

DIVYOL SOLUBLE CUTTING COOLANT – BIOSYNTH G1000 / G2000 / G3000

Applications:

Divyol Biosynth G1000, G2000 and G3000 are specially formulated semi-synthetic cutting oils for ferrous, non-ferrous and alloy metals. These coolants are suitable for turning, milling, grinding and various other operations involving cast iron, especially for grinding ferrous metals.

Divyol Biosynth G2000 and G3000 are recommended for all types of coolant systems except high pressure ones like VMC.

While using Divyol Biosynth G1000, water hardness must be maintained at above 100 ppm.

Clean system essential: before introducing any grade of Divyol Biosynth into a new system, the system should be thoroughly cleaned of all impurities and flushed with a mixture of 80% water and 20% Divyol Biosynth of the same grade.

Advantages:

Divyol Biosynth has the added advantage of operator safety compared to conventional mineral oil-based cutting oils. If the operator's hand comes in contact with the fluid, it causes no itching. Being a synthetic blend, it also resists bacterial degradation, prevents rusting (especially on ferrous components) and ensures stable emulsion for a reasonably long period. There is no unpleasant odour or discoloration of the emulsion. Its mild EP properties enable superior surface finish, whereas mineral based products have been found wanting due to inadequate flushing. Being nitrite free, they are also eco-friendly.

Typical properties:

Sr. No.	Characteristics	Test Method	Divyol Biosynth		
			G 1000	G 2000	G 3000
1	Appearance	Visual	Bright and clear	Bright and clear	Bright and clear
2	Colour	ASTM D 1500	Greenish	Greenish	Greenish
3	Kinematic viscosity at 40 °C, cSt min.	ASTM D 445	25 – 60	50.00	45.00
4	PH 3% solution in T/W	ASTM D	9.12	9.00	9.00
5	Cast iron corrosion	IP:125	Complies	Complies	Complies
6	Emulsion stability 3% solution	ASTM D 1479	Complies	Complies	Complies

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

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