



CILORA 119

Neat Cutting Oil

Description; Description

Cilora 119 is an active EP neat cutting oil - a blend of high quality solvent refined mineral oil, sulphurised fat, chlorinated paraffins and elemental sulphur. It has a clear golden colour, possesses pleasantly low odour characteristics and incorporates an additive to give controlled misting properties.

The viscosity of this grade was selected to ensure adequate lubrication and low fume capability, yet permit high rates of flow. Good heat dissipation is achieved by the combination of high flow rates and the good wetting properties of the oil.

Applications; Applications

Cilora 119 is designed for use in single and multi-spindle automatics where heavy duty machining operations are carried out on medium and high carbon steels and alloy steels. It is ideal for use with most metals encountered in gear cutting and medium duty form grinding and it can also be used for some broaching and thread grinding operations.

It is recommended for a wide range of applications on a variety of tougher materials - a feature that allows the user to potentially limit the number of cutting oils employed, thus reducing ordering, storage, distribution and reclamation procedures.

Cilora 119 contains active sulphur and therefore should not be used on yellow metals.

Main Benefits; Main Benefits

- Light colour
- Low odour
- Controlled misting properties
- Wide range of applications

- Excellent tool life
 - Minimum of tool grinding and setting
 - Maintenance of good surface finish
 - Rationalisation of oil stocks
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Storage; Storage

All packages should be stored under cover. Where outside storage is unavoidable drums should be laid horizontally to avoid the possible ingress of water and the obliteration
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of drum markings. Products should not be stored above 60°C, exposed to hot sun or freezing conditions.; of drum markings. Products should not be stored above 60°C, exposed to hot sun or freezing conditions.

Health, Safety and Environment; Health, Safety and Environment

Health, safety and environmental information is provided for this product in the Materials Safety Data Sheet. This gives details of potential hazards,

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Typical Characteristics; Typical Characteristics

	Test Methods; Test Methods	Units; Units	Grade :: Grade :
			Cilora 119
Appearance			brown
Density at 15°C	ISO 3675, ASTM D1298	kg/m ³	894
Viscosity KV @ 40°C	ISO 3105, ASTM D445	mm ² /s	22
Flash Point (PMC)	ISO 2719, ASTM D93	°C	186
Pour Point	ISO 3016, ASTM D97	°C	-15
Neutralisation Number	ASTM D664	mgKOH/g	0.3
Copper Corrosion	ISO 2160, ASTM D130		4
Reichert at 1500N	Reichert	mm ²	7.5
4-Ball Weld Load	ASTM D2783	N	5000

The above figures are typical of those obtained with normal production tolerance and do not constitute a specification.

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