



An ISO 9001:2015 Certified Co.

Product Data Sheet

DC Soluble Cutting Oil Level 1

- Performance Standards: ISO 6743-7:1986, IS 1115: 1986
- Usage Guidelines: most grinding, sawing, turning, milling, reaming, drilling 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%), Lubricity Improver (2 to 8%)

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

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