

Cutting oil - inactive ISO L-MHE

SBLm[®]-K

SBLm[®]-K is inactive low viscosity cutting oil for metalworking containing refined mineral oil, lubricating additives, high pressure (EP) additives, corrosion inhibitors and antiwear (AW) additives.

ADVANTAGES

- The use of advanced additives allows lubrication at high pressures and reduced tool wear,
- Excellent lubricating and EP properties,
- Good adhesion to metal surfaces,
- Minimal loss of oil due to removal with shavings,
- Good chip removal from the cutting zone,
- Good oxidation stability and filtrability extend product life,
- Low tendency of smoke/fog creation,
- Good anticorrosion protection properties guarantee interoperational protection.

QUALITY LEVEL

ISO 6743-7, L-MHE,
ISO/TS 12927

APPLICATION

SBLm[®]-K is applied for machining items made of aluminum alloys and non-ferrous metals in medium machining modes on single-spindle and multiple-spindle automatons. It is suitable for operations of drilling small diameter holes and large depths (deep drilling with spiral drills).

Type of processing	Grey iron	Low-alloy steels	High-alloy steels	Non-ferrous metals and alloys	Light metals and alloys
Deep drilling	**	*	-	***	***
Processing on automatons	**	*	-	***	***

*** the best, ** acceptable, * satisfactory, - not satisfactory

ADDITIVE CONTENT

Esters	Sulfur		P	Ca	Zn	Cl
	active	inactive				
+	-	+	+	+	-	+

TYPICAL CHARACTERISTICS

CHARACTERISTICS	UNITS	VALUES	METHODS
Appearance	-	clear	visual
Density at 15°C	g/ml	0,870	EN ISO 3675
Kinematic viscosity at 40°C	mm ² /s	10	ISO 3104

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Flash point	°C	min 140	EN ISO 2592
Copper corrosion (100°C/3h)	degree	1a	EN ISO 2160
Corrosion on steel	-	no	ISO 7120

Friction coefficient in the cutting zone: $\mu = 0,080 - 0,085$

STORAGE

Store in covered area. If stored outdoors, it is necessary to place the drums in a horizontal position to prevent the accumulation of water on the surface of the drum. Do not store at elevated temperatures or in locations exposed to direct sunlight, nor at the temperatures below 0°C.

All necessary instructions can be found in the product SDS. It contains the details of possible hazards, warnings and first aid measures, as well as the impact on the environment and the necessary measures for the storage and handling.

PACKING

Plastic pails of 20 L, tin drums of 180 kg and plastic container of 850 kg.

Data are orientational, manufacturer reserves the right to make changes in order to improve product quality.

