

PRODUCT DATA SHEET



SOLUBLE CUTTING OILS

PALKUT - SL

This is premium quality water soluble cutting oil, specially developed to form extremely stable milky emulsion even with extreme hard water (400 ppm) leading to excellent tool life and finish, in all metal cutting operations, where cooling is more important than lubrication. It has excellent antirust and anti-froth quality and cause no corrosion of machine, work piece or tool. Do not decompose chemically; leave objectionable odour, cause discoloration and staining. This is operator friendly and economical in use.

PALKUT - SL is blended from refined mineral oil, emulsifier and other additives.

Procedure:

- ❖ Dilution ratio with water varies between 5%to10% depending on severity of machining.
- ❖ While preparing emulsion always add cutting oil to water (not the other way round) to prevent inversion of the emulsion.
- ❖ Clean the coolant reservoir and system periodically, recharge the system with 1% solution of coolant to be charged and circulate for at least 1 hr. and then drain completely.
- ❖ Check the emulsion strength regularly and top up if necessary.

PERFORMANCE LEVEL: IS 1115-1986 specifications.

CHARACTERISTICS		
S. NO.	PROPERTIES	PALKUT SL
1.	Kinematic Viscosity cSt @40°C, min.	20
2.	Flash Point COC, °C, min.	150
3.	Copper Strip Corrosion Properties	Passes
4.	Cast Iron Corrosion Properties	Passes
5.	pH 5% emulsion in D/W	8-9
6.	Emulsion Stability (for 24 hrs.) 5% in tap water 5% in 400ppm water	Stable Stable
7.	Heat Stability Properties (at 0°C to 5°C)	Passes
8.	Volatile Matter @100°C for 16 hrs. % by mass, max.	20

* The specifications are subject to variations/ development / customization.

PACKING: 210L, 50L, 20L