

SOLUBLE CUTTING OIL

DESCRIPTION

SOLUBLE CUTTING OIL is formulated from high quality base oils and combination of passive and extreme pressure additive package especially developed for cutting oils used in severe operations. This cutting oil is extremely effective by providing rust and corrosion protection of parts, cutting tools, and the machine.

APPLICATIONS

SOLUBLE CUTTING OIL is multipurpose, neat cutting oil for turning, milling, reaming, drilling, shaping, broaching of a wide variety of metals. It has outstanding emulsion stability and readily mixes with water. It is recommended at 10:1 up to 20:1 water oil dilution for milling, boring and turning and 40:1 for grinding. The emulsion is prepared by adding oil to water and not vice versa. It is non-staining and can be used on both ferrous and non-ferrous metals.

BENEFITS

- Gives excellent surface finish on parts.
- Good oxidation stability.
- Corrosion and rust protection of parts and machine.
- Excellent cooling properties that avoid overheating of parts and chips in machining operation.
- Reduce tool wear.
- Helps prevent varnish and sludge formation.
- Non-staining to ferrous and non-ferrous metals.
- Increase tool life and faster machining.

PRODUCT TYPICAL CHARACTERISTICS

PROPERTIES		UNITS	VALUE	TEST METHOD
Grade		-	68	-
Specific Gravity	@ 15°C	-	0.8950	ASTM D-1298
Viscosity	@ 40°C	mm ² /s	67.50	ASTM D-445
Corrosion			0/1-1	IP- 125
Color		-	3.0	ASTM D-1500
Emulsion Stability (400 ppm) - oil		ml	NIL	IP-263
Emulsion Stability (400 ppm) - cream		ml	NIL	IP-263
Rust Prevention Breakpoint		-	20:1	IP-287
Ph of Emulsion (20:1)		-	9.30	ASTM D-1287