



Product Data

Castrol Ilocut 334™

Heavy Duty, Deep Hole Drilling Neat Oil

Description

This product is for deep hole drilling and trepanning operations. It is formulated with specially selected mineral oils and contains a mix of polar, mild and active Extreme Pressure (EP) additives. These additives effectively take care of the varying stresses at the cutting edge, the chamfers and especially during the cutting process. At the highly stressed friction points where high local temperatures are obtained, thermal decomposition of these additives occur. Reaction at the sliding metal surfaces takes place giving metallic derivatives, which act as solid lubricant films. Ilocut 334 contains fat and sulphur as the polar and EP additives.

In deep hole drilling operations the coolant has to be fed through the boring bar under high pressures. It is therefore essential to use the right viscosity coolant to ensure rapid flushing action for clearing swarf from the boring head. It is also important that the viscosity of the fluid should permit high velocity flow and not cause entrapment or foaming with the small holes incorporated in the cutter head.

Application

Ideally suited for gun drilling systems, BTA boring systems and ejector boring systems where the coolant is forced under pressure to clear swarf without foaming. This grade also offers excellent heat dissipation, improved finish and extends tool life. This grade is also used for hobbing and gear shaving operations.

Advantages

This product offers:

- ◆ *Excellent cooling properties*
- ◆ *Minimum power consumption*
- ◆ *Improved tool life*
- ◆ *Reduced pump wear*
- ◆ *Minimized wear of guide lands*
- ◆ *Boosted feed rates*
- ◆ *High surface finish*
- ◆ *Higher dimensional accuracy*

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Characteristics

The typical figures for ILOCUT 334 are given in the Characteristics table.

Characteristics	Typical Value
Appearance	Clear yellow Liquid
Relative Density @ 30°C	0.870
Kinematic Viscosity @ 40°C cSt	14
Flash Point IC (Open Cup)	150
Copper strip corrosion @ 100°C for 1 hour	Class 4
Additives	Fat + Sulphur

Not recommended for cuprous metals. Staining may occur on high nickel alloys during storage or subsequent heat treatment.

These are typical figures and do not constitute a specification.

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