



Product Data

Castrol Ilocut[®] 152,154

Description

A highly refined, dark brown opaque mineral oil containing a generous proportion of sulphurised fatty oil.

The sulphur is carefully combined with the fatty oil in such a way that it will not stain copper alloys or give rise to undesirable corrosion effects, yet will release the element at the higher temperatures encountered at the chip/ tool interface, so that it functions as an effective anti-weld agent. Consequently, oils in this category are ideally suited for the machining of light alloy steels, yellow metals, and mild and low carbon steels.

Castrol Ilocut[®] 152 and **Castrol Ilocut[®] 154** differ only in viscosity and sulphurised fatty oil contents.

Performance Benefits

- Consistently high surface finish and dimensional accuracy
- Versatile product which can be used in many applications and materials.
- Increases tool life and reduce change frequency.
- Low fire risk due to high flash point.
- Low fuming and misting.

Recommended Applications

They are recommended for use over a wide range of cutting applications and are particularly valuable for repetition work on small automatics, and light operations on capstan and turret lathes.

Also recommended for operations such as :

Gear generating
Gear shaping
Gear spline hobbing

Castrol Industrial

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Typical Characteristics

Castrol	Ilocut® 152	Ilocut® 154
Colour	Dark Amber	Dark Amber
Density @ 15°C	0.872	0.872
Kinematic Viscosity @ 40°C, cSt	25.8	38.9
Closed Flash Point, °C	196	204
Sulphur % wt	A	B
Chlorine % wt	Nil	Nil
Fat % wt	C	D
Copper Corrosion (100°C @ 3 Hrs)	1a	1a

(A : <1 % B : 1 - 3 % C : >3 - 9 % D : >9 - 20 % E : >20 %)

All reasonable care has been taken to ensure that the information contained in this publication is accurate as of the date of printing. However, such information may, nevertheless, be affected by changes in the blend formulation occurring subsequent to the date of printing. Material Safety Data Sheets are available for all Castrol Industrial North America Inc. products. The MSDS must be consulted for appropriate information regarding storage, safe handling and disposal of a product.