

### DESCRIPTION

Servocut 335 and 345 are chlorinated inactive type cutting oils containing additives to impart oiliness and EP properties. Chlorine and non-corrosive sulphurised fat is incorporated to provide anti-weld, extreme pressure and oiliness characteristics to these oils and hence these grades give excellent performance over a wide range of temperatures.

### PERFORMANCE BENEFITS

- ✘ Minimise welding of the chip to the cutting tool.
- ✘ Help retain sharpness of the cutting edge and reduce stress at the cutting point.
- ✘ Reduce friction between chip and tool face thus generate less heat
- ✘ Do not stain non-ferrous metals
- ✘ Can be used as a hydraulic and general purpose lubricating oils in case cross leakages occur.

### APPLICATION

Servocut 335 & 345 oils are recommended for:

- ✘ All machining operations on non-ferrous metals.
- ✘ Machining of ferrous metals where the severity of operation is not high.

Addition of chlorine enables the use of these oils for extreme pressure – low/moderate temperature cutting operations where feed rates are high but speeds are low.

These operations include gear hobbing, screw cutting, tapping, milling, reaming etc.

### CHARACTERISTICS

GRADE	335	345
Kinematic Viscosity, cSt @ 40°C	31 – 35	40 - 44
Flash Point (COC), °C Min.	160	180
Pour Point, °C Max.	0	0
Copper Strip Corrosion, @ 100 °C, 3 hrs, Max	1	1

### HEALTH & SAFETY

These oils are unlikely to present any significant health or safety hazard when properly used in the recommended application and good standards of industrial and personal hygiene are maintained.

For further information please contact our nearest office OR:

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