



Product Data

Castrol Ilocut 3341™ Heavy Duty Neat Machining Oil

Description

This product is for deep hole drilling and trepanning operations. It is formulated with specially selected mineral oils and contain 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 3341 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

Specially recommended for deep hole drilling, boring and trepanning operations. This grade contains a heavier dosage of the EP additives which effectively lubricate the bearing pads under high pressures and temperatures encountered in high speed operations. It also extends the cutter life. Like Ilocut 334, this grade is also used for arduous high speed operations including hobbing and gear shaving even on numerically controlled machines.

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*

Castrol Ilocut 3341
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Castrol India Limited, Industrial Lubricants & Services, Rayala Towers, II Tower, V Floor, 781-785, Anna Salai, Chennai – 600 002.
Tel: +91 44 42198899 Fax: +91 44 28416305 Toll Free: 1800 - 425 - 4588 (BSNL) Help Line: 044-39019019
Email:customer.service@castrol.com



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Characteristics

The typical figures for ILOCUT 3341 are given in the Characteristics table.

Characteristics	Typical Value
Appearance	Clear yellow liquid
Relative Density @ 30°C	0.870
Kinematic Viscosity @ 40°C Cst	15
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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