

PRODUCT DATA SHEET



NEAT CUTTING OILS

PALKUT ST – 1,2,3,4,5,6

These products are high performance neat cutting fluids, designed for a wide range of applications. The product meets the highest demands of operating, cutting conditions, tools & work piece materials. Each of these products differ in their viscosity & other characteristics etc. to cover a wide range of applications. These products offer stable oil film, excellent heat dissipation, EP properties & improved surface finish.

PALKUT ST -1 & 2

Non-staining type neat cutting oils containing chlorinated EP additives. These products are recommended for machining operation on mild steel, carbon steel, nickel steel and manganese steel such as thread grinding, form grinding, milling, honing & lapping etc.

PALKUT ST - 3

Non-staining type sulphurised fatty oil based neat cutting oil which covers a wide range of machining operations, aids in obtaining good surface finish & protects tool from excessive wear. Recommended for application in high-speed automatic machine tools & multispindle lathes where operations like turning, honing etc. are performed. It is also suitable for application as general-purpose machine tool lubricant.

PALKUT ST - 4

It contains sulphurised & chlorinated additives which provides excellent performance in all machining operations on non-ferrous metals & can also be used for gear hobbling, gear shaving, screw cutting, tapping, milling etc.

PALKUT ST - 5

It is an active sulphur-chlorinated type cutting oil which is recommended for deep hole drilling & deep hole boring. It is suitable for cutting of ferrous & ferrous alloys only.

PALKUT ST - 6

It is a neat cutting oil containing sulphurised fat besides active sulphur & chlorinated additives. Recommended for severe metal cutting operations including gear cutting, broaching, thread cutting, hobbing etc. It is not recommended for use on non-ferrous metals.

CHARACTERISTICS							
S.NO.	PROPERTIES	PALKUT					
		ST-1	ST-2	ST-3	ST-4	ST-5	ST-6
1	Appearance	Clear & bright amber fluid					Dark Brown
2	Kin. Viscosity, cSt @ at 40°C, Min.	5-8	15-25	15-25	27-35	11-15	27-35
3	Flash Point, COC °C, Min.	120	150	150	160	135	160
4	Contains						
	a) Inactive Sulphur	NO	NO	YES	YES	NO	YES
	b) Active Sulphur	NO	NO	NO	NO	YES	YES
	c) Chlorine	YES	YES	NO	YES	YES	YES

The specifications are subject to variations / development / customization.

PACKING: 210L, 50L, 20L