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## **CONTOL GENERAL PURPOSE SOLUBLE CUTTING OIL**

### **Description**

These are premium quality water soluble cutting oils, specially developed to form extremely stable milky emulsion with water of normal hardness leading to excellent tool life and finish, in all metal cutting operations, where cooling is more important than lubrication. They have excellent antirust and antifroth quality and causes no corrosion of machine, work piece or tool. It does not decompose chemically; leave objectionable odor, cause discoloration and staining. These are operator friendly and economical in use, blended from refined mineral oil, emulsifier and other additives are fortified with performance additives to suit wider range of metalworking operations. It has long service life even in hard water up to 600 ppm, provides better lubricity and anti wear properties.

### **Application**

Contol General Purpose Soluble Cutting Oil is recommended for cutting, drilling, shaping, and other metal removal operations of ferrous and non-ferrous materials where high quality of coolant is required. Not recommended for the machining of Magnesium due to potential fire hazards.

### **Procedure :**

- 1) Dilution ratio with water varies between 5% to 10% and 2% to 4% for soluble cutting oil respectively depending on severity of machining.
- 2) While preparing emulsion always add cutting oil to water (not the other way round) to prevent inversion of the emulsion.
- 3) Clean the coolant reservoir and system periodically, recharge the system with 1% solution of coolant to the charges and circulate for at least 1 Hr. and then drain completely.
- 4) Check the emulsion strength regularly and top up if necessary.

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### Specification/Performance Level

IS 1115-1986 specifications.

### Typical Properties

Sr.No.	Properties	Soluble Cutting Oil
1.	Kinematic Viscosity cSt @40Deg.C, min.	25-45
2.	Flash Point COC, Deg.C, min.	135
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	Stable
	5% in 400 ppm water	Stable
7.	Heat stability properties (at 0 to 5 Deg.C)	Passes
8.	Volatile Matter @100 Deg.C for 16 Hrs. % mass, max.	20