

# 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
- Suitable for minimum quantity lubrication
- Gentle to material
- Fully synthetic



## Properties

**Rivolta S.K.S. 40** and **Rivolta 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.

**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 processes. 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 **Rivolta 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.

Suitable application devices and accessories in our [accessories brochure](#).

	S.K.S. 40	S.K.S. 48
<b>Form</b>	liquid	
<b>Colour</b>	light-yellow	amber
<b>Odour</b>	mild	



**Available in:**

- 250 ml bottle (PU 12 pcs.)
- 400 ml spray can (PU 12 pcs.)
- 10 l can

	Value		Norm
	S.K.S. 40	S.K.S. 48	
<b>Density at +15 °C</b>	0,84 g/ml	0,86 g/ml	DIN 51757
<b>Kine. Viscosity at +20 °C</b>	60 mm²/s	125 mm²/s	DIN 51562-1
<b>Kine. Viscosity at +40 °C</b>	30 mm²/s	50 mm²/s	DIN 51562-1
<b>Flash point</b>	+230 °C	> +180 °C	DIN EN ISO 2592
<b>Pourpoint</b>	-50 °C	-40 °C	DIN ISO 3016
<b>Evaporation loss 6 h/ +200 °C</b>	2,5% by weight	< 2,5% by weight	DIN 51581
<b>Conradson carbon residue</b>	< 0,1% by weight	–	DIN 51551
<b>Thread cutting test Schatz-testing bench M10; X 15 CrNiSi 2520 Cutting speed counter rpm</b>	–	17 Nm / 420 N	–
<b>Corrosion effect on copper</b>	1-100 A3 corr.-grade	1-100 A3 corr.-grade	DIN EN ISO 2160