

Broaching is the severest amongst the various machining operations. This is accomplished by Horizontal or Vertical Machines which broach on the internal or external surfaces of the job. Internal broaching is severer than the external broaching and the vertical operations are severer than the horizontal ones.

A Broach consists of a metal rod having a series of equally spaced teeth which progressively make deeper cuts on the job. Each cutting tooth of the broach is in contact with the job during the entire cut and each succeeding tooth is buried deeper in the cut being made. The cutting fluid used for broaching should have maximum anti-weld and extreme pressure properties in order to ensure high accuracy and finish of the job.

**Divyol Broaching Oil No.1** is a blend of specially selected light bodied base oils and additives which helps it withstand extreme loads encountered in broaching operations. The oil is specially blended to ensure enhanced cooling to obtain smooth polished surfaces.

**Divyol Broaching Oil No. 32** has been formulated after extensive trials at customers plant. Its higher Viscosity & Flash Point enhances its load carrying ability making it suitable for other machining operations as well.

**Divyol Broaching Oils offer the below mentioned Benefits:-**

1. Prolong the life of Broaches.
2. Do not pose abnormal health hazards.
3. Require minimum top-up

**Typical Specifications of Divyol Broaching Oils :**

Characteristics	Test Methods	DIVYOL BROACHING OILS	
		No.1	No.32
Appearance	Visual	Bright & Clear	Bright & Clear
Density	D-1298	0.92	0.97
Flash Point COC°C	D-92	175	185
Viscosity cSt @40°C	D-445	17.5	32
Chlorine	--	YES	YES
Sulphur	--	YES	YES
Fats	--	YES	YES
EP Weld Load KG's	--	1200 kg	800 kg

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Disclaimer: Gandhar makes no warranties, representation or conditions of any kind expressed or implied for use with respect to these products. Final determination of suitability of the product for the application contemplated by the users is solely their responsibility.



**QMS 9001:2015, EMS 14001:2015, OHSAS 18001:2007, NABL Accreditation, GMP Certified and Government Recognised Three Star Export House**

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