

## DIVYOL NEAT CUTTING OILS – ST CUT 10 TO 50M

### Applications:

Divyol ST Cut is a series of high performance multipurpose neat cutting oils formulated with high quality refined mineral oils and select additives to ensure cost effective machining operations. These non-staining and non-corrosive products are designed for light and moderate duty metal working operations, especially recommended for surface and flute grinding of hardened parts. They are also recommended for machining operations of high tensile stainless steel as well as nickel-chromium alloys on automates, gear cutting, hobbing, drilling/reaming and thread cutting machines. These oils are widely used as an economical replacement of soluble cutting oils for obtaining a better finish on ferrous and non-ferrous metals.

### Standards:

Divyol ST Cut series of cutting oils conform to performance specifications as per IS3065: 1985 Type I & II Grade.

### Advantages:

Divyol ST Cut series of fluids give superior surface coverage which improves their cooling ability. They impart a better surface finish to metal components after machining and are non-corrosive and non-staining on non-ferrous metals. They help extend service life of the cutting tools.

### Typical properties:

Sr. No.	Characteristics	Test Method	Divyol ST CUT										
			10	10L	12	23M	25	25M	26	28	35	45	50M
1	Appearance	Visual	Bright and clear	Bright and clear	Bright and clear	Bright and clear	Bright and clear	Bright and clear	Bright and clear	Bright and clear	Bright and clear	Bright and clear	Bright and clear
2	Flash point, COC, °C, min.	ASTM D 92	150	150	150	196	140	170	190	190	160	190	228
3	Pour point, °C, max.	ASTM D 97	+8	-21	-3	-6	8	-6	-3	-3	6	3	-6
4	Kinematic, viscosity at 40 °C, cSt, min.	ASTM D 445	12	13.05	7.92	28.36	22 – 25	38.09	28.11	31.80	40 – 45	35 – 45	49.80

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

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