

Product Data Sheet

SERVO CUT 253

Neat Cutting Oil



Description

Servocut 253 is specially formulated product to be used for deep hole boring and trepanning operations, where pressurized coolant system is employed for easy swarf removal.

It has been formulated using carefully selected high viscosity index base oils and contains special fatty material and active Sulphur in solution. The product has pleasant red colour.

Performance, Features and Benefits

- Helps in continuous accurate cutting in long work cycle operation
- Has minimum mist forming tendency when used in high pressure coolant feed systems
- Provided effective cooling and flushing necessary in deep hole drilling operations
- Ensures good surface finish
- Optimizes filter life due to low sludging tendency at operating temperature
- Gives better tool life

Application

Servocut 253 is recommended for:

- Deep hole drilling including gun drilling operations
- Trepanning operations
- Boring operations

This product is not recommended for operation on non-ferrous metals.

Typical Physical Characteristics

	Method	Servocut 253
Appearance at 30 °C	Visual	Clear red liquid
Density at 29.5 °C. g/ml	ASTM D 4052	0.836
Kinematic viscosity at 40°C, cS t	ASTM D-445	13.5
Flash point COC , °C	ASTM D-92	200
Pour Point, °C	ASTM D-97	(-)6
Copper strip corrosion at 100°C for 3hrs	ASTM D-130	4
Total Acid Number, mg KOH/gm	ASTM D- 664	0.2
Four ball weld load, Kg	IP 239	700

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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