



# Ilocut 534

High performance neat cutting oil

## Description

Castrol Ilocut™ 534 is a medium viscosity, chlorinated paraffins containing, high performance neat cutting oil.

## Application

Ilocut 534 has been designed for drilling and deep hole drilling of steels, stainless steel and difficult steel alloys such as inconel.

This product contains active sulphur and is not compatible with yellow metals.

ü ü suggested core application ü possible application, please consult Castrol representative prior to use

|                              | Cast Iron | Low alloyed steel | High alloyed steel / nickel-chromium alloys | Titanium alloys | Aluminium alloys | Yellow metals |
|------------------------------|-----------|-------------------|---|-----------------|------------------|---------------|
| Honing/<br>Superfinishing    |           |                   |   |                 |                  |               |
| Grinding                     |           |                   |   |                 |                  |               |
| Drilling                     | ü ü       | ü ü               | ü ü   |                 |                  |               |
| Broaching/Gear manufacturing | ü ü       | ü ü               | ü   |                 |                  |               |
| General machining            | ü ü       | ü ü               | ü ü   |                 |                  |               |

## Advantages

- Advanced additive technology gives high extreme pressure (EP) lubricity properties and can help to lower production costs through extended tool life
- Improved surface finish and increased cutting speeds can lead to improvement of process efficiency
- Economic product suitable for a wide range of machining applications

## Typical Characteristics

| Properties       | Standard                 | Unit               | Data  |
|------------------|--------------------------|--------------------|-------|
| Appearance       | Visual                   |                    | Amber |
| Viscosity @ 40°C | DIN 51562<br>ASTM D 445  | mm <sup>2</sup> /s | 16    |
| Density @ 15°C   | DIN 51757<br>ASTM D 1298 | kg/l               | 0.89  |
| Flashpoint COC   | ISO 2592<br>ASTM D 92    | °C                 | >150  |
| Copper corrosion | ISO 2160<br>ASTM D 130   | 3 hr at 100 °C     | 4c    |

Subject to usual manufacturing tolerances.

## Storage

To avoid product deterioration always keep the container/drum tightly sealed. Store the product in a cool, dry place away from direct sunlight. Prevent exposure to frost and avoid water ingress. For optimum product stability, it is preferable to store the product indoors between 5°C and 45 °C / 41°F and 113°F.

For more details, please refer the product safety data sheet.

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