



DEEP DRILL Soluble Oil

PRODUCT DESCRIPTION

ASHBURN DEEP DRILL is a heavy duty, water soluble cutting oil. This product is formulated with a unique blend of additives that out perform conventional straight oils in severe operations. It provides superior lubrication for greater accuracy, fewer rejects & increased productivity, as well as, excellent rust protection for parts & machinery.

TYPICAL ANALYSIS

APPEARANCE:.....Translucent Amber Liquid
 pH @ 5% SOLUTION:9.2
 SPECIFIC GRAVITY:1.03
 ODOR:..... Pleasant

APPLICATION

Recommended for difficult machining applications such as deep hole drilling, gun drilling, form grinding & crush grinding of steels, aluminum and alloys such as titanium & inconel.

RECOMMENDED STARTING DILUTIONS

Operation	Carbon Steels, Cast Steels	High Alloy Steels, Stainless Steels	Aircraft, Tool Steels	Copper, Aluminum
Machining-Milling Drilling, Turning	1:20 (5.0%)	1:20 (5.0%)	1:15 (6.7%)	1:20 (5.0%)
Grinding	1:25 (4.0%)	1:25 (4.0%)	1:20 (5.0%)	1:25 (4.0%)
Reaming, Tapping, Sawing, Broaching	1:10 (10%)	1:10 (10%)	1:10 (10%)	1:10 (10%)

REFRACTOMETER READINGS

Dilution Ratio	1:10 (10.0%)	1:15 (6.7%)	1:20 (5.0%)	1:25 (4.0%)	1:30 (3.3%)
Refractometer Reading	10.0	6.8	5.0	4.0	3.0

NOTES

- Use Ashburn Machine Cleaner for quick and thorough pre-cleaning of machine tools and coolant systems.
- Consult Ashburn prior to use on metals or applications not recommended.
- Unless recommended by Ashburn, this product should not be mixed with metalworking fluid additives.

PACKAGING

A-9975-05 5 Gal Pail
 A-9975-55 55 Gal Drum
 A-9975-275 275 Gal Tote