



**SHELL FENELLA OIL D 605**  
*SHELL Drawina Oil 23 (Previous name)*

**Metal Working**  
**Neat Drawing Oil**

- Chlorine free
- Low aromatic content
- Heavy metal free
- Low evaporation
- Low mist

**APPLICATIONS**

Shell Fenella Oil D 605 is a special heavy duty oil for stamping, drawing, deep drawing, bold & screw drawing and thread rolling operations.

The very high content of chlorine-free EP-additives guarantees a long tool-life even on machining steels of very high tensile strength and material with low carbon content can be used until thickness up to 5 mm. Shell Fenella Oil D 605 can also be used for removal operations.

**CHARACTERISTICS**

Shell Fenella Oil D 605 is based on specially refined mineral oil and contains a combination of chemically active and polar additives.

The additives are selected to provide the oil with particularly high load-carrying properties. In this way long tool lives and excellent surfaces of the machined workpieces are achieved.

Shell Fenella Oil D 605 discolours yellow metals.

**TYPICAL PHYSICAL CHARACTERISTICS OF SHELL FENELLA OIL D 605**

	Unit	Method	SHELL Fenella Oil D 605
Density at 20°C	kg/dm <sup>3</sup>	ASTM D 1298	0,930
Kin. viscosity	mm <sup>2</sup> /s	ASTM D 445	
at 20°C			157
at 40°C			55
at 100°C			7,3
Flash point COC	°C	ISO 2595	190
Cu Corrosion			4C
Colour			Brown

These characteristics are typical of current production.

Whilst future production will conform to Shell's specification, variation in these characteristics may occur.

**REMARKS**

**-Technical Support:**

Shell Application Engineering department can provide more detailed advice concerning Shell Fenella Oil D 605.

**-Health and Safety**

More information you will find in the material safety data sheet.

**-Storage**

- Recommended temperature: 5 - 40 °C
- Storage time: 3 years
- Storage class (VCI-concept): 10