

CASE STUDY 35

(WATER-DILUTABLE SEMI-SYNTHETIC CUTTING COOLANT)



CUSTOMER DETAILS :

A leading company in South India manufacturing shell molding from S.G.Iron and Grey Iron Castings.



OBJECTIVES FOR CONDUCTING THE TRIAL

1. No EHS Issues - Operator & Environmental Friendly.
2. Good rust protection
3. To achieve the required finish – Ra: 0.6 and improvement in visual finish
4. To reduce the cost of oil.



OPERATING / APPLICATION DETAILS:

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|------------------|----------------------|----------------------|----------------|
| 1. Machine | : Makino | 6. Cycle time | : 80secs |
| 2. Tank capacity | : 400ltrs | 7. Coolant Conc | : 4~ 5% |
| 3. Operation | : Turning, grooving. | 8. Sump life | : 6 ~ 8 Months |
| 4. Filter | : Conveyer filter | 9. Water used | : DM water |
| 5. Material | : Steel & Cast iron | 10. Component | : Casing |
| | | 11. Trial Evaluation | : 3 months |



COMPONENT VIEW



PRODUCT RECOMMENDED: HICUT 6710

TRIAL RESULTS



Achieved the required finish – Visual finish & Ra: 0.4



No EHS Issues observed - Operator & Environmental Friendly.



Cost saved ~ 10%