



METAL WORKING FLUIDS:

TL SOLUBLE CUTTING OIL

Performance Level : IS 1115: 1986

These are premium quality soluble cutting oils blended from mineral oils, emulsifier and additives. It forms a stable emulsion of the oil in water type.

Application: This oil is recommended for cutting operations on ferrous and non- ferrous materials.

Sr. No.	Characteristics	ISO VG 32
1	Appearance	Light brown clear fluid
2	Ash, % by mass	1.29
3	Copper strip corrosion test at 100°C for 3 hrs.	1a
4	Flash Point, COC, °C	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 °C	25 to 40

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