

# PRODUCT DATA SHEET

## **SUPERCOOL-S**

### **(SOLUBLE CUTTING OIL)**



Commonly known as 'Soluble Cutting Oil' is light viscosity super refined oil with pleasant odour, soluble in water. It is excellent medium as a coolant and lubricant while metal cutting, used as an emulsion with water.

Supercool-S is a superior quality soluble type metal working emulsifying fluid having exceptional anti corrosive & rust preventive properties. The oil is having superior hard water stability & exhibits better cast iron corrosion test result.

Supercool-S is recommended for more severe application for both ferrous & non-ferrous metals in 5 to 10% emulsion strength depending upon the severity of machining operation.

#### **ADVANTAGES**

- Exceptional anti corrosion and rust preventative.
- Stable milky emulsions in water having hardness range 400 - 800 ppm.
- Highly satisfactory dissipation & cooling properties resulting in excellent surface finishes & longer tool life.
- Does not contain ingredients harmful to operation.
- Does not decompose, retains physical properties.
- Better hard water stability with superior cast iron corrosion test results.

#### **APPLICATION**

Supercool-S is suitable for all metals & machinery operations where emulsifying oils are generally used. It is also recommended in turning, drilling, grinding boring and milling operations.



## Technical Specification

Viscosity @ 40°C CST	29.0
PH of 5% emulsion in water	7 - 9
Emulsion stability 24 hours in 400 ppm water	ok
Cash iron corrosion ( 20 : 1 emulsion 400 ppm)	pass o.k

### STEP IN SUMP MANAGEMENT

- Always add oil to water & never the other way.
- Always top up with emulsion and never with the neat oil.
- Never add water directly to the sump. Always add weak emulsion.
- Always clean the sump thoroughly before a fresh change.
- Always skim off the tramp oil from the sump on a regular basis that the coolant can breathe.
- Always use soft water. The total hardness (carbonate) should not exceed 400 ppm.
- Always dispose off spent coolant with local and etp normes.

### Recommended dilution ratios (Supercool-S:water)

For Milling, Turning	1 : 25
For Drilling, Boring	1 : 20
For Grinding	1 : 30



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