

Product Data

ZIE BROACH 17 & 32 Premium Broaching Oil

Description:

Broaching is the severest amongst the various machining operations. This is accomplished by Horizontal or Vertical Machines which broach on the internal or external surfaces of the job. Internal broaching is severer than the external broaching and the vertical operations are severer than the horizontal ones.

A Broach consists of a metal rod having a series of equally spaced teeth which progressively make deeper cuts on the job. Each cutting tooth of the broach is in contact with the job during the entire cut and each succeeding tooth is buried deeper in the cut being made. The cutting fluid used for broaching should have maximum anti-weld and extreme pressure properties in order to ensure high accuracy and finish of the job.

Zie Broach 17 is a blend of specially selected light bodied base oils and additives which helps it withstand extreme loads encountered in broaching operations. The oil is specially blended to ensure enhanced cooling to obtain smooth polished surfaces.

Zie Broach 32 has been formulated after extensive trials at customers plant. Its higher Viscosity & Flash Point enhances its load carrying ability making it suitable for other machining operations as well.

Features and Benefits:

- Prolong the life of Broaches.
- Do not pose abnormal health hazards.
- Require minimum top-up

Typical characteristics:

Characteristics	Test Method	Zie Broach 17	Zie Broach 32
Appearance	Visual	Bright and clear	Bright and clear
Density	D-1298	0.92	0.97
Kinematic viscosity, cSt at 40 °C	ASTM D 445	17.5	32
Flash point (COC), °C, min.	ASTM D 92	175	185
Chlorine		Yes	Yes
Shulphur		Yes	Yes
Fats		Yes	Yes
EP Weld Load in Kgs		1200	800

The above figures are typical figures with normal production tolerance.

Health & Safety

These oils are unlikely to present any significant health or safety hazard when properly used in the recommended application and good standards of industrial and personal hygiene are maintained.