



Emulsichem Lubricants Pvt. Ltd.

CASE STUDY OF LAVISA SUPER-90

Date	01/10/2006
Name of the organization	Bharat Forge Ltd.
Address	Mundhwa, Pune.
M/c. no. & make for study	3151, Moutch
Type of operation	Turning, threading
Material removal	NA
Thickness of sheet	NA
Type of material	CI
Type & make of tools used	Inserts
Recommended product	Lavisa Super-90
Date of charging coolant	August 1999
Dilution (water : oil)	1 : 20
Compared with existing product	Newly installed line in 1999

OBSERVATIONS & COMMENTS

- Knuckle's turning & threading operation are done on Motch Machines.
- Sustain tremendous heat generated during heavy turning operation.
- Lavisa Super-90 gave best cooling performance with low evaporation rate.
- No foul smell even if M/c remains idle on weekly off.
- No rust observed for at least 48 hrs.
- Bath life observed 6 month for over a period of 7 years.



Emulsichem Lubricants Pvt. Ltd.

CASE STUDY OF LAVISA SUPER-90

Date	01/02/2007
Name of the organization	Bharat Forge Ltd.
Address	Mundhwa, Pune.
M/c. No. & make for study	Landis
Type of operation	Grinding operation
Material removal	0.15 mm per side face & 0.500 mm on Ø
Thickness of sheet	NA
Type of material	Forged steel
Type & make of tools used	Grinding wheel (Slip Naxos)
Recommended product	Lavisa Super-90
Date of charging coolant	August 2000
Dilution (water : oil)	1 : 20
Compared with existing product	NA
Final finish achieved	0.8µ Ra
Dressing frequency	Excellent (3 journals per dressing)

OBSERVATIONS & COMMENTS

The Product Lavisa Super-90 is the best product for grinding operation. Due to the product usage many advantages accomplish. For e.g. due to the very flushing action of the product there is no accumulation of grinding dust on the Grinding wheel. The dressing frequency reduces drastically and very good surface finish achieved i.e. in the range of 0.8 micron Ra. value. The bath life observed was very good, anti-rust properties achieved are very good.