

FIBROL PETROLEUM Mineral Based Water Soluble Cutting Oil

Recommended Use	Cast Iron	Alloy Steel	Carbon Steel	Al. Alloy	Yellow Metals
Grinding	--	--	--	--	--
General Machining	√√	√√	--	√	--
Drilling	√√	√√	--	√	

SPECIFICATIONS

Sr. no .	Characteristics	Test Method	VALUE
1.	Appearance	Visual	clear
2.	Colour, Oil	Visual	Brown
3.	Colour, Emulsion	Visual	Milky White
4.	Copper Corrosion, 1000 C, 3 hrs.	ASTM D130 1a	1a
5.	Emulsion Test, 5:1 & 20:1 ratio in water of 400 ppm hardness (as CaCO ₃)	IS 1448 P:68	No oil, no cream
6.	Frothing Test, 5:1 & 20:1 ratio in water of 200 ppm hardness (as CaCO ₃)	IS 1448 P:99	Passes (no froth)
7.	Thermal Stability Test	IS 1448 P:100	Passes
8.	Refractometer Factor		1.0
9.	pH, at 5% in distilled water	--	9.3



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