

# MAK SHEROL B

## Description

MAK Sherol B is premium quality soluble cutting oil blended from refined mineral oil, emulsifier and other additives. It forms extremely stable milky emulsion of the "Oil in Water" type. This oil has exceptionally high emulsion stability even with extreme hard water (400 ppm) leading to excellent tool life and finish in all metal cutting operations, where cooling is more important than lubrication. It does not decompose chemically leave objectionable odour, cause discoloration and staining.

## Application

This Soluble Cutting Oil is recommended for use in a variety of cutting operations like drilling, forming, planing, milling, sawing and on ferrous and non-ferrous materials. It is used at water to oil ratios between 20:1 and 30:1.

## Benefits

- Excellent cooling and lubrication: High wetting property enhances lubrication and helps in extending tool life.
- Low foaming tendency: Helps in maintaining continuous oil film in between the moving parts thus avoiding metallic contact.
- Stable emulsion – Helps in getting extended life and also resists bacterial growth. However, care should be taken to avoid entry of Tramp Oil and oil should be kept in circulation to extract maximum life.
- Good rust protection – Carefully selected additive protects machine parts from rusting.

## Performance Level

- IS 1115:1986 [Reaffirmed March, 2002]
- UK DEFSTAN 91-23 for oil ZX-1 specifications

## Technical Specifications

Characteristics	Test Methods	MAK SHEROL B
Appearance	--	Light brown
Ash, % by mass	ASTM D874	1.29
Copper corrosion @ 100°C, for 3 hrs	ASTM D130	1a
Flash Point, (COC), °C	ASTM D92	160
Emulsion Test, 5:1 & 20:1 ratio in water of 400 ppm hardness (as CaCo3)	IS 1448 P:68	No oil, No cream
Frothing test a) 5:1 & 20:1 ratio in 200ppm hardness (as CaCo3)	IS 1448 P:99	Passes
Thermal stability test	IS 1448 P:100	Passes

All the mentioned values are typical which may vary from batch to batch.

## Storage and Handling

- Indoor Storage is always preferable
- Barrels should be kept horizontally at 3'o'clock 9 'o clock position
- Barrels should be kept away from dusty or heated areas as much as possible
- During handling any contact with dust must be avoided

## Health and Safety

These oils are not hazardous under normal conditions of use. For further guidance appropriate Material Safety Data Sheet (MSDS) may be referred.

## Advice

For any further advice on applications or otherwise, please contact the nearest Bharat Petroleum territory office or Technical Services department at the address given below.

### **Bharat Petroleum Corporation Ltd.**

Product and Application Development Dept.  
 BPCL 'A' Installation, Sewree Fort Road, Sewree (East)  
 Mumbai -400015  
 E-mail: [MAKcustomercare2@bharatpetroleum.in](mailto:MAKcustomercare2@bharatpetroleum.in)  
 Tel No.: 022-24176351