



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 H ₂ O)	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 ₃			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.