



PRODUCT DATA SHEET

CUTTING OIL LIFE – (Metal)

Product Code (1003/1)

DESCRIPTION:

CUTTING OIL LIFE— is a highly stable oil in water emulsion developed for use as a cost effect, metalworking fluid. It is widely used for Aluminum machining. This is a new- generation, Biostable water soluble cutting oil.

APPLICATION:

- General machining.
- Grinding.
- Aluminum Machining

Materials:-

- Low to medium tensile steels.
- Aluminum, copper and their alloys.

Recommended concentrations

	%	Ratio
Grinding	2 - 3	50 : 1 – 30:1
General machining, non-ferrous materials	3 - 5	30:1 – 20:1
General machining ferrous metals.	5	20:1

Concentrations may need to be increased when machining difficult materials and where the water hardness of the diluent has an effect on corrosion inhibition.

Mixing:

Cutting oil life should be added gradually into the full volume of water- never the reverse, and gentle agitation maintained until all the oil has been added and a uniform emulsion obtained. Use lower concentration for top-up to achieve recommended mix- ratios.

Performance Features:

- Nitrite free- operator's health & safety. Reduced risk of the formation of nitrosamines.
- Phenol& chlorine free – Environmentally safe. Low disposal costs.
- Excellent lubricity – high oil content provides excellent machine tool lubrication.
- Emulsion stability – tolerant to difficult diluent waters.
- Corrosion inhibition – high level of corrosion inhibition on tool, slide ways and components.





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PRODUCT CHARACTERISTICS:

Test Parameter	Units	Test Limits	Test Method
Appearance	-	C&B	Visual
Density @ 15°C	Kg/m3	0.88 – 0.95	ASTM D-4052
Viscosity @ 40°C, min.	cSt	40	ASTM D-445
Dilution			
Dilution Appearance	-	Milky	Visually
pH Value (5% dilution)	-	9.2	-
Herbert Corrosion test	-	0/0-0	IP 125
Filter Paper Corrosion test	%	Nil	IP 287
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