



TM

JUPITER PETROTEC PRODUCTS

(Mfgs.of: Automotive, Industrial and Speciality Products & Lube Additives)

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JUPITOL Cut Cool Gr.I / Cut Cool Gr.II (Soluble Cutting Oils)

Product Category	Industrial
Serial No	022
Date	01/11/2004

Product Description:-

Jupitol Cut Cool Gr.I and Jupitol Cut Cool Gr.II are Soluble Cutting Oils formulated from premium quality base oils and superior additives. The quality of the product is kept at very high level. It is used in machines with low to medium tensile ferrous metals, non-ferrous metals such as aluminium and alloys.

Properties:-

- Excellent cooling, wetting and lubrication properties. characteristics.
- Good corrosion resistance.
- Greater abilities to assist the tools in cutting operation.
- Disperse readily in water and produce stable emulsion.
- Offers resistance to fungal and bacterial growth.

Typical Characteristics:-

S.No	Test	JOM	Test Method	Specification of Soluble Cutting Oil	
				Cut Cool Gr.I	Cut Cool Gr.II
1	Colour	NA	Visual	Bright Amber Fluid	Bright Amber Fluid
2	Clarity	NA	Visual	Clear	Clear
3	Density @ 29.5°C	Gm/cc	ASTM D1298	0.890 (Typical)	0.892 (Typical)
4	Kin. Viscosity @ 40°C	CSt.	ASTM D445/IP71	28.00 (T)	29.50 (T)
5	Flash Point (COC)	°C	ASTM D 92	150 (Min.)	150 (Min.)
6	Ash (% by Mass) Max	%	ASTM D 482	3.5	3.8
7	Emulsion Stability	NA	ASTM D1479	Milky white emulsion stable with 400 ppm hard water for 24hrs.	Milky white emulsion stable with 200 ppm hard water for 24 hrs

Pack Sizes Available: 20ltr (Bucket), 50 Ltr & 100 Ltrs Plastic Barrel & 210 Ltrs in MS Barrel

The values mentioned above are subject to change due to our continued R & D.
NA: denotes not applicable.

Few Tips for using Soluble Cutting Oil

Check to see the emulsion sump is clean and free from any solid / liquid contaminants before emulsion is made.

Stir well, the coolant oil with a clean tool / rod before use and close it properly after use.

Use soft water (less than 100 ppm) to form emulsion for better performance and stability.

Do not add softening chemicals to prepare soft water with the emulsion sump as the same will break the emulsion. Always prepare soft water separately.

Add oil to water with constant stirring to make emulsion at appropriate ratio as recommended.

The water:oil ratio of 20:1 or to a max. of 25:1 will provide best results under normal machining operations for both ferrous and non-ferrous metals. In the case of cast iron machining the water:oil ratio of 15:1 will give the good result.

Stir the emulsion and circulate with a small pump through a filter provided with fine mesh to remove the suspended solid particles everyday after its use to prolong the life of the emulsion.

Do not pour / contaminate the emulsion sump with any old / rejected oil or bad water or floor swept of the plant.

Care to be taken to the coolant emulsion sump for periodic cleaning and avoid any solid, liquid and gaseous contamination.