



Cilora 128

EP Neat Cutting Oil

Description; Description

Cilora 128 is a non-active solvent refined mineral oil containing a very high percentage of chlorinated additive, together with a fatty compound to provide excellent anti-weld and extra lubrication properties.

It also contains a special additive to reduce the staining caused by chlorine, plus an anti-wear additive for effective lubrication of coolant supply pumps.

Applications; Applications

Cilora 128 was primarily developed to meet the performance requirements of the more arduous gun drilling operations. Also to provide superior pump life particularly where vane pumps are used. Refrigeration units are fitted to some gun drilling machines to cool the oil. The use of Cilora 128 presents no problems on the copper or brass coils as it is non-active, ie contains no free sulphur.

However, its particular characteristics also make it suitable for many other machining applications on high tensile steels and heat resistant alloys, ie gear cutting, broaching, tapping and threading.

Cilora 128 can also be used to machine copper based alloys in many difficult machining operations.

Main Benefits; Main Benefits

- Permits high flow rates to be achieved, thus assisting the removal of swarf
- Good heat dissipation
- No unpleasant smell
- Anti corrosion properties between operations

- Maximum drill life
- Assists in maintaining good surface finish and accuracy
- Improved pump life
- Light colour
- Wide range of applications

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 128
Appearance			Cilora 128 yellow
Density at 15°C	ISO 3675, ASTM D1298	kg/m ³	998
Viscosity KV @ 40°C	ISO 3105, ASTM D445	mm ² /s	29
Flash Point (PMC)	ISO 2719, ASTM D93	°C	180
Pour Point	ISO 3016, ASTM D97	°C	-15
Neutralisation Number	ASTM D664	mgKOH/g	1.3
Copper Corrosion	ISO 2160, ASTM D130		1
Reichert at 1500N	Reichert	mm ²	2.8
4-Ball Weld Load	ASTM D2783	N	5600

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

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