

JICHUAN PIRANHA CHLORINE-FREE

DARK CUTTING OIL D-20 CF

AN ENVIRONMENTALLY FRIENDLY HEAVY DUTY CUTTING OIL FOR
DEEP HOLE DRILLING

PRODUCT DESCRIPTION:

JICHUAN PIRANHA DARK CUTTING OIL D-20 CF is a specially formulated cutting oil which provides superior performance to oils which contain chlorine. Provides extra anti-weld properties for good surface finish and maximum tool life. Contains mist suppressant to prevent fogging. Low viscosity permits rapid settling of small metal chips and allows high production rates in high speed operations.

TYPICAL USES:

- Broaching operations where light cuts are desired.
- Used for deep hole drilling, forming and trepanning of ferrous and ferrous alloys with 30-80% machinability.
- Other cutting operations where speed of operation requires a lower viscosity oil than JICHUAN DARK CUTTING OIL D-20 CF.
- NOT RECOMMENDED for non-ferrous metals.

FEATURES:

- Extended tool life.
- Low viscosity allows high production rates in high speed operations.
- Anti-mist to control oil fog in high speed operations.
- Extra anti-weld additive permits machining tough metals such as stainless steels.
- Chlorine-free nature of this oil makes it readily disposable.
- Dyed green for easy identification.

TYPICAL INSPECTIONS

GRAVITY,°API	24.7
FLASHPOINT,°F.	320
COLOR	GREEN
VISCOSITY:	
SUS@100°F.	105
cSt@40°C.	19.45
ACTIVESULFUR,WT.%	4.5

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FATTYOILS,WT. %	11.0
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VALUES SHOWN HERE ARE TYPICAL AND MAY VARY

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