

NON - CORROSIVE STRAIGHT CUTTING OILS**IPOL ST CUT 14 H, 14P2SC, 14P4SC****Description:**

Metal removal by machining is the most common process used in the metal working industry.

Ferrous and non-ferrous metals and their alloys are machined to close tolerance by using straight cutting oils.

Non-corrosive straight cutting oils can be universally used for all types of machining operations of a less severe nature.

Salient Features:

IPOL ST CUT 14H/ 14P2SC / 14P4SC are formulated with refined neutral oils and specially selected oiliness additives to impart superior cooling ability and provide a fine finish. .

Application:

IPOL ST Cut 14H is used where non-staining of surfaces is of prime importance machining all types of moderate operations.

IPOL ST Cut 14P2SC - It meets IS 3065-1985 type I, Grade II - specification. Suitable for multiple operations involving severe grinding process.

IPOL ST Cut 14P4SC is a general purpose neat cutting oil suitable for automats used for precision machining in antifriction bearing manufacturing industry.

Product Data

Benefits:

- Single product can perform over a wide range of requirements.
- Superior metal wetability characteristics improving cooling.
- Do not evolve obnoxious fumes.
- Helps in product consolidation.

Typical Results :

Characteristics	Test Methods IS 1448	Result		
		ST Cut 14H	ST Cut 14P2SC	ST Cut 14P4SC
Appearance	Visual	Bright & Clear		
Density @ 15°C	ASTM D 1298	0.858*	0.89	0.88*
Flash Point COC°C	P-69	130	160	130
Pour Point °C	P-10	+ 6	+ 6	0
Viscosity cSt at 40°C	P-25	9-10	23	20/24
Saponification value % mgm KOH/gm	P-55	--	10	--
EP Weld Load Kg	ASTM D 2783	--	126	126

The above data is typical & does not constitute a specification. The information provided is not to be taken as a warranty or representation for which we assume no legal responsibility, nor as permission or recommendation to practice any attended location or otherwise. It is solely offered for your consideration, investigation and verification.

Spltech/05-01(a)/0110
Page 2 of 2