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## Cilora 68

### Extreme Pressure Neat Cutting Oil

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#### Description; Description

Cilora 68 is a high viscosity, light coloured, active EP neat cutting oil based on a blend of highly solvent refined mineral oils. It contains a special low odour sulphurised

fatty additive, chlorinated paraffin and free sulphur giving very high load carrying and excellent anti-weld lubricating properties.

#### Applications; Applications

Cilora 68 is formulated for machining extremely tough and difficult to machine steels. Its high performance characteristics and viscosity make it suitable for severe gear cutting operations.

It can also be used in the production of large thread forms by tapping, chasing, rolling and grinding.

Cilora 68 is not suitable for the machining of yellow metals.

#### Main Benefits; Main Benefits

- Very high cutting performance
- Minimises tool setting and grinding
- Light colour for easy workpiece visibility

- Low odour for improved operator acceptability
- Assists in maintaining good surface finish
- Adheres well to tool and component

#### 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, precautions and First Aid measures, together with environmental effects and disposal of used products.; Health, safety and environmental information is provided for this product in the Materials Safety Data Sheet. This gives details of potential hazards, precautions and First Aid measures, together with environmental effects and

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### Typical Characteristics; Typical Characteristics

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	Test Methods; Test Methods	Units; Units	Grade ;; Grade :
			Cilora 68
Appearance			
Density at 15°C	ISO 3675, ASTM D1298	kg/m <sup>3</sup>	931
Viscosity KV @ 40°C	ISO 3105, ASTM D445	mm <sup>2</sup> /s	80
Flash Point (COC)	ISO 2572, ASTM D92	°C	228
Pour Point	ISO 3016, ASTM D97	°C	-9
Neutralisation Number	ASTM D664	mgKOH/g	0.5
Copper Corrosion	ISO 2160, ASTM D130		4b
Reichert at 1500N	Reichert	mm <sup>2</sup>	6.9
4-Ball Weld Load	ASTM D2783	N	7000

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

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