



For total industrial lubricant solutions



# Soluble Cutting Oil

## Cutvel S Plus

IS: 1115-1986 (RA 2002)

### Product Data Sheet

**DESCRIPTION:** CUTVEL S PLUS is a PREMIUM SOLUBLE CUTTING OIL manufactured from carefully selected paraffinic base oils and proprietary emulsifiers which have a bearing on the stability of long lasting emulsion even with water of 400 ppm hardness.

CUTVEL S PLUS gives the desired cooling characteristics and effective foam control, provides rust and corrosion protections with required lubricity for the cutting operations with good finish of work pieces and longer life for tools. CUTVEL S PLUS is also fortified with appropriate biocides to keep control of bacterial growth even during machine shutdown period.

A stable milky white emulsion is prepared by adding the oil to water, with continuous stirring

**APPLICATION:** CUTVEL S PLUS 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) performance requirements.

### Typical Properties

CHARACTERISTICS	CUTVEL S PLUS
Emulsion Stability & Frothing	Passes
Copper Strip Corrosion at 100°C for 3 hours	1a
Cast Iron Corrosion Test	0/1-1
Thermal stability Test	Passes
Flash Point,COC,°C, Min.	150
pH of 5% emulsion	9.2 (Typical)