



An ISO 9001:2015 Certified Co.

Product Data Sheet

DC Soluble Cutting Oil Level 4

- Performance Standards: ISO 6743-7:1986, IS 1115: 1986
- Usage Guidelines: severe grinding, sawing, turning, milling, reaming, drilling, boring, cutting, tapping, broaching, gear cutting, threading operations; advisable to use drinking water or de-mineralized water for dilution; more dilution is used for less severe operations, technically equivalent to Neat Cutting Oil Level 2 @ 1:1
- Composition: Base Oil Group II, Additives: Anti Corrosion (0.4 to 2%), Anionic & Non-ionic Emulsifiers (5 to 15%), Lubricity Improver (2 to 8%), Anti Foam (0.1 to 1%), AW Additives (0.4 to 2%), EP Additives (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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