

Product Data Sheet

IPOL St Cut 55

Neat cutting oil for hobbing, shaving & threading operation

Description:

IPOL St Cut 55 is active type neat cutting oil containing lubrication additives along with extreme pressure additives blended with high quality base oil for hobbing & threading operation.

Special sulphur & EP additive chemistry used in this product gets chemically active at the tool-work piece-chip interface & ensure protection to the cutting tool over a wide range of operating temperature in operation.

Salient Features:

Blended with high performance mineral oil stocks with special active sulphur & EP additives. Special chemistry of additives used in the product make it very effective over wide range of temperatures with excellent surface finish.

Performance Standard: IS 3065 – 1985 (Reaffirmed 1995) Type III Grade.2

Benefits:

- Continuous protection to tool edges over a wide range of operating temperature.
- Support in improved surface finish due to the added lubricity additives.
- Higher EP load prevent localized welding between the tool & chip.
- Long tool life and least down time.
- Enable machining of tough alloy steel.
- Specially selected base oil minimize the drag out losses on components & swarf.
- Help to economize on machining operations.

Application:

- This oil recommended for most of the cutting operations on the ferrous metals under sever conditions which demand for high degree of superior extreme pressure chemistry in product.
- This product is suitable for gear hobbing, shaving, drilling, reaming & thread cutting operation on high tensile steels & alloys.
- Not recommended on yellow metals.

Characteristics

Properties	Test method	Typical Test Values
Color	ASTM D 1500	2.5
Appearance	Visual	Bright and Clear
Sp. Gravity @ 30 °C	ASTM D1298	0.887
Kin Viscosity @ 40 C, cSt	ASTM D 445	31
Flash Point (COC) in °C	ASTM D92	185
Pour Point, °C	ASTM D 97	0
Cu-Corrosion Test [120°C/01 Hrs.]	ASTM D830	4 A
Foam Test [Seq.-I]	ASTM D 1401	20 ml/10sec
Weld Load	ASTM D-2783	400 KG
Sulphur	Qualitative	Positive
Chlorine	Qualitative	Positive

The above data is typical & does not constitute a specification. The information provided is not to be taken as a warranty or representation for which we assume no legal responsibility, nor as permission or recommendation to practice any attended location or otherwise. It is solely offered for your consideration, investigation and verification.

Storage and Packaging

IPOL ST CUT 55 can be supplied either in 210 liter non-returnable HDPE/ Steel drums or in bulk.

The product should be preferably stored indoors in dry conditions and protected from extreme temperatures. In case the drums are stored outside, adequate precaution needs to be taken to cover them for avoiding any rain water contamination.