



PIRANHA

CLEAR CUTTING OIL C-31

HEAVY DUTY - ACTIVE - TRANSPARENT CUTTING OIL



Product Description: PIRANHA CLEAR CUTTING OIL C-31 is a transparent cutting oil developed from selected naphthenic base stocks plus active sulfur, chlorine and fatty oils. The unique combination of chlorine, sulfur and fat provides the extreme pressure properties and lubricity required for the most difficult machining operations. Similar to LSC Dark Cutting Oil D-15 in extreme pressure properties and machinability characteristics, but the transparency of this oil permits operator to better see work piece being cut.

Features:

- Transparent Heavy Duty Cutting Oil - Permits operator to see work piece being cut.
- One oil satisfies 80% of all cutting operations reduced inventory.
- Provides smooth surface finish.
- Reduces tool/work piece temperature.
- Extends cutting tool life.
- Anti-mist properties.

Typical Uses:

- A transparent cutting oil recommended for all difficult machining on difficult to machine ferrous and ferrous alloys.
- Used in broaching, heavy duty threading, tapping, gear shaving, boring, thread and form grinding and thread rolling of ferrous and ferrous alloys with machinability ratings of over 70% to below 40%.
- Also used in reaming, gear cutting and plain drilling of hard carbon and alloy steels with machinability rating of 50% to below 40%.

NOT RECOMMENDED FOR NON-FERROUS METALS SUCH AS ALUMINUM, COPPER OR BRONZE AS THIS ACTIVE CUTTING OIL WILL STAIN THESE METALS.

Typical Specifications:

PARAMETERS

TYPICAL RESULTS

Gravity, ° API	20.5
Flash Point, °F.	335
Color, D-1500	L3.0
Viscosity:	
SUS@100°F.	205
cSt. @ 40° C.	38.5
Active Sulfur, Wt. %	2.2
Chlorine, Wt. %	2.4
Fatty Oils, Wt. %	4.0

**NOTE: THIS PRODUCT IS DARKER DUE TO NEW STATE OF THE ART TECHNOLOGY
VALUES SHOWN HERE ARE TYPICAL AND MAY VARY**