



# ORACOU P 252

## SOLUBLE CUTTING OIL MULTI-PURPOSE

### DEFINITION

ORACOU P 252 is a water-soluble, biologically-stable, microemulsion-type semi-synthetic oil that is specially formulated for machining and grinding operations of ferrous and non-ferrous metals.

### ADVANTAGES

- Is biologically-stable, which prolongs the life of basins even during extended periods of down time; possesses considerable stability in regards to micro-organisms.
- Can be used in various operations in medium-sized jobs: cutting, milling, boring, drilling, etc.
- Use for grinding, especially centreless grinding which requires lubrication.
- Silicone-free.
- Provides excellent anti-corrosion protection.
- Facilitates emulsification.
- Possesses considerable ability to quench; dilute product to 3% - 6% for the toughest jobs.
- Can be used for numerous worked metals: ferrous and non-ferrous metals, such as aluminium, copper, cast iron, titanium, stainless steel and other alloys.
- Protects against bacteria and fungus, prolonging the life of the emulsion.
- Becomes opalescent after dilution, which allows user to see working conditions effectively.
- Especially suited for computed numerically controlled work and machining centres.
- Chlorine-, sulphur-, nitrite-, and phosphate-free. Designed for application on titanium in the aeronautics industry.
- Economical thanks to its long working life and high dilution ratio.

### APPLICATION FIELDS

Specially conceived for computed numerically controlled work, machining centres, or centralised lubrication systems.

Produces excellent results in grinding carbide.

### TECHNICAL CHARACTERISTICS

#### CONCENTRATE

Density at 25°C - ASTM D 4052 .....	1,05
Kinematic density at 40°C - ASTM D 445.....	35 cSt
Flash point - ASTM D 56.....	>100 °C
Chlorine, sulphur, phosphate, nitrite content .....	none

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#### Manufacturing site and registered office

Parc Industriel de la Plaine de l'Ain - 225 allée des Cèdres - 01150 Saint-Vulbas - FRANCE

Tél. +33 (0)4 74 40 20 25 - Fax +33 (0)4 74 40 20 26 - [www.orapi-maintenance.com](http://www.orapi-maintenance.com)

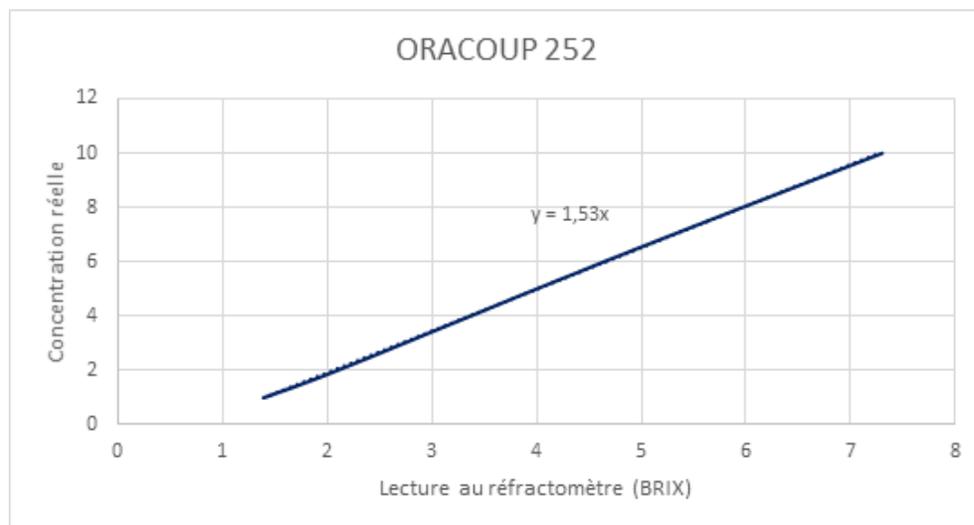
## TECHNICAL CHARACTERISTICS - continued

### EMULSION

pH diluted to 5% ..... 9.2  
 Corrosion test - IP 287/78 ..... at 5% 0 score  
 Corrosion test - CNOMO ..... at 5% 0 score

## INSTRUCTIONS FOR USE

Pour the oil into the water while mixing well.  
 Verify the emulsion using a refractometer.  
 See the graph below.



### Recommended dilution rates:

Grinding ..... 3% to 4%  
 Grinding carbide ..... < 2%  
 Turning, bar turning, drilling, sawing ..... 4% to 6%  
 Milling, threading, tapping ..... 5% to 7%

## STORAGE

Storage temperature: between +5°C and +40°C  
 Do not freeze.

## HYGIENE AND SAFETY

Contains no dangerous products; complies with current EEC standards.

## PACKAGING

5 L jerry-can	ref. 2852 J1	x 4
20 L drum	ref. 2852 O1	x 1
200 L drum	ref. 2852 U2	x 1

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