

PRODUCT DATA SHEET

SERVO CUT 945, 945 A



DESCRIPTION

Servocut 945 & 945 A are active type neat cutting oils and 945 A contains higher dosage of sulphurised fats. These oils contain a sulphurised fatty material, which improves oiliness property thus providing better surface finish.

Sulphur incorporated in these oils become chemically active at the tool-work piece-chip interface and ensures protection to the cutting tool over a wide range of operating temperatures.

PERFORMANCE BENEFITS

- Provides continuous protection to tool edges over a wide range of operating temperatures.
- Helps in improved surface finish due to the added oiliness property.
- Enables machining of tough, ductile steels in severe operations.
- Prevents localised welding between the chip and tool.
- Keeps at minimum, oil drag-out losses on components and swarf.

APPLICATION

Servocut 945 and 945 A are recommended for most of the cutting operations on ferrous metals under severe operating conditions, which demand high degree of chemical activity in oils. This oil is suitable for machining operations on high tensile stainless steel as well as Ni-Cr alloys by automatics, gear cutting, hobbing, drilling, reaming and thread cutting machines. To obtain best results with the use of this product, it is necessary that a copious flow of oil at low pressure is maintained at the cutting area.

The use of Servocut 945/945 A for cutting operation on non-ferrous metals and its contact with soft metal bushes in machines should be avoided.

PERFORMANCE STANDARDS

- Meets IS : 3065-1985 (Reaffirmed 1995) Type III Grade 2.

CHARACTERISTICS

	Servocut 945 & 945 A
Kinematic Viscosity, cSt @ 40°C	28 - 34
Flash Point (COC), °C Min.	160
Pour Point, °C Max	0
Copper strip corrosion, @ 100°C, 3 hrs, Max	4
Saponification No.	18 (only 945 A)

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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