

# KIXX CUTTING OIL SL

## SOLUBLE CUTTING OIL

### DESCRIPTION

KIXX Cutting Oil SL is specially developed for a general purpose soluble cutting fluid of the non-EP type; it is blended from premium quality mineral oil and a good package of emulsifier and corrosion inhibitors. It forms a milky white emulsion. The emulsion formed is homogenous and does not split during usage on routine machine shut-downs, under normal conditions.

KIXX Cutting Oil SL is recommended for general purpose metal cutting operations of ferrous and non ferrous materials, where high quality coolant is required.

Always add oil to water under agitation to make a good emulsion. Do not add water to oil.

### APPLICATIONS

- Recommended for a variety of cutting operations on ferrous and nonferrous metals. It gives extended tool life and finish in all cutting operations where cooling is more important than lubrication.
- Recommended dilution ranges are :-
  - 1: 20 Milling, drilling, turning & sawing.
  - 1:10 to 1:20 Sawing, tapping & reaming.
  - 1:40 Centre-less surface grinding.

### PERFORMANCE

- BIS 1115:1986

### BENEFITS

- Highly stable emulsion.
- Prolonged tool life, excellent surface finish, superior cooling and lubricating properties.
- Excellent rust protection.

### KEY PROPERTIES

Appearance	Dark Brown Clear Liquid
Density @29.5 °C	0.869
Kinematic Viscosity @40°C (mm <sup>2</sup> /s)	26.77
Flash Point (°C, COC)	140
pH (5% Emulsion in D/W)	9.0

Also, KIXX Cutting Oil SL has passed the following tests

Corrosion Test (IP 125)	Pass
Emulsion Stability (for 24 hr)	
5% in Tap Water	Pass
5% in 400ppm Hard Water	Pass
Heat Stability Test (at °C & 50°C)	Pass