

Cooling Oil Specifications for Coolant Systems for KAPP NILES Gear Grinding Machines

Following specifications have to be met:

- Kin. viscosity at 40°C: min. 5 – max.13 mm²/sec;
(older machine models with hydrostatic bearings require a viscosity of 10-18 mm²/sec)
- Flashpoint >160°C;
- Copper corrosion class 1 according to DIN51759 at least at 50°C. It is also necessary to specify the copper corrosion class at 100°C;
- Pass through 5-10 micrometer fine filter;
- Electrical conductivity ≥ 3000 pS/m;
(certain Kapp models can accept a lower electrical conductivity)
- Heavy metals are not permitted in cooling oil;
- Exercise due diligence when switching to and mixing different oil types;

Please note that KAPP NILES has not done performance tests with oils and does therefore not make any guarantees as to how any particular oil may impact workpiece quality or quantity, grinding burn, damages to machine or tools, or any health impact on personnel.

Last updated: September, 2018

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