

JICHUAN NFD SOLUBLE OIL

A PREMIUM QUALITY SOLUBLE OIL FOR CUPPING & IRONING 2-PIECE METAL CANS

PRODUCT DESCRIPTION:

JICHUAN NFD SOLUBLE OIL NO.OC-1 is a specially formulated water mulsifiable metal working fluid. It is specifically formulated for service in high speed 2-piece metal can manufacturing.

TYPICAL USES:

- Used in cutting difficult to machine metals of all types.
- Recommended for cupping and blanking in the fabrication of two-piece metal cans, either aluminum or steel. Recommended water to oil ratio 5:1 through 10:1 depending on machinability rating.
- Recommended for wall ironing in the fabrication of two-piece metal cans, either aluminum or steel. Recommended water to oil ratio 30:1 through 50:1 depending on machinability ratios
- Also used in milling, boring and turning, plain drilling, sawing, and thread and form grinding of ferrous metals with a machinability ratio of 25-t00. Recommended water to oil ratio 10:1 through 20: t depending on machinability ratios.
- Commonly used in plain grinding operations at ratios between 50:1 through 100:1.

FEATURES:

- Excellent cooling ability.
- Smooth work finish provided by lubricity additive.
- Increasing tool life through balanced additive package.
- Forms stable emulsion even with hand water.
- Foam inhibited.
- Rust and corrosion inhibited for protection of machine parts and workpiece.
- Wide cutting range-from easy to machine to difficult to machine metals.

TYPICAL INSPECTIONS

GRAVITY,°API	28.20
APPEARANCE	Bright&Clear
COLOR,D-1500	4
VISCOSITY:	
SUS@100°F.	275-325

Shanghai Jichuan Trading Co.,Ltd.

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cSt@40°C.	50-60
SHELL FOUR BALL	
ON NEAT OIL	1.15MM
ON 9:1 EMULSION	0.79MM
EMULSIBIMTY	Pass
EMULSION STABILITY	Pass
FOAMING	Pass
pH 5% in DI Water	8

VALUES SHOWN HERE ARE TYPICAL AND MAY VARY

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