

MAK SHEROL BN

Description

SHEROL BN is soluble cutting oil blended from refined mineral oil, emulsifier and other additives. It forms stable milky emulsion of the "Oil in Water" type. It does not decompose chemically and also do not cause discoloration or staining of the work piece

Application

This soluble cutting oil is recommended for soluble cutting oil application used at water to oil ratios between 20:1 and 30:1.

Benefits

- Excellent cooling and lubricating
- Extended tool life
- Low foaming tendency
- Easy emulsification - stable emulsions
- Good rust protection - machine and parts

Performance Level

IS 1115: 1986 [Reaffirmed March, 2002]

Technical Specifications

Characteristics	Test methods	MAK SHEROL BN
Appearance	visual	Light brown & clear fluid
Copper Corrosion @ 100°C, for 3 hrs	ASTM D130	1a
Flash Point, (COC) °C	ASTM D92	160
Emulsion Test, 5:1 & 20:1 ratio in water of 400 ppm hardness (CaCo3)	IS 1448 P:98	No oil, No cream
Frothing test 5:1 & 20:1 ratio in 200ppm hardness (as CaCo3)	IS 1448 P:99	Passes
Cast Iron Corrosion Test, 20:1 ratio emulsion with 400 ppm hard water (as CaCo3)	IS 1448 APPENDIX A	0 / 0-0 (No corrosion, passes)
Thermal stability test	IS1448 P:100	Passes

All the mentioned values are typical which may vary from batch to batch.

Storage and Handling

- Indoor Storage is always preferable
- Barrels should be kept horizontally at 3'o'clock 9 'o clock position
- Barrels should be kept away from dusty or heated areas as much as possible
- During handling any contact with dust must be avoided.

Health and Safety

These oils are not hazardous under normal conditions of use. For further guidance appropriate Material Safety Data Sheet (MSDS) may be referred.

Advice

For any further advice on applications or otherwise, please contact the nearest Bharat Petroleum territory office or Technical Services department at the address given below.

Bharat Petroleum Corporation Ltd.

Product and Application Development Dept.
 BPCL 'A' Installation, Sewree Fort Road, Sewree (East)
 Mumbai -400015
 E-mail: MAKcustomercare2@bharatpetroleum.in
 Tel No.: 022-24176351