

S.K.S. 40 / 48

High performance cutting oils



The benefits at a glance

- ✓ Minimize friction and wear
- ✓ Increase the tool life
- ✓ Extremely low evaporation
- ✓ Chlorine-free
- ✓ Non-hazardous
- ✓ Treat material with care
- ✓ Fully synthetic



Property

Rivolta S.K.S. 40 and S.K.S. 48 are fully synthetic cutting oils for metal-cutting processes.

S.K.S. 40: is a fully synthetic high performance cutting oil. A combination of a high-grade temperature stable fully synthetic base oil which shows a low evaporation capacity together with a new additive technology give a range of performance to our product that is far superior compared to conventional cutting oils. A special material protective additivation allows the machining of nonferrous metals as well as of high temperature stable chrome nickel steel. Our fully synthetic base oil is extremely temperature stable and by this allows a cutting process with a low evaporation and a low emission.

S.K.S. 48: is a fully synthetic special cutting oil for most difficult machining operations. To a fully synthetic base oil we added extreme pressure-additives and anti-wear agents which increase the compressive strength of the oil and which improve the surface properties of the machined workpieces. Therewith one can even economically machine high-alloy steel in most difficult cutting processes.

Fields of application

S.K.S. 40: as cooling and cutting oil for metal-cutting pro-

Form	liquid
Colour	S.K.S. 40: light-yellow S.K.S. 48: amber
Odour	mild

cesses. For drilling, thread cutting, sawing, milling, turning, grinding and broaching of:

- ferrous metals, such as e.g. case-hardened steel and heat treatable steel, free cutting steel, stainless steel, chrome nickel steel, creep resistant / high temperature resistant steel, cast steel, gray cast iron, etc.
- nonferrous metals, such e.g. aluminium and aluminium alloys, copper and copper alloys, titanium and titanium alloys.

S.K.S. 48: as metal cutting oil for most difficult machining operations at high-alloy steel, stainless steel, chrome nickel steel, manganese carbon steel. Also suitable for case-hardened steel and free cutting steel. Applicable for thread cutting, drilling, rubbing, countersinking and keyway cutting.

Instructions for use

Rivolta S.K.S. 40 and S.K.S. 48 to the friction point by spray can or as bulk ware. Both products are also available in a 250 ml bottle which is very easy to use.



	Value		Norm
	S.K.S. 40	S.K.S. 48	
Density at +15 °C	0,84 g/ml	0,86 g/ml	DIN 51757
Kine. Viscosity at +20 °C	60 mm ² /s	125 mm ² /s	DIN 51562-1
Kine. Viscosity at +40 °C	30 mm ² /s	50 mm ² /s	DIN 51562-1
Flash point	+230 °C	> +180 °C	DIN EN ISO 2592
Pourpoint	-50 °C	-40 °C	DIN ISO 3016
Evaporation loss 6 h/ +200 °C	2,5 % by weight	< 2,5 % by weight	DIN 51581
Conradson carbon residue	< 0,1 by weight	-	DIN 51551
Thread cutting test Schatz-testing bench	-	17 Nm	-
M10; X 15 CrNiSi 2520 Cutting speed counter 100/min	-	420 N	-
Corrosion effect on copper	1-100 A3 corr.-grade	1-100 A3 corr.-grade	DIN EN ISO 2160