

Product Data Sheet

SERVOCUT SPECIAL

Cutting Oil



Description

Servocut Special is a long life, bio-stable, EP (Extreme Pressure) type water miscible high performance cutting fluid having higher oil content. It contains optimised dosages of chlorine additive and is free from boron, nitrite, etc.

It is a versatile cutting fluid suitable for machining of low carbon & alloy steel, yellow metal alloys

Performance, Features and Benefits

- Stable emulsion providing longer sump life with water hardness upto 250 ppm as CaCO_3
- Excellent protection against bacterial growth
- Superior cooling characteristics
- High EP property for enhanced tool life
- Excellent surface finishing
- Lower oil consumption
- Suitable for ferrous and non-ferrous (Cu) applications
- Excellent antirust and corrosion protection properties for ferrous, Cu and its alloys
- Operator friendliness, when used in recommended dilution range

Application

Servocut Special is recommended for use in the cutting operations on nonferrous and ferrous metals in a water-mix form at concentration level of 4-8 (% v/v).

It is especially recommended for machining applications of low carbon steel, yellow metal alloys. It is not suitable for cast iron based workpiece.

Approvals / Performance Standards / Recommendations

Servocut Special provides excellent performance in milling, turning, drilling, boring, grooving, thread cutting & forming etc. cutting applications for ferrous and non-ferrous alloys based components in various industries like automotive ancillary, automotive plants, industrial machining etc.

Typical Physical Characteristics

	Method	Servocut Special
Appearance at 30 °C	Visual	Clear brown liquid
Density at 29.5 °C, g/ml	ASTM D-4052	0.954
Kinematic viscosity at 40 °C, cSt	ASTM D-445	70
Copper Strip Corrosion at 100 °C, 3 hrs	ASTM D-130	1
pH of 5.0% (v/v) oil in distilled water	pH Meter	9.3
Emulsion test at 20:1 & 5:1 dilution in water of 400 ppm hardness as CaCO_3 – oil / cream, ml	P: 98	Nil/Traces
Cast Iron Corrosion Test at 20:1 dilution in water of 400 ppm hardness as CaCO_3	IS: 1115-86 App. A	0/0-0
Frothing Test at 20:1 dilution in water of 200 ppm hardness as CaCO_3	P: 99	Pass

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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