

CUTTING OIL 103 X

Description:

IPOL ST Cut BR Grades are active type neat cutting oils and contain medium viscosity, low pour and high flash base oils with suitable EP additives.

These oils have fatty additives, which improves oiliness property providing better surface finish. They ensure protection to the cutting tool over a wide range of operating temperature.

Salient Features / Performance Standards

Meets IS : 3065 - 1985 (Reaffirmed 1995) Type III Grade 2

Application:

- IPOL ST Cut BR 103, BR 103X are recommended for most of the cutting operation on ferrous metal under severe operating conditions.
- They are ideally suited for multi spindle automats, multi tool lathes in machining, of high tensile stainless steel as well as Ni-Cr alloys.
- The use of these oils for cutting operation on Non-ferrous metal should be avoided.

Benefits:

- By virtue of its excellent lubricity, protects the tool edges over a wide range of temperature.
- Good oiliness property improves surface finish.
- Enables machining of tough, ductile steels in severe operations.
- Suitable for rationalizing the variety of neat cutting oils in use.
- Better swarf removal due to high detergency.
- Achievers over all economy of the operations.

Product Data

Typical Results: IPOL ST Cut BR Oils

Characteristics	Test Methods IS 1448	Results	
		BR - 103	BR - 103X
Colour	ASTM D 1500	2.0	L 2.5
Appearance	Visual	Pinkish	Yellow
Sp. Graity @ 30°C	ASTM D 1298	0.852	0.869
Flash Point COC°C	P-69	196	196
Pour Point °C	P-10	(-)9	L -6
Viscosity cSt at 40°C	P-25	20 - 25	30 - 34
Copper Corrosion	P-15	4C	4C
EP Weld Load Kgs.	ASTM D 2783	180	180

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