

## DIVYOL NEAT CUTTING OILS – ST CUT 52 / 53 / 54 / 55 / 67

### Applications:

Divyol ST Cut 52, 53, 54, 55 and 67 are a premium series of oil formulated with select refined base oils and a combination of high performance additives comprising sulphur, fat and performance chemicals. These oils are designed for lubrication and cooling of metal surfaces in severe operating condition on tough ferrous metals. They are recommended for most metal working operations, e.g. gear cutting, broaching and threading on ferrous metals and alloys, except on non-ferrous and cuprous metals.

### Standards:

Divyol ST Cut of grades 52, 53, 54, 55 and 67 conform to IS: 3065: 1985 type 3 Grade III performance standards.

### Advantages:

Divyol ST Cut of grades 52, 53, 54, 55 and 67 have proven to be excellent general purpose straight cutting oils with a satisfactory performance over a wide range of machine tool speeds and cutting depths. Their high weld load properties enable machining under the most arduous metal working operations on tough ferrous metals, resulting in longer service life of cutting tools.

They impart an excellent surface finish on worked metal components. They cause very low active sulphur drop-outs, leading to sustained EP properties. They are cost-effective in operations, helping to reduce maintenance costs, which in turn has made them industry favourites and reduced the number of cutting oil grades in use.

### Typical properties:

Sr. No.	Characteristics	Test Method	Divyol ST Cut				
			52	53	54	55	67
1	Colour, max.	ASTM D 1500	2.0	4.0	4.0	4.0	5.0
2	Appearance	Visual	Bright and clear	Bright and clear	Bright and clear	Bright and clear	Bright and clear
3	Flash point, COC, °C, min.	ASTM D 92	165	180	180	180	180
4	Pour point, °C, max.	ASTM D 1500	-3	-3	-3	-3	-3
5	Kinematic viscosity at 40 °C, cSt min.	ASTM D 445	24.0	30 – 38	35	36 – 40	62 – 74
6	Copper strip corrosion 3 hrs. at 100 °C, max.	ASTM D 130	4	4	4	3	3
7	EP weld load kg	–	800	800	800	800	800

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

Disclaimer: Gandhar makes no warranties, representation or conditions of any kind expressed or implied for use with respect to these products. Final determination of suitability of the product for the application contemplated by the users is solely their responsibility.