



## LUBRITA BROACHING OIL 01

Broaching is the severest amongst the various machining operations. This is accomplished by Horizontal or Vertical Machines which broach on the internal or external surfaces of the job. Internal broaching is severer than the external broaching and the vertical operations are severer than the horizontal ones.

A Broach consists of a metal rod having a series of equally spaced teeth which progressively make deeper cuts on the job. Each cutting tooth of the broach is in contact with the job during the entire cut and each succeeding tooth is buried deeper in the cut being made. The cutting fluid used for broaching should have maximum anti-weld and extreme pressure properties in order to ensure high accuracy and finish of the job.

### PRODUCT DESCRIPTION

Lubrita broaching oil is blends of specially selected light bodied base oils and additives which help it withstand extreme loads encountered in broaching operations. The oils are specially blended to ensure enhanced cooling to obtain smooth polished surfaces. These additives get activated and form protective film under local temperature and EP enabling excellent surface condition. It's low viscosity enables easy removal of debris. It contains fats, sulphur and chlorine to enhance fluid properties.

### PERFORMANCE BENEFITS

1. Excellent heat dissipation.
2. Provides optimization of product range
3. Economical in terms of cost per unit.
4. Adequate lubricity and EP additives for prolong Broach life.
5. Faster debris removal gives excellent surface finish free from nicks and other surface irregularities.
6. Good cooling results in consistent accuracy and surface finish.
7. Anti-misting – Environmental and operator friendly.

### APPLICATION

Lubrita Broaching oil is specially suitable for broaching and gear cutting steel, stainless steels and Nickel alloys. It is recommended for non-ferrous metals

### CHARACTERISTICS

S: no	Test Parameter	Test Methods	Lubrita Broaching Oil 01
1.	Appearance	Visual	Bright & Clear
2.	Kinematic Viscosity @ 40°C, cST	D 445	18
3.	Specific Gravity @ 29.5°C, Kg/L	D 1298	0.865
4.	Flash Point, COC, °C, Min	D 92	175
5.	Copper Strip Corrosion @ 100°C, 1 Hr.	D 130	4 C