



Peak Oil

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TECHNICAL DATA

Clearcut TC2, TC21, TC32 & TC51 Inactive Neat Cutting Oils



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Clearcut TC2, TC21, TC32 & TC51

Inactive Neat Cutting Oils

A range of neat cutting oils formulated from specially selected base stocks fortified with varying combinations of performance enhancing lubricity improvers coupled with non-active sulphurised and chlorinated extreme pressure additives, offering products to accommodate a wide range of arduous machining operations.

The carefully balanced lubricity compounds coupled with selected sulphurised fatty esters and chlorinated extreme pressure additives combine to produce effective machining lubricants of the non-active type offering excellent multi-service ability.

This heavily fortified range extends tool life and surface finish by effectively reducing frictional heat, providing improved flushing and penetration collectively providing excellent anti-weld and boundary characteristics.

Note: These grades are based on controlled release sulphur additives and in certain operations could promote staining of yellow metals.

Performance Benefits

- ◆ **Clearcut TC2** - Medium viscosity oil formulated as a cost effective product where free cutting materials are involved. (Chlorine Free)
- ◆ **Clearcut TC21** - developed for bar and chucking automatics, gear cutting, tapping and screw cutting on medium tensile alloys and carbon steels
- ◆ **Clearcut TC32** - developed for similar applications as Clearcut TC21 but to accommodate high tensile materials including stainless and heat resisting alloys
- ◆ **Clearcut TC51** - for use in single and multi spindle automatics where heavy-duty machining operations are carried out on medium to heavy-duty carbon and alloy steels. It is also ideally suited for gear cutting, grinding, broaching and thread grinding operations



Batoyle Freedom Group

Lubricants of Excellence

Typical Physical Characteristics

Clearcut	TC2	TC21	TC32	TC51
Specific Gravity @ 15°C	0.864	0.879	0.896	0.882
Viscosity @ 40°C (cSt)	20.3	23.1	19.7	22.7
Viscosity @ 100°C (cSt)	4.0	4.3	3.9	4.1
Closed Flash Point °C	>200	>200	>200	>200
Appearance	Dark Brown Liquids			

Health and Safety

These products are mineral oil based and should be handled according to good standards of industrial hygiene. For further detailed health and safety information please consult the material safety data sheet, available on request.

Storage

Drums should be stored on their sides in a clean, dry place and protected from extremes of temperature, store >5°C.

The information given is correct to the best of our knowledge. It is offered in good faith but without guarantee as the conditions and methods of use of our products are beyond our control.