



Product Data

Castrol Ilocut 103™

Neat Cutting Oil for Ferrous Machining

Description

This product is specially blended from highly refined mineral oils and sulphurized fatty oils containing active sulphur. Sulphur present reacts chemically at the tool work/chip interface, to produce metallic derivatives, which form a low friction film between the metal surfaces. This film is effective upto 1000 C and minimizes built up edge and ensures optimum anti-chip welding properties. This product can be used advantageously in large centralized systems.

Application

Specially suited for automatic, semi-automatic and combination turret lathework, gear cutting, threading and tapping operations on high tensile steels. This grade has the highest dosage of free sulphur and sulphurized fat in this series, which ensures high anti - weld properties and is thus more suited for heavy-duty operations.

Advantages

These products offer:

- ◆ *Excellent tool life*
- ◆ *Improved surface finish*
- ◆ *Reduced risk of atmospheric contamination, being non-fuming.*
- ◆ *Low oil drag out*
- ◆ *Economy in usage*

Castrol Ilocut 103
01.11.2006, Version Number 1.0
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Characteristics

| Characteristics | Typical Value |
|--|------------------------------|
| Appearance | Clear and bright amber fluid |
| Relative density g 30'C | 0.890 |
| Kinematic Viscosity @ 40'C cSt | 35 |
| Flash point OC (open cup) | Class 4 |
| Copper strip corrosion @ 100C for one hour | Sulphurized fat + |
| Additives | Sulphur (Active) |

Not recommended for cuprous metals. Staining may occur on high nickel alloys during storage or subsequent heat treatment.

These are typical figures and do not constitute a specification.

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