



TL NEAT CUTTING OIL 22

Performance Level : IS 1115: 1986

These are premium quality Neat cutting oils blended from mineral oils, emulsifier and additives. It forms a stable emulsion of the oil in water type. The oils are applied generously to the work tool chip to get the maximum cooling effect, increase the tool life and improve productivity.

Application: This oil is recommended for operational, metal and performance requirements.

Sr. No.	Characteristics	Result
1	Appearance	Light brown clear fluid
2	Ash, % by mass	1.29
3	Copper strip corrosion test at 100 $^{\circ}\text{C}$ for 3 hrs.	1a
4	Flash Point, COC,	160
5	Water, % by mass	2
6	Emulsion Test, 5:1 & 20:1 ratio in water of 400 ppm hardness (as CaCO ₃)	No oil, No cream
7	Frothing Test 5:1 & 20:1 ratio in 200 ppm hardness (as CaCO ₃)	Passes
8	50:1 ratio with distilled water	-
a)	Cast Iron corrosion test	-
b)	20:1 ratio emulsion with 400 ppm hard water (as CaCO ₃)	0/0-0 (No Corrosion Passed)
9	Thermal Stability Test	Passes
10	K.V. cSt @ 40 $^{\circ}\text{C}$	25 to 40

Note: The above mentioned data are typical and it may vary with batch to batch within Permissible specification limits.