



Emulsichem Lubricants Pvt. Ltd.

CASE STUDY OF LAVISIA SUPER-90

Date	01/01/2007
Name of the organization	Cooper Foundry Pvt. Ltd.
Address	MIDC, Satara
M/c. no. & make for study	03, Mazak
Type of operation	Turning & rough grinding
Material removal	2 to 3 mm
Thickness of sheet	NA
Type of material	Gray cast iron
Type & make of tools used	Drillco-Seco inserts
Recommended product	Lavisa Super-90
Date of charging coolant	25/03/2006
Dilution (water : oil)	1 : 20
Compared with existing product	Symcool-86

OBSERVATIONS & COMMENTS

- Bore water (Hardness 650ppm).
- Lavisa Super-90 mixed in hard water easily and uniformly.
- As compared to existing oil finish looks better and no fuming observed, indicating good cooling properties. Heavy job cooled faster.
- Machine gets clean and non-sticky.
- No rust observed on job, even after 48 hours.
- Insert life increased. With existing oil they were getting 3 jobs per insert, after using Lavisa Super 90 they got 5 jobs per insert.
- Due to emulsions translucency, operation can be viewed clearly. Less topping up of oil required.