



An ISO 9001:2015 Certified Co.

Product Data Sheet

DC Soluble Cutting Oil Level 0

- Performance Standards: ISO 6743-7:1986, IS 1115: 1986
- Usage Guidelines: most grinding, sawing, turning, milling operations; advisable to use drinking water or de-mineralized water for dilution; more dilution is used for less severe operations
- Composition: Base Oil Group II, Additives: Anti Corrosion (0.4 to 2%), Anionic & Non-ionic Emulsifiers (5 to 15%)

S.No	Characteristics	Test Method	Results
1	Kinematic Viscosity @40°C, cSt, min	IS 1448 P:25	20
2	Flash Point, Cleveland (open) cup, °C, min	IS 1448 P:69	150
3	Thermal Stability test	IS 1448 P:100	passes
4	Volatile matter at 100°C for 16hrs, % by mass, max	IS 1115-B	20
5	Ash Content, % by mass, Max	IS 1448 P:4	3.5
6	Copper Strip Corrosion, 100°C, 3 hrs, max	IS 1448 P:15	1
7	Water, % by mass, max	IS 1448 P:40	10
8	Emulsion test, 5:1 and 20:1 ratio in 400ppm hardness (as CaCO ₃), max	IS 1448 P:98	0.1 ml oil and 0.2 ml cream
9	Frothing test, 5:1 and 20:1 ratio in 200ppm hardness (as CaCO ₃), max	IS 1448 P:99	No froth after 15 minutes
10	Cast Iron Corrosion test, 20:1 ratio in 400ppm hardness (as CaCO ₃), max	IS 1115-A	0/1-1

Disclaimer: DC makes no warranties, representation or conditions of any kind expressed or implied for use with respect to these products. Final determination of suitability of the product for the application contemplated by the users is solely their responsibility.