



Technical Product Information

# PIRANHA

## DARK CUTTING OIL D-20

A HEAVY DUTY CUTTING OIL FOR DEEP HOLE DRILLING



**Product Description:** PIRANHA DARK CUTTING OIL D-20 is a specially formulated low viscosity naphthenic base oil fortified with active sulfur, chlorine, and fat to provide 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.

### 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.

### 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 PIRANHA DARK CUTTING OIL D-15.

**NOT RECOMMENDED FOR NON-FERROUS METALS.**

### Typical Specifications:

#### PARAMETERS

#### TYPICAL RESULTS

Gravity, ° API	22.4
Flash Point, °F.	340
Color, D-1500	D8
Viscosity:	
SUS@100° F..	93
cSt. @ 40° C.	17.5
Active Sulfur, Wt. %	4.5
Chlorine, Wt. %	2.9
Fatty Oils, Wt. %	11.0

VALUES SHOWN HERE ARE TYPICAL AND MAY VARY