



## Emulsichem Lubricants Pvt. Ltd.

### CASE STUDY OF EMULKUT-1872

Date	02/01/2007
Name of the organization	Tata Motors Ltd.
Address	MIDC, Pimpri 411018.
M/c. no. & make for study	IGBH-818- C-8
Type of operation	Rear boring / Front boring
Material removal	0.4 - 0.5 mm
Thickness of sheet	1000 lit.
Type of material	Aluminum
Type & make of tools used	Carbide
Recommended product	EMULKUT-1872
Date of charging coolant	28/09/2006
Dilution (water : oil)	1 : 20
Compared with existing product	Cottola

### OBSERVATIONS & COMMENTS

1] Trial date-29/09/2006
2] Bath Life-Assured six months with filtration of coolant after every 2 months.
3] Coolant filter date-30/11/2006
4] Total oil consumption for 3 months - 50 lit. For initial bath charging +55 lit for Topping up Total = 105 lit. * Per month avg.oil topping up consumption for 1 M/c : 18 lit.
5] Surface finish-Ok, Ra Value- within specified range.
6] Antirust & oxidation properties- Ok, No black spot or pit mark on component observed.
7] Any mechanical maintenance problem - No.
8] Flashing properties-M/c area remains clean with all chips carried away to filter & converse.
9] Operator comfort-No foul smell, even if M/c remain non operational for 4-5 days.
10] Tool life-tool life remains same as compared to cottola. For 72 (F) & 57(R) 260 to 280 no. of components per resharp tool.