



## SRN LUBRICANTS PRIVATE LIMITED

### PRODUCT DATA SHEET



#### CIIFROL SOLUCUT 45

**CIIFROL SOLUCUT 45** is a soluble emulsion type high performance bio-stable, micro emulsion type extreme pressure water soluble cutting fluid. It forms milky white emulsions when mixed with water. The emulsion formed is homogenous and does not break even during prolonged usage or shut downs. CIIFROL SOLUCUT 45 is a medium oil content product whose emulsions are suitable for operations on a wide range of ferrous alloys including high tensile steel and other difficult to machine alloys. These emulsions are also suitable for Aluminium alloys and yellow metal alloys.

#### Applications:

**CIIFROL SOLUCUT 45** is recommended for general purpose machining operations like sawing, milling, drilling and other chip forming operations, general purpose surface, cylindrical and centreless grinding operations. Solucut Extra gives excellent oil life in comparison with other conventional soluble cutting oils and also provides extended tool life and finish in general machining and grinding operations. These oils are also found to be very good even with water hardness of 400 ppm. Recommended dilution rates for various operations are as under

- General machining: 5-7%
- Grinding: 3-5%
- Difficult Operations or Materials: 7-10%

Please avoid water with high Chloride content ( Above 50 ppm ) and high Calcium and Magnesium content ( Above 500 ppm )

#### Specifications:

This propriety formulation of SRN Lubricants passes PERFORMANCE STANDARD: IS 1115: 1986 (Reaffirmed 1996)

#### Benefits:

- Low foaming in all water conditions to ensure continuous grinding performance
- Inhibits microbial growth to enhance coolant sump life
- Extended Protection of work piece, machine components & tool material from rust & corrosion.
- Excellent surface Finish, superior cooling properties.
- Very long emulsion life.

#### KEY PROPERTIES

CIIFROL SOLUCUT 45	
Parameters	Typical Results
Appearance	Amber Fluid
Kinematic Viscosity@ 40 Deg C	20 - 30
Flash point Deg C ( Typical )	155
pH of 5% emulsion in water( Typ )	8.5 - 9.5 Typical
Cast Iron Corrosion	Passes
Emulsion Stability	Excellent
Mineral Oil Content	18%

#### Disclaimer:

The above given values are typical results; however the guaranteed specifications values are different and often lower than the typical values. For the guaranteed specifications, please discuss with SRN Lubricants representative or visit our website [www.ciirol.co.in](http://www.ciirol.co.in)