

Non Corrosive Straight Cutting Oil

IPOL ST CUT 14P3SC

Description:

Metal removal by machining is the most common process used in the metal working industry for manufacture of machine parts. Non-corrosive straight cutting oils are universally used for machining Ferrous and Non-ferrous metals where staining type of oils cannot be used. These oils are suitable for a wide range of machining operations of a less severe nature.

Salient Features:

IPOL ST Cut 14P3SC is a non-staining type of a neat cutting oil, blended with medium viscosity, high VI base oils and EP additives for providing antiweld and oiliness characteristics.

It meets requirements of BIS-3065-1985, type 2 Grade III.

Application:

- Suitable for multiple operations involving severe metal grinding processes like flute grinding of drills, Reamers and other Form-grinding Tools.
- For Ferrous and Non ferrous stocks, gives excellent results on multi-spindle automatics.
- Equally satisfactory for cuprous metals or steels.

Benefits:

- Consistently gives high surface finish and dimensional accuracy.
- Do not dis-colour the components.
- Versatile product which can be used in many machining operations.
- Increased tool life and overall economy of the operation.

Product Data

Typical Results: IPOL ST Cut 14P3SC

| Characteristics | Test Methods IS 1448 | Results |
|-------------------------------|-------------------------|----------------|
| Appearance | Visual | Bright & Clear |
| Specific Gravity @ 30°C | P:32 | 0.860 |
| Viscosity cSt @ 40°C | P:25 | 30/45 |
| Flash Point (coc)° C | P:69 | 160 |
| Pour Point °C | P:10 | +6 |
| Saponification value | P:55 | 5.5 |
| Four ball EP Weld Load Kg. | ASTM D 2783 | 126 |

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