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(54) Title: NOVEL WATER SOLUBLE METAL WORKING FLUIDS

(57) Abstract

This invention relates to novel water soluble metal working fluid compositions, their use to work metal, a process for working metal using such compositions and the metal worked article of manufacture. More particularly, this invention relates to fluid compositions useful in cutting, grinding, shaping and other metal working operations which require a lubricant. The terms "first Group A" and "second Group B" are used herein to denote different groups and not to indicate any sequence of use or selection as any possible combination or sequence of use of a component(s) is envisioned without limit of any kind. The disclosed fluid compositions are also anticorrosive and environmentally more acceptable than current oil based fluids. There has now been discovered an essentially odorless, substantially non-oil misting, water-soluble metal working fluid comprising at least one component selected from a first Group A herein and optionally one or more components selected from a second Group B herein preferably with the balance of the composition being water and other (optional) minor ingredients. When a component is employed from Group A and a component is employed from Group B the action of the combination generally enhances performance of the resulting combination with contain moieties from both Group A and Group B.