

PRODUCT DATA SHEET



SOLUBLE CUTTING OILS

PALKUT - SL, SL SUPER

These are premium quality water soluble cutting oils, specially developed to form extremely stable milky emulsion even with extreme hard water (400 ppm) leading to excellent tool life and finish, in all metal cutting operations, where cooling is more important than lubrication. They have excellent antirust and anti-froth quality and cause no corrosion of machine, work piece or tool. They do not decompose chemically; leave objectionable odour, cause discoloration and staining. These are operator friendly and economical in use.

PALKUT - SL is blended from refined mineral oil, emulsifier and other additives.

PALKUT - SL SUPER is fortified with EP additive to suit wider range of metalworking operations. It has long service life even in hard water up to 600ppm, provides better lubricity and anti-wear properties.

Recommended for cutting, drilling, shaping, grinding, 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:

- ❖ Dilution ratio with water varies between 5%to10% and 2%to4% for PALKUT SL&SL SUPER respectively depending on severity of machining.
- ❖ While preparing emulsion always add cutting oil to water (not the other way round) to prevent inversion of the emulsion.
- ❖ Clean the coolant reservoir and system periodically, recharge the system with 1% solution of coolant to be charged and circulate for at least 1 hr. and then drain completely.
- ❖ Check the emulsion strength regularly and top up if necessary.

PERFORMANCE LEVEL: IS 1115-1986 specifications.

CHARACTERISTICS			
S. NO.	PROPERTIES	PALKUT SL	PALKUT SL SUPER
1.	Kinematic Viscosity cSt @40°C, min.	20-30	20-30
2.	Flash Point COC, °C, min.	150	150
3.	Copper Strip Corrosion Properties	Passes	Passes
4.	Cast Iron Corrosion Properties	Passes	Passes
5.	pH 5% emulsion in D/W	8-9	8-9
6.	Emulsion Stability (for 24 hrs.) 5% in tap water 5% in 400ppm water	Stable Stable	Stable Stable
7.	Heat Stability Properties (at 0°C to 5°C)	Passes	Passes
8.	Volatile Matter @100°C for 16 hrs. % by mass, max.	20	20

* The specifications are subject to variations/ development / customization.

PACKING: 210L, 50L, 20L