

DIVYOL GUN DRILLING OILS – NO. 1 / 1A / 1F / 2

Applications:

Divyol Gun Drilling Oils 1, 1A, 1F and 2 are heavy-duty oil blends recommended for deep hole drilling, boring, broaching, gun drilling, tapping, milling, threading and honing operations of cast iron, steel and high-speed steel alloys. These oils are also used in machine tool industries, vertical machining centers, conventional lathe machine, milling and radial drilling machine and in multi spindle drilling. These oils were specially formulated to meet the higher performance levels required by some machine manufacturers and end-users. The high loading conditions encountered in the working of ferrous metals required the use of highly effective additives which have been incorporated in this formulation. Each grade in it comprises low viscosity base oils and select additives for required oiliness, extreme pressure performance and quick chip removal. Their low viscosity and the consequent higher thermal conductivity help maintain the tool edge temperatures within limits, thus ensuring better job finish and longer service life of tools.

Advantages:

Divyol Gun Drilling Oils 1, 1A, 1F and 2 enable reduced friction and good anti-weld properties at the chip-tool interface, resulting in extended cutting tool life and good surface finishes on the machined parts. They enable excellent performance in the most difficult machining operations and also permit clear view of the work piece.

Typical properties:

Sr. No.	Characteristics	Test Method	Divyol Gun Drilling Oils			
			NO 1	NO 1A	NO 1F	NO 2
1	Colour, max.	Visual	Bright and clear	Bright and clear	Bright and clear	Bright and clear
2	Appearance	Visual	Semi-transparent	Semi-transparent	Semi-transparent	Semi-transparent
3	Odour	Smell	Acceptable	Acceptable	Acceptable	Acceptable
4	Kinematic viscosity at 40 °C, cSt, min.	ASTM D 445	11	17.5	15.27	37.41
5	Flash point COC, °C, min.	ASTM D 92	160	160	170	180
6	Type	–	Sulphurised	Sulphurised	Sulphurised	Sulphurised
7	Chlorine	–	Yes	Yes	Yes	Yes

The above properties are typical values and do not constitute specification of the product.

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