



## LUBRITA CUTTING OIL MFE SUPER SOLUBLE OIL

High End Mineral Based Soluble Cutting Oil

### DESCRIPTION

**LUBRITA CUTTING OIL MFE SUPER** is water emulsifiable oils for metal working operations where better rust protection, long oil life & maximum cooling is desired. These oils are developed with selected base oils, emulsifiers and biocides for ready mixing to form a stable emulsion which provide good rust protection and excellent cooling.

**LUBRITA CUTTING OIL MFE SUPER** is recommended for turning , milling , CNC, VMC, Grinding and other light to medium general machining operations in ferrous and non-ferrous metals. LUBRITA CUTTING OIL MFE SUPER is not recommended for Magnesium machining. **Performance Standards:** Meet IS: 1115-1986 standards. **BENEFITS**

- Form stable emulsions with water upto even 400 ppm hardness.
- Permit rapid separation of chips and grinding dirt keeping circulating line clean.
- Provide excellent protection against rusting.
- Provide effective cooling.
- Formulated for components with high resistance to bacterial attack and protected from bacterial degradation.
- Free from Nitrites, Phenol, Rosin & chlorinated additives

Typical Data	Concentration in %
Grinding	2-5%
General Machining( Turning, Drilling etc)	4-6%
Difficult operation or machining	6-8%

**KEY PROPERTIES**

SR. NO.	TEST	TEST METHOD	UNIT	SPECIFICATION		TYPICAL VALUE
				MINIMUM	MAXIMUM	
1	Appearance	Visual	....	Clear & Bright		Clear & Bright
2	Colour	ASTM D-1500	....	Dark Brown		Brown
3	Density @29.5°C	ASTM D-1298	Kg/m <sup>3</sup>	To Be reported		0.8713
4	Kin Visc.@40°C	ASTM D-445	mm <sup>2</sup> /s	45.00	60.00	59.76
5	5% Emulsion In 500 ppm Hard Water	IS- 1115	....	Stable With Out Any Separation For 24 Hrs Min		Pass
6	Thermal Stability (cold & hot)	IS- 1115	deg.C	Shall Pass The Test		Pass
7	Pour Point, °C	ASTM D-97	deg.C		.-3	-9
8	TAN, mg of KOH/gm	ASTM D-2896	mg of KOH/gm		5	3.86
9	Cu Corrosion,@100°C	ASTM D-130	deg.C		1a	1aPass
10	PH@5% Distilled	ASTM D1287	---	9 PH		9.59

Refractrometer correction factor is equal to 1

**Pack Size:25L, 210 L**

\* Figures are indicative only. Values depend on method of application and shape of components.

Notes:

- Most of our products contain Petroleum based chemicals and hence it is essential to store 'Under Shelter'.
- The information contained herein is true and accurate to the best of our knowledge. However, we strive to improve the product with continuous R & D. The company makes no warranty of results and assumes no obligations or liabilities from the use of any products or process mentioned herein because the use is beyond our control. This publication is not to be taken as a license to operate under or recommendation to infringe upon, any patents.