

Product Data Sheet

MAK SHEROL B

DESCRIPTION

It is premium quality soluble cutting oil blended from refined mineral oil, emulsifier and other additives. It forms extremely stable milky emulsion of the "Oil in Water" type.

PERFORMANCE BENEFITS

- Exceptional emulsion stability even with extreme hard water (400 ppm) leading to excellent tool life and finish in all metal cutting operations, where cooling is more important than lubrication

APPLICATIONS

This soluble cutting oil is recommended for use in a variety of cutting operations on ferrous and non-ferrous materials. It is used at water to oil ratios between 20:1 and 30:1.

PERFORMANCE LEVEL

- IS 1115 : 1986 [Reaffirmed March, 2002]
- UK DEFSTAN 91-23 for oil ZX-1 specifications

Characteristics	IS 1448	Typical Figures
Appearance	--	Light brown
Ash, % by mass	P:4	1.29
Copper corrosion @ 100°C, for 3 hrs	P:15	1a
Flash Point, (COC), °C	P:69	160
Emulsion Test, 5:1 & 20:1 ratio in water of 400 ppm hardness (as CaCo3)	P:68	No oil, No cream
Frothing test		
a) 5:1 & 20:1 ratio in 200ppm hardness (as CaCo3)	P:99	Passes
Thermal stability test	P:100	Passes

Health and Safety

This oil is not hazardous under normal conditions of use. For further guidance appropriate Material Safety Data Sheet may be referred.

Bharat Petroleum Corporation Ltd.

Technical Services

A' Installation, Sewree (East), Mumbai – 400 015

Phone: 022-24176354, Fax: 022-24182511 / 24166512

email: z_techservices@bharatpetroleum.in

Edition: R&D / Ind / 063 / Issue1/Oct, 2008 2008