

## DIVYOL BROACHING OILS – NO. 1 / M

### Applications:

Divyol Broaching Oils No.1 and M are specially formulated blends of highly refined mineral oil base stocks, chlorine, fat and sulphur as extreme pressure additives. These oils act chemically at elevated temperatures forming a solid metallic film, while simultaneous cooling imparts a surface finish to the component. The robustness of Divyol Broaching Oil makes it ideal for use in cutting operations where extreme lubrication is required, especially in broaching and gear cutting of steel, stainless steels and nickel alloys. It is suitable also for broaching of medium carbon steel of automotive components as well as shaving and gear cutting operation where anti-chip welding properties are most essential.

### Advantages:

Divyol Broaching Oils No.1 and M have a high flash point ensuring greater operator safety with zero health hazards. Their unique combination of light bodied base oils and select additives gives the oils excellent EP resistance. These qualities result in excellent heat dissipation, quick chip flush out, smooth polished surfaces of finished components and longer service life of broaches. They cover most of product application range and prove to be reliable and economical in usage requiring minimum top-up.

### Typical properties:

Sr. No.	Characteristics	Test Method	Divyol Broaching Oils	
			No. 1	M
1	Appearance	Visual	Bright and clear	Bright and clear
2	Flash point COC, °C, min.	ASTM D 92	175	170
3	Kinematic viscosity at 40 °C, cSt , min.	ASTM D 445	17.5	17.9
4	Chlorine	IS:1448 P:50	Yes	Yes
5	Sulphur	-	Yes	Yes
6	Fats	-	Yes	Yes
7	Saponification value mg KOH/g	IS:1448 P:55	3.5	3.5
8	Cu Corrosion at 100 °C, 3 hrs.	IS:448 P:15	4c	4c
9	4 Ball, EP weld load, kg	ASTM D 2783	1200	1200

The above properties are typical values and do not constitute specification of the product.

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