



PRODUCT DATA SHEET

Vorsol Super (Soluble Cutting Oil)

Description:

VORSOL Super is a multipurpose soluble cutting oil formulated from highly refined base oils, fortified with high quality emulsifier to form a stable milky white emulsion in a wide range of water hardness.

Product Benefits:

- Meets IS :1115-91 specification
- High emulsion stability
- Low Foaming
- Good Cooling & Lubricity
- Multi-metal compatibility
- Operator Friendly
- Wide range of application

Applications:

- Recommended for all types of machining operations
- Suitable for both Ferrous and Non Ferrous metals
- Can be used for both standalone and central systems

Recommended Dilutions:

- Grinding,
 - Turning, Drilling on Non- Ferrous material
 - Turning, Drilling, Tapping- Ferrous
 - Machining, Tapping- Aluminium
- } 3 – 7 %, depending upon application & material



Coolant Management Guidelines:

- Ensure that before charging an emulsion the machines are clean. While preparing the emulsion always add oil to water, while addition the agitator must be on. Never add water to oil.
- Check the emulsion concentration on regular basis. Maintenance of proper concentration gives satisfactory performance as well as minimize bacteria problem.
- Always ensure to maintain the pH range between 8.5 to 9.2
- The top up should be done in the form of emulsion. Never add only water or oil to the sump.
- Periodical checking of Bacterial count needs to be done. The earlier detection of bacterial count can be tackled easily by using proper additives.

Properties:

Sr. No	Properties	Test Method	specifications
1	Appearance	Visual	Clear Bright
2	Colour	visual	Brown Liquid
3	Density @ 29.5°C	ASTM D 1298	0.860—0.930
4	Flash Point	ASTM D 92	190° C
5	Frothing test 20:1 & 5:1 ratio in 200 ppm Hard water	IS:1448	No froth after 15 min
6	PH of 5% emulsion in D/W	Internal	9.2
7	Cast Iron corrosion Test 20:1 in 400ppm water	IP 125	No Staining observed
8	BRIX factor		1.0

Note: The above data is typical & does not constitute a specification. The information provided is not to be taken as a warranty or representation for which we assume no legal responsibility, nor as permission or recommendation to practice any attended location or otherwise. It is solely offered for your consideration, investigation and verification. This product should not be used for purposes other than its intended use. If disposing of used product, take care to protect the environment.