

Product Data Sheet

MAK SHEROL BN

DESCRIPTION

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

PERFORMANCE BENEFITS

- Good emulsion stability
- Does not decompose chemically

APPLICATIONS

This soluble cutting oil is recommended for soluble cutting oil application used at water to oil ratios between 20:1 and 30:1.

PERFORMANCE LEVEL

- IS 1115 : 1986 [Reaffirmed March, 2002]

Characteristics	IS 1448	Typical Figures
Appearance	--	Light brown clear fluid
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 (CaCo3)	P:98	No oil, No cream
Frothing test a) 5:1 & 20:1 ratio in 200ppm hardness (as CaCo3)	P:99	Passes
Cast Iron Corrosion Test, 20:1 ratio emulsion with 400 ppm hard water (as CaCo3)	--	0 / 0-0 (No corrosion, 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.

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