



For total industrial lubricant solutions



# Soluble Cutting Oil

## CUTVEL S

IS:1115 - 1986 (RA 2002)

### Product Data Sheet

**PRODUCT DESCRIPTION:** CUTVEL S is a MULTI-PURPOSE SOLUBLE CUTTING OIL manufactured from carefully selected paraffinic base oils and proprietary emulsifiers which have a bearing on the stability of the emulsion even with water of 400 ppm hardness. A stable milky white emulsion is prepared by adding the oil to water with continuous stirring. CUTVEL S gives the desired cooling characteristics, provides rust protection, lubricity for the cutting operation with good finish of work piece and longer life for tools. CUTVEL S is also fortified with appropriate biocides to keep control of bacterial growth.

**APPLICATION:** CUTVEL S is recommended for a variety of cutting operations on both ferrous and non-ferrous metals. For general machining operations the emulsion is normally prepared with 5% oil and for grinding operation the emulsion has 2% of oil.

**CAUTION :** Not recommended for machining of magnesium as fine chips of magnesium is a fire hazard when moistened with water.

**PERFORMANCE LEVEL:** Meets IS 1115-1986 (RA 2002).

### Typical Properties

CHARACTERISTICS	CUTVEL S
Water, % mass, Max.	10.0
Copper strip corrosion at 100°C for 3 Hrs, Max.	1 (a)
Emulsion Stability Test ,5:1 and 20:1 ratio in water of 400 ppm hardness	Passes
Thermal stability Test	Passes
Ash, % by mass, Max.	3.5
Frothing Test , 5:1 and 20:1 ratio in water of 200 ppm	Passes
Flash Point,COC,°C, Min.	150
Cast Iron corrosion test	0/1-1

These are typical figures and do not constitute a specification. In pursuit of continuous improvement, these figures may be changed without notice at the sole discretion of Nandan Petrochem Ltd.

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