

Product Data Sheet

SERVO CUT 945 & 945 A

Neat Cutting Oil



Description

Servocut 945 & 945 A are active type neat cutting oils. Servocut 945 A contains higher dosage of fatty material which improves oiliness property thus providing better surface finish.

Sulphur incorporated in these oils become chemically active at the tool-work piece-chip interface and ensures protection to the cutting tool over a wide range of operating temperatures.

Performance, Features and Benefits

- Provides continuous protection to tool edges over a wide range of operating temperatures.
- Helps in improved surface finish due to the added oiliness property.
- Enables machining of tough, ductile steels in severe operations.
- Prevents localized welding between the chip and tool.
- Keeps at minimum oil drag-out losses on components and swarf.

Application

Servocut 945 and 945 A are recommended for most of the cutting operations on ferrous metals under severe operating conditions, which demand high degree of chemical activity in oils. These oils are suitable for machining operations on high tensile stainless steel as well as Ni-Cr alloys by automatics, gear cutting, hobbing, drilling, reaming and thread cutting machines. To obtain best results with the use of these products, it is necessary that a copious flow of oil at low pressure is maintained at the cutting area.

The use of Servocut 945/945 A for cutting operation on non-ferrous metals and its contact with soft metal in machines should be avoided.

Approvals / Performance Standards / Recommendations

- Meets IS: 3065-1985 (Reaffirmed 2018) Type 3 Grade II.

Typical Physical Characteristics

	Method	Servocut 945	Servocut 945A
Appearance at 25/30 °C	Visual	Clear brown liquid	Clear liquid
Density at 29.5 °C, g/ml	ASTM D 4052	0.867	0.868
Kinematic viscosity at 40°C, cS t	ASTM D 445	28.3	28.02
Flash point COC , °C	ASTM D 92	217	188
Pour Point, °C	ASTM D 97	(-) 9	(-) 3
Copper strip corrosion at 100°C for 3hrs	ASTM D 130	4	4
Saponification No value, mgKOH/g	ASTM D 94	-	19.5
Four ball weld load, Kg	IP 239	600	600

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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