

Product Data Sheet

MAK SHEROL SS

DESCRIPTION

It is a high oil content inherently stable watermix cutting fluid. It produces a milky to semi translucent emulsion which depending on the water quality, is low in odour and gives good corrosion protection to machines and components. It contains extreme pressure additives to provide excellent cutting performance.

APPLICATIONS

This soluble cutting oil is recommended for sawing, turning, milling, drilling and other chip forming operations.

Suggested concentrations %:
 Difficult operations of materials: 7-10
 General machining: 5-7
 Grinding: 3-5

PERFORMANCE BENEFITS

- Corrosion protection even above 400 ppm hard water
- Suitable for a wide range of ferrous alloys including high tensile steels, aluminium alloys, yellow metal alloys, oil resistant polymers and composites
- Readily forms a milky, stable emulsion in a wide variety of water qualities. Avoid water with high chloride content (above 50 parts per million) & high calcium or magnesium contents (above 500 parts per million)
- Gives better EP properties

PERFORMANCE LEVEL

- IS 1115 : 1986 [Reaffirmed March, 2002]

Characteristics	IS 1448	Typical Figures	
		Concentrate	Emulsion
Appearance	--	Amber, fluid	Milky to semi translucent
Specific gravity at 15.6°C	P:32	0.99	--
PH at 5%	--	--	9.1
IP 287 corrosion test, %Bpt		--	3.0
Defoam in 50ppm water		--	Nil (30 seconds)

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

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