



Product Data

Castrol Ilocut 1253™

Deep Hole Drilling Neat Oil

Description

This product is formulated with specially selected low viscosity mineral oils and contains polar, mild and active EP type of additives. These additives effectively take care of varying stresses at the cutting edge. At highly stressed friction points where high local temperatures are obtained, thermal decomposition of these additives occur. Reaction at the sliding metal surfaces occurs giving metallic derivatives, which act as solid lubricant film.

Application

This product is recommended for deep hole boring, deep hole drilling, including gun drilling and trepanning operations.

Operation	Cast Iron	Carbon Steel	Alloy Steel	Stainless Steel	Copper Alloys	Aluminium Alloys
Deep Hole Boring	†	†	†	†	‡	‡
Deep Hole Drilling	†	†	†	†	‡	‡
Gun drilling	†	†	†	†	‡	‡

† SUITABLE

‡ NOT SUITABLE

Castrol Ilocut 1253
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All reasonable care has been taken to ensure that the information included 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 India Limited products. MSDS must be consulted for appropriate information regarding storage, safe handling and disposal of a product

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Advantages

Product Feature	Operational Advantage	Customer Benefits
Low viscosity	Excellent heat dissipation	Consistent dimensional accuracy and finish
	Less oil drag out	Low top up, Economy in use
Special polar and EP additives	Good anti - chip welding properties	Excellent tool life and reduced rejections
Low Fuming & misting	Cleaner work atmosphere at the shopfloor	Environment & operators friendly
Chlorine Free	No disposal problem	Reduced disposal cost

Characteristics

Characteristics	Typical Value
Colour	<3.0
Relative Density @ 30 deg C	0.865
Kinematic Viscosity @ 40 deg C. cSt	9.95
Flash Point deg C (COC), Min	150
Reactive Sulphur % Wt, Min	0.5
Copper strip corrosion @100degC for 1 hour	4b
Four Ball Weld Load,Kgs	800

The above are typical figures and do not constitute a specification.

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