



# SHELL SITALA™ OIL C 630

## Heavy duty soluble oil

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### Product Description

Shell Sitala™ Oil C 630 is a, heavy duty, chlorinated, emulsifiable cutting fluid with excellent hard water stability. Shell Sitala™ Oil C 630 combines the lubricity of cutting oils with the excellent cooling and anti-weld properties of EP containing soluble oils. The residual oily film of the product offers in-process corrosion protection of machined parts.

Shell Sitala™ Oil C 630 was developed for most severe machining operations such as broaching, threading, tapping and hobbing of both ferrous and non-ferrous metals. It gives excellent results on a variety of materials where ordinary soluble oils fail.

Shell Sitala™ Oil C 630 is equally suitable for large central systems as well as for individual sumps. Recommended concentration ratios are: General machining – 2% to 5%; Tapping and threading – 4% to 7%; Broaching and other severe operations – 10% to 20%.

### Applications

- general machining
- tapping and threading
- broaching and other severe operations
- can be used in single machines or in central systems

For proper mixing, always add oil to water with sufficient agitation to form a milky emulsion.

Shell Sitala™ Oil C 630 should be stored between 40°F and 100°F in dry conditions.

**DO NOT SUBJECT TO FREEZING TEMPERATURES AS PRODUCT COULD BECOME UNUSABLE.**

### Features and Benefits

- excellent lubricity helping to extend tool life
- stable in storage and during use helping to minimize downtime
- formulated to be low foaming helping the operator to view operation
- free of nitrites or phenols

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### Typical Properties of Shell Sitala™ Oil C 630

	Test Method	
Product Code 55 gallon drum 5 gallon pail		5064184 -----
Appearance	Visual	Light brown, transparent liquid
Flash Point, °F (concentrate)	D 92	>300
Chlorine		Present
Specific Gravity		0.95

### Concentration by Refractometer

The concentration of Shell Sitala™ Oil C 630 can be determined by using a refractometer.

Reading	% Concentration	Water: Product
1.2	1	99:1
2.3	2	49:1
3.5	3	32:1
4.7	4	24:1
5.9	5	19:1
7.0	6	16:1
8.2	7	13:1
9.4	8	12:1
10.5	9	10:1
11.7	10	9:1

### Handling & Safety Information

Product should be stored in a clean and dry environment which is maintain and 40°F and 100°F.

For information on the safe handling and use of this product, refer to its Material Safety Data Sheet <http://www.shell-lubricants.com/msds/>. If you are a Shell Distributor, please call **1+800-468-6457** for all of your service needs. All other customers, please call **1+800-840-5737** for all of your service needs. Information is also available on the World Wide Web: <http://www.shell-lubricants.com/>.