

## DIVYOL NEAT CUTTING OILS – ST CUT OIL 677 / 678

**Applications:**

Divyol ST Cut Oils 677 and 678 are non-staining type neat cutting oil blends recommended for cold forging operation of small, medium and big size stainless steel fasteners.

**Standards:**

Divyol ST Cut Oil blends are formulated using highly refined virgin base stocks of medium viscosity and fatty oils besides inactive sulphur and chlorinated additives. These formulations meet the performance standards as per IS 3065- 1985, TYPE II, Grade 3 (RE-AFFIRMD 1995).

**Advantages:**

Divyol ST Cut Oil blends, both 677 and 678, have higher heat dissipation capacity and give maximum surface coverage (wetting) of worked metals. Select additives give the blends superior EP properties. They impart excellent surface finish, cause no staining and lead to longer service life of tools. These oils can be used for multiple operations.

**Typical properties:**

Sr. No.	Characteristics	Test Method	Divyol	
			ST CUT 677	ST CUT 678
1	Appearance	Visual	Bright and clear	Bright and clear
2	Colour	ASTM D 1500	Dark brown	Dark brown
3	Specific gravity at 29.5 °C	ASTM D 1298	0.878	0.895
4	Kinematic viscosity at 40 °C, min., cst	ASTM D 445	55 – 65	60 – 80
5	Flash point °C (COC) min.	ASTM D 92	160	190
6	Pour point °C max.	ASTM D 97	-3	-3
7	Saponification value, mg KOH/g	P:55 of IS:1448	Nil	15
8	Contains:			
	inactive sulphur	–	Yes	No
	chlorine	–	No	Yes

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

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