



## Product Data

### Castrol Ilocut 534™

Superior Deep Hole drilling 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. In Ilocut 534 the EP property of sulphur additive is further synergised by the addition of compounds containing chlorine and phosphorous.*

*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

*A special product incorporating sulphur, chlorine, phosphorous and fat was developed to meet the continuous demand for greater cutting speeds. This grade has low viscosity and excellent EP properties which are vital in deep hole drilling and trepanning operations. This grade offers exceptional finish and at the same time gives a high metal removal rate, thus minimising production costs. High dosage of EP additives ensure a longer tool life.*

## Advantages

*These products offer:*

- ◆ *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 534 are given in the Characteristics table.*

Characteristics	Typical Value
Appearance	Clear yellow liquid
Relative Density @ 30°C	0.900
Kinematic Viscosity @ 40°C cSt	16
Flash Point IC (Open Cup)	160
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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