

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
Form	liquid	
Colour	light-yellow	amber
Odour	mild	



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



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