

GUN DRILLING OIL 1 - FOR FERROUS METALS

Description:

Gun drilling is also known as deep drilling, involves drilling of holes to a depth some times exceeding 200 to 300 times the hole-dia.

The quality of the cutting fluid is of great importance since it not only removes the metal chips but also has to provide adequate lubrication to the tool cutting edges, as the tool travel-speed sometimes exceeds 200 mm per minute.

It is very essential for these fluids, to use the right viscosity coolant to ensure good flushing action for the swarf and to maintain the high viscosity flow of the fluid.

Salient Features:

- Formulated with specially selected mineral oils.
- The additive packages are such that they impart adequate EP and Polar characteristics to the lubricant.
- Low viscosity and consequent higher thermal conductivity.
- Ensures better job finish and prolonged tool life.

Application:

- Ideally suited for gun-drilling systems, and boring operations.
- Can also work for hobbing and gear shaving operations.
- Recommended specially for drilling in ferrous Metals.

Benefits:

- Excellent Cooling properties
- Improved tool life
- High surface finish
- Minimum power consumption
- Higher dimensional accuracy

Product Data

Typical Results: IPOL Gun Drilling oil No. 1

Characteristics	Test Methods IS 1448	Results
Appearance	Visual	Bright & Clear
Odour	Smell	Acceptable
Sp. Gravity @ 30°C	ASTM D 1298	0.859
Viscosity cSt at 40°C	P-25	10.5 - 12.0
Flash Point COC °C	P-69	146
Pour Point °C	P-10	L -9
Chlorine % Wt.	P-50	Nil

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