

Product Data Sheet

IPOL Broaching Oil No.1

Heavy duty neat broaching oil

Description:

IPOL Broaching Oil No.1 is formulated with chlorine, fat & sulphur as extreme pressure additives. These additives react chemically at elevated temperature forming solid metallic film. This helps in extending broach life & provides improved surface finish to component.

This is a robust product & successfully used in machine shops where extreme lubrication qualities are required in cutting operation. These broaching oils are even suitable for the machining of hardest material possible.

Salient Features:

Blend of specially selected light bodied base oils and additives to withstand extreme pressures.

- Offers enhanced cooling and smooth polished surfaces.
- High flash point and excellent EP characteristics.

Benefits:

- Long broach life.
- Excellent heat dissipation.
- Quick chips separation.
- Low mist formation.
- Provides optimization of product range
- Economical in terms of cost per unit.

Application:

- Especially suitable for broaching and gear cutting steel, stainless steels and Nickel alloys. This product is used for broaching of medium carbon steel of automotive components. This product can be used for shaving operation also in gear cutting where anti chip welding properties are important. Specialized additives used help to extend the life of costly broaches.

Characteristics:

Parameters	Test Methods	Typical Test Results
Appearance, Visual	Visual	Bright & Clear
Specific Gravity @ 30°C	ASTM D 1298	0.935
K. Viscosity @ 40°C, cSt	ASTM D445	17
Flash Point, °C (COC)	ASTM D 92	186
Pour Point, °C	ASTM D 97	(-) 6
Chlorine	Standard	Present
Free Sulphur Active	Standard	Present
Saponification Value	Standard	3.5
Cu Corrosion @ 100°C / 3 Hrs.	ASTM D 130	4C

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