

DIVYOL SOLUBLE CUTTING OILS – CUT 200 / 300 / 400 / 500 / 800 / 1000

Applications:

Divyol Soluble Cutting Oils of grades 200, 300, 400, 500, 800 and 1000 are specially formulated for working on ferrous materials. These blends can be used in severe operations like turning, drilling, milling etc. Of these Divyol Cut 800 and Divyol Cut 1000 can be used in water of 800 and 1000 ppm hardness. The emulsions are to be prepared by adding oil to water and not vice-versa. It is advisable to prepare the emulsions just before use or not later than the same day.

Standards:

Divyol Soluble Cutting Oils are blended with select bactericides and conform to IS:1115-1986 performance specifications.

Advantages:

Divyol Soluble Cutting Oil prevents rusting of the work piece and machine tool beds, thereby extending their service life. The blend's bactericidal additives ensure a stable emulsion for a reasonable duration. It also imparts good surface finish to the work piece. It causes no foaming or staining and is operator-friendly.

Typical properties:

Sr. No.	Characteristics	Test Method	Divyol Soluble Cutting Oils					
			Cut 200	Cut 300	Cut 400	Cut 500	Cut 800	Cut 1000
1	Appearance	Visual	Bright and clear	Bright and clear	Bright and clear	Bright and clear	Bright and clear	Bright and clear
2	Kinematic viscosity at 40 °C, cSt, min.	ASTM D 445	20	20	20	20	25	25
3	Copper corrosion at 100 °C for 3 hrs.	ASTM D 130	1a	1a	1a	1a	1a	1a
4	Cast iron corrosion	IP:125	Complies	Complies	Complies	Complies	Complies	Complies
5	Emulsion stability and frothing	ASTM D 1479	Complies	Complies	Complies	Complies	Complies	Complies

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

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