

Product Data Sheet

SERVOCUT 353

Premium Neat Cutting Oil



Description

Servocut 353 is a low viscosity sulphur-chlorinated type cutting oil. Its selected additives impart antiweld properties, which help machining of intricate shapes with high precision. Being a low viscosity product, it has excellent cooling and quick swarf removal characteristics.

Performance, Features and Benefits

- Caters for more arduous machining of tough ferrous and ferrous alloys.
- Gives high precision on long work cycle operations.
- Provides effective flushing of fine swarf.
- Ensures faster cooling of tool and work piece.
- Has minimum rust forming tendency when used in high pressure coolant feed systems.
- Has minimum misting tendency when use in high pressure coolant feed systems.
- Assists in achieving high rate of production.
- Has low sludging tendency to give optimum filter life.
- Helps achieve longer tool life.

Application

Servocut 353 is recommended for deep hole boring and deep hole drilling of ferrous and ferrous alloys. It gives excellent finish, because of balanced combination of fat, chlorine and active sulphur, under continuous and long work cycle. It is also suitable for certain honing operations.

This product is not recommended for machining of non-ferrous metals.

Typical Physical Characteristics

| Parameters | Method | Value |
|----------------------------------|------------|-------|
| Appearance | Visual | Clear |
| Colour | ASTM D1500 | 2.0 |
| Density @ 29.5 °C, gm/ml | ASTM D1298 | 0.862 |
| Flash point COC, °C | ASTM D92 | 156 |
| Pour Point, °C | ASTM D97 | 0 |
| Kinematic viscosity at 40°C, cSt | ASTM D445 | 11.5 |
| Total Acid Number, mg KOH/g | ASTM D64 | 4.0 |
| Ca % Wt | IP-111 | 0.23 |
| Zn % | IP-117 | 0.18 |

Health, Safety & Environment

Based on available information, this product is not expected to produce adverse effects on health when used for the intended application and the recommendations provided in the Material Safety Data Sheet (MSDS) are followed. MSDS's are available upon request through your sales contract office, or at <https://cx.indianoil.in/>. This product should not be used for purposes other than its intended use. If disposing of used product, take care to protect the environment.

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