



# MAK SHEROL B

Superior multipurpose soluble metalworking fluid with excellent cooling, lubricity and rust protection

MAK Sherol B is a premium quality soluble cutting oil blended from mineral oil and special additive to provide superior tool life and other benefits. It has excellent emulsion stability with hard water.

**Applications:**

MAK Sherol B is developed with a high mineral oil content for a variety of metal cutting operations where cooling is important. This high performance soluble oil is designed for general machining like drilling, planning, milling, sawing of ferrous metals.

Recommended Use	Cast Iron	Alloy Steel	Carbon Steel	Al. Alloy	Yellow Metals
Grinding	--	--	--	--	--
General Machining	√√	√√	--	√	--
Drilling	√√	√√	--	√	--

√√ Main applications, √ Check with supplier

**Performance/ Benefits:**

**High Lubricity** – provides excellent lubricity and surface finish. Extends tool life.

**High Emulsion Stability** – readily emulsifies to form stable milky emulsion (oil in water type, water hardness 400 ppm) and does not decompose easily. Resists bacterial growth.

**Low Foaming Tendency** – allows high pump pressures and helps maintaining continuous oil film between moving parts. Compatible with soft water.

**Good Rust Protection** – for both machine tools and work pieces.

**Chlorine and Phenol Free** – environmental requirements.

**Concentration:**

The type of machining, the hardness of water and the corrosion protection required decide the concentration. It is typically used at 3% to 5% concentration. Refractometer factor is 1.0.

**Specification:**

- IS 1115:1986 (Reaffirmed 2013)

**Typical Physico-Chemical Data: MAK Sherol B**

Characteristics	Method	Value
Colour, Oil	Visual	Brown
Appearance, Oil	Visual	Clear
Colour, Emulsion	Visual	Milky White
Copper Corrosion, 100°C, 3 hrs.	ASTM D130	1a
Emulsion Test, 5:1 & 20:1 ratio in water of 400 ppm hardness (as CaCO <sub>3</sub> )	IS 1448 P:68	No oil, no cream
Frothing Test, 5:1 & 20:1 ratio in water of 200 ppm hardness (as CaCO <sub>3</sub> )	IS 1448 P:99	Passes (no froth)
Thermal Stability Test	IS 1448 P:100	Passes
Refractometer Factor		1.0
pH, at 5% in distilled water	--	9.3

**Additive:**

EP	Phenol	Sulphur	Amines	Chlorine	Nitrites
--	--	--	√	--	--

**Storage & Handling:**

The product should be stored inside. Keep it properly sealed to avoid contamination. Avoid freezing. Shelf life is 2 yrs. under protected storage conditions.

**Health & Safety:**

It is unlikely to be hazardous when properly used in recommended applications. Contamination of the coolant from other oils, greases, chemicals, dirty water etc. can occur during the use. It should be avoided. Regular monitoring of the in-use product is recommended.