

## TECHNICAL DATA SHEET

### CAL-CUT CI 1220

*Mineral Oil Based High Performance Neat Oil*

#### DESCRIPTION

**CAL-CUT CI 1220** is high performance neat cutting oil free of chlorine, zinc & heavy metals.

**CAL-CUT CI 1220** is having excellent wetting and lubricating properties, fortified with anti-wear and extreme pressure additives to improve cutting performance and tool life.

#### APPLICATION

**CAL-CUT CI 1220** offers improved performance on ferrous and non-ferrous materials like steel alloys, titanium alloys and non-ferrous metals.

**CAL-CUT CI 1220** is suitable for hobbing, turning, drilling, milling, sawing, reaming and more such operations, including high speed machining.

#### SPECIAL FEATURES

- Chlorine, Zinc and heavy metals free makes the product operator and environmental friendly
- Advanced additive technology gives high lubrication properties and lowers production costs through extended tool life.
- No smoke or mist, clean workplace
- High removal rate increases the productivity
- Multi-metal machining using our superior additive technology provides opportunity for product consolidation .

#### HEALTH AND SAFETY

For proper handling and storage, please refer SDS, and share the information to user. For any other information, please contact Callington representative.

The product is available in 200 Liters-Drum and 20 Liters-Pails

#### TYPICAL DATA

PARAMETERS	METHOD	TYPICAL VALUES
Appearance	Visual	Clear, yellow to amber fluid
Density @ 30 °C, g/cm <sup>3</sup>	ASTM D 4052	0.870
K. Viscosity @ 40 °C, cSt	ASTM D 445	21.00
Flash Point, COC, °C	ASTM D 92	> 170
Copper Corrosion, [3h, 100 °C]	ASTM D 130	1b

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### CALLINGTON PRODUCTS

Callington's **SYN** and **CAL-COOL ES** series are proven product for use in all metalworking applications.

Apart from above, Callington is having below product range:

**Cal-Cut series** of neat cutting oils available for all neat oil applications.

**CalGuard DW and DWP** series of Rust Preventives suitable for protection up-to 12 months

**Pro-Clean** series of cleaners suitable for removing different soils from components and meet the Millipore requirement

**Evap-Lube** series of stamping oils

**Eco-Tap Spray** for drilling, tapping, cutting

### COOLANT MANAGEMENT

- Neat oils are relatively maintenance free fluids when compared with water miscible fluids
- However neat oils shall be filtered on regular basis, depending on chips accumulation, to remove metal fines
- The metal fines may react with cutting fluids and act as catalyst for oxidation
- The presence of metal fines in cutting fluid may also cause surface finish issues
- It is always recommended to avoid mixing of lube oils / hydraulic oils in the cutting fluid, as the contamination may deteriorate the performance of cutting fluid.

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