



## LUBENZ SP CUTTING OIL

### Product Data Sheet

#### Product Description

LUBENZ SP CUTTING OIL is high quality water soluble cutting oil specifically formulated for cutting and grinding operations of metalworking for both ferrous and non-ferrous components. These oils are formulated to provide outstanding emulsion stability & rust inhibition and works satisfactorily for all types of processes involving fine carbon steels.

#### Features & Benefits

- Outstanding lubricating property.
- Excellent rust and corrosion protection.
- Excellent emulsion stability.
- Excellent cooling of tools and worked components.
- Avoids objectionable odors due to the presence of bactericides in the formulation.

#### Application

LUBENZ SP CUTTING OIL is water soluble cutting oil suitable for use in all type of cutting and grinding operations for both ferrous & non-ferrous components, with following recommended dilution ratios.

- 3 - 5% for general metal working.
- 2.5 - 4% for grinding.
- 5 - 10% for heavy duty cutting.
- 5 - 6% for use as a fire-resistant hydraulic fluid.

#### Typical Characteristics

| LUBENZ SP CUTTING OIL                   | Test Method | Units | Water Soluble Cutting Oil  |
|---|-------------|-------|----------------------------|
| Color                                   | ASTM D 1500 | -     | 4.0                        |
| Appearance                              | Visual      | -     | Brown & Clear              |
| Specific gravity @ 60/60 °F             | ASTM D 4052 | gm/cc | 0.872                      |
| Viscosity @ 40 °C                       | ASTM D 445  | cSt   | 40.6                       |
| pH value (1% solution in distilled H2O) | E70         | -     | 9.0 max                    |
| Emulsion stability, 24 hour             |             |       | -                          |
| a. 5% in distilled water                | ASTM D 3707 | -     | Slight ring – no oil trace |
| b. 5% in 340 ppm CaCo <sub>3</sub>      |             |       | 2 ml cream – no oil trace  |
| Pour Point                              | ASTM D 97   | °C    | -12                        |
| Flash Point (COC)                       | ASTM D 92   | °C    | 185                        |
| Sulfur content                          | ASTM D 4951 | %wt   | 0.35                       |

*The above figures are typical of blends with normal production tolerance and do not constitute a specification.*