



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

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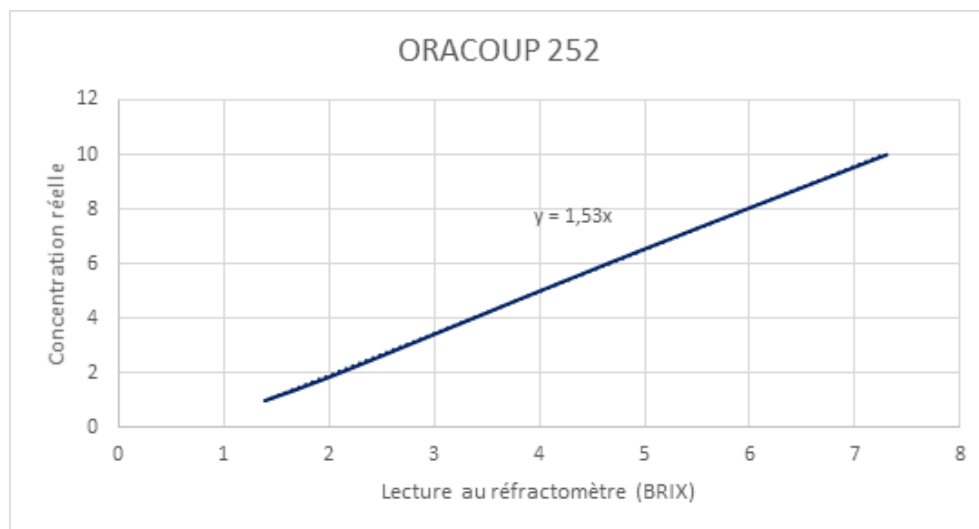
TECHNICAL CHARACTERISTICS - continued

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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