

MCM Soluble Cutting Oil Series

High Quality Water Miscible Cutting Oil

DESCRIPTION

MCM Soluble Cutting Oil series is an additive water miscible cutting oil. It is a blend of highly refined paraffinic base oil and additives to keep the good emulsion stability as well. It is free of nitrite and PTBB (Para ter-butyl Benzoic Acid) and contains no hazardous substances. The effectiveness of the microbial attack resistance properties of the substances avoid the uncontrolled growth of bacteria, yeast and fungi.

The Soluble series produces good emulsion stability in hard water quality up to 400 ppm CaCO₃. To prepare the good emulsion, always add the product into water. It is not allowed to add inverse.

The Soluble series are MCM CUTOIL-451, MCM CUTOIL-452 and MCM CUTOIL-453

ADVANTAGES

- Powerful lubrication film created under EP condition may extend the tool life and always produce fine surface finish.
- Corrosion protection.
- Prolong the tank side life from microbial attack.
- Good cleaning ability.
- Low foaming tendency.
- Hard water resistance.

TYPICAL PROPERTIES

Data (typical value)			
Parameter	MCM CUTOIL-451	MCM CUTOIL-452	MCM CUTOIL-453
Appearance	Light brown Liq.	Light brown Liq.	Light brown Liq.
Odor	spesific	Apple like	pleasant
Viscosity (@ 25 C - cps) ASTM D2983	> 25.0	> 25.0	> 25.0
pH (5% soln) DIN 51369	8.5 – 9.5	8.5 – 9.5	8.5 – 9.5
Density (15 C- kg/l) ASTM D1070	> 0.86	> 0.86	> 0.86
Rus protection on cast iron chips 5% soln – ASTM D4627 – 97	Good	Good	Good
Chlorine, Sulphur, ester	N/A	N/A	present

APPLICATION

MCM CUTOIL-451 is designed for all severe machining operations on ferrous and non-ferrous metals.

MCM CUTOIL-452 is designed for all severe machining operations on ferrous and non-ferrous metals specially for machining operation in yellow metal.

MCM CUTOIL-453 is designed for all severe machining with moderate to heavy duty operation on ferrous and non-ferrous metals.

HOW TO USE

Recommended dosage for MCM CUTOIL -451, MCM CUTOIL -452 and MCM CUTOIL -453:

Operation	Aluminium materials	Cast iron materials
Cutting	5 – 12 %	5 – 8 %
Grinding	3 – 5 %	3 – 5 %

PACKAGING

MCM Soluble Coolant Series are available in 200liters/stainless steel drum and 1000 liters/tote.