



## PRODUCT BULLETIN

### SPEC CUT 20

#### Metal Working Lubricant

##### General Description

**SPEC CUT 50** is a soluble oil concentrate specially designed to be a general purpose, multi-functional fluid for most ferrous and non ferrous materials and operations as diverse as cylindrical grinding, ID broaching and gear hobbing. **SPEC CUT 20** provides extended sump life while reducing carry off and leaves a fluid oily residue to prevent sticky ways and chunks. It is effective in some types of screw machines as a replacement for straight cutting oil and has EP additives to reduce chip welding and mechanical lubricity for good performance on soft gummy materials.

##### Application

Always add **SPEC CUT 20** concentrate to the water with continuous stirring. NEVER THE REVERSE. Do not premix richer than 3 parts water to 1 part **SPEC CUT 20** concentrate (3:1). Premixing the initial charge and/or makeup solution outside of the machine sump is recommended. Do not add **SPEC CUT 20** concentrate directly to the working solution in the machine tool.

<i>Light Duty Machining &amp; Grinding:</i>	5%
<i>Moderate Duty Machining:</i>	5%-7%
<i>Heavy-Duty Machining:</i>	7%-10%
<i>Very Heavy-duty Machining:</i>	10%-20%
<i>Design Concentration Range:</i>	5%-20%

##### Physical Properties

Color	Greenish Liquid
Odor	Mild Solvent
Specific Gravity	.93 - .96
pH	9 - 10
Flash Point	> 300/F
Boiling Point	> 250/F
Freezing Point	< 32/F

##### Availability

**SPEC CUT 50** is available in UN approved 5 gallon pails, 55 gallon drums and bulk quantities.

##### Handling

Observe warning label on containers. Normal precautions for industrial chemicals apply.