



# Aquatex®3380

General Purpose, High Lubricity Soluble Oil

Product Data Sheet

## Customer benefits

### More efficient general machining

Extra lubricity minimizes friction between the tool and workpiece, facilitating machining at increased production rates. The low foaming tendency is an advantage in high speed operations. The high level of detergency prevents loading of grinding wheels with grit and metal fines, and also in flushing and settling of chips.

### Improved precision and surface finish

Excellent cooling and higher lubricity properties of the emulsion allow for effective heat transfer from the cutting zone and reduced friction between the tool and workpiece, providing improved dimensional accuracy and surface finish on parts.

### Lower maintenance

Selected base oil components provide effective rust protection of machine and parts, the high level of reserve alkalinity neutralizes acids that may develop in emulsion systems with use.

### Longer emulsion life

Carefully balanced combination of base oil, emulsifiers and coupling agents produces stable, long-lasting emulsions. The high level of reserve alkalinity improves the emulsion's resistance to bacterial degradation. The effective biocide combats micro-organisms.

## Applications

Can include:

- Wide variety of machining operations on non-ferrous metals such as aluminium, where extra lubricity is required
- Machining of ferrous alloys where surface finish of the part is of critical importance
- Drilling, forming, planing, milling, sawing and turning operations on a variety of carbon and alloy steels ranging from soft to medium hardness, particularly where carbide tip tooling is being used
- Grinding of aluminium and its alloys.

*Water-containing metalworking fluids such as soluble oil emulsions should never be used for machining operations on magnesium or magnesium-containing alloys as a fire or explosion hazard may exist. The recommended product for machining these metals is Almag Oil.*

## Product features:

- **Aquatex®3380** is a general purpose soluble oil specifically formulated for extra lubricity.
- **Aquatex®3380** contains selected base oils, emulsifiers and coupling agents.
- **Aquatex®3380** exhibits high levels of detergency, low foaming tendencies, and contains a biocide to combat a wide spectrum of micro-organisms commonly found in sumps and reservoirs.

## Applications cont.

AQUATEX®3380	
DILUTION	
<b>Type of Machining</b>	
General	5 - 10%
Grinding	5%

- Aquatex 3380 forms a milky white emulsion when mixed with water.
- Always add oil to water (not water to oil).
- For use in water with total hardness up to 300 mg/L.
- Refractometer factor is 1.1 (i.e., a refractometer reading of 1°Brix represents an emulsion strength of 1.1%).

## Product specifications

AQUATEX®3380	
KEY PROPERTIES	
Product code	530716
Appearance (in neat form)	Pale
Density, kg/L @ 20°C	0.90
pH @ 5% dilution	9.4
Corrosion Protection, IP287 Break Point, %	5

## ENVIRONMENT, HEALTH and SAFETY

Information is available on this product in the Material Safety Data Sheet (MSDS) and Customer Safety Guide. Customers are encouraged to review this information, follow precautions and comply with laws and regulations concerning product use and disposal.

To obtain a MSDS for this product, visit:  
[www.chevronlubricants.com](http://www.chevronlubricants.com).



## Aquatex® 3380

### Service considerations

#### System Cleaning

For top performance, thoroughly clean the system to remove residues, machining debris/fines, bio-accumulations, etc., from previously used products. For further information, please contact your local Chevron Technical Manager.

#### Emulsion Preparation

A minimum of two-thirds of water to be used in the emulsion should be charged (at room temperature) into a separate mixing vessel. Slowly add the amount of oil required to obtain the correct emulsion concentration, with thorough mixing. Remember O I L (Oil In Last) to avoid forming an invert emulsion and, where possible, use automatic mixers. Chevron Soluble Oils are formulated to be compatible with water up to 300 mg/L hardness. For best results, water of low hardness should be used in emulsion preparation and make-up. Hard water tends to deplete the emulsifiers, resulting in surface scum and soap formation over extended periods of time.

#### Monitor Emulsion Regularly

Service life may be greatly extended through the use of good fluid monitoring practices. Check emulsion strength regularly, always premixing emulsion prior to adding to system. Where possible, adjust concentrate by adding pre-mixed emulsion of suitable concentration. Pre-mixed Aquatex 3380 emulsion should only be added to the system where there is adequate fluid movement for thorough mixing, and never directly before the filter. The pH should be periodically checked and maintained within the range of 8.5 to 9.5. Maintenance of correct emulsion strength is generally sufficient to maintain the pH. Checking for bacterial/fungal growth should be carried out using bacteria/fungi dip slides or other suitable test kits.

#### Remove Tramp Oil and Other Contaminants

Elimination of tramp oil and other contaminants is essential to prolonging emulsion life. Since the presence of tramp oils provides nutrients for bacterial growth, any tramp oil should be periodically skimmed from sumps and reservoirs. Foreign materials such as machining debris and fines should be periodically removed by filtration or other suitable means.

#### Handling Practices

It is recommended that Aquatex 3380 be stored indoors at room temperature to protect against the effects of temperature extremes. Aquatex 3380 should never be stored at temperatures below 4°C for extended periods, since low temperature storage conditions may lead to stratification and/or layering of components. If outdoor storage is necessary and separation is observed, the product can usually be reconstituted by agitation to remix the ingredients. Overheating of the product may result in removal of water and/or coupling agents, which will adversely affect the balance of ingredients and make the product unusable.

In addition, extreme care should be taken to prevent the oil from becoming contaminated during storage. Any contaminants could have very unfavorable effects on the emulsification and performance characteristics of the product. .

This bulletin was prepared in good faith from the best information available at the time of issue. While the values and characteristics are considered representative, some variation, not affecting performance, can be expected. It is the responsibility of the user to ensure that the products are used in the applications for which they are intended.

Produced by:  
**Chevron Lubricants**  
– Asia Pacific