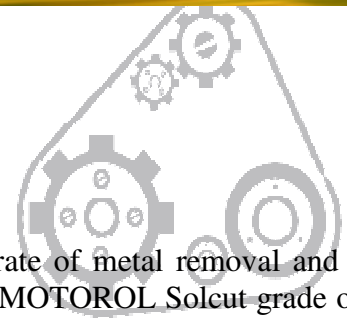




SOLUBLE CUTTING OIL
MOTOROL SOLCUT - 40/50/70



Introduction:

Cutting fluids play a vital role in accelerating the production rate by enabling increased rate of metal removal and by reducing or eliminating problems associated with severe and hazardous machine operation. MOTOROL Solcut grade oils give milky white emulsion with antibacterial chemical, coupling agents and additives controlling rust and corrosion.

Applications:

MOTOROL Solcut grades are suitable for all metal and machinery operations where emulsifying oils are generally used for cooling. It is also recommended in turning, drilling, grinding boring and milling operation of ferrous and non-ferrous metals.

Performance Standard:

Meets IS: 1115-1986.

Advantages:

- ◆ Protection from rust and corrosion
- ◆ Gentle to the hands of the operator and hence operator friendly
- ◆ Forms stable emulsion in water of 600 ppm hardness (water softener recommended for water with hardness exceeding 600 ppm)
- ◆ Good flushing action
- ◆ Does not decompose and retain physical properties
- ◆ Contain excellent bio-resistance properties leading to a long sump life

Typical Specifications:

Sr. No.	Characteristics	Test Method	40	50	70
1	Kinematic Viscosity at 40°C, cSt	ASTM D 445	21-30	31-40	41-50
2	Flash Point, °C (COC)	ASTM D 92	150	150	160
3	Cast Iron Corrosion Test at 100°C for 3 Hrs.	ASTM D 130	Passes	Passes	Passes
4	5 % Emulsion stability for 24 hours	-	Stable	Stable	Stable
5	PH of 5 % emulsion in water	pH Meter	8.5	8.5	8.5
6	Recommended Mixing ratio (Oil to Water)	-	1:40	1:40	1:30

Environment, Health & Safety:

Every care has been taken to ensure the accuracy of the information in this PDS. This however may be affected by subsequent improvement in product (R&D). MSDS is available for all MOTOROL products on request. MOTOROL products are unlikely to present any health and safety hazard with proper use for the correct application and maintain proper personal hygiene. Do not spill oils on the shop floor, discharge into drains, ground or water sources.