

PRODUCT INFORMATION

ANGLER

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AccuCut 1940

DESCRIPTION

AccuCut 1940 is a dark red- brown cutting oil, extremely light in viscosity. It is highly compounded with mixed fats for extra lubricity which helps establish the necessary fluid film between carbide wear pads (gun drill) and the work and helps reduce the heat generated by tool to chip friction. These fats also give superior metal wetting so essential for carrying the active chemicals of the oil to the point of tool contact. Both active sulfur and chlorine are abundantly in **AccuCut 1940** as the chemical agents to prevent chip welding to the tool. The low viscosity of this cutting oil assures fluid penetration to the tool point, rapid heat transfer to cool and the work and adequate flushing of chips. **AccuCut 1940** resists foaming under pressure so that cooling and flushing characteristics are constant.

APPEARANCE

AccuCut 1940 is primarily recommended for trepanning, gun drilling, and other deep hole drilling operations requiring pressurized systems because of its extraordinary heavy compounding, it has also been used successfully on tough automatic screw machine and turret lathe jobs.

TYPICAL DATA

Appearance	Dark red brown liquid
Density @ 60 F, lbs. /gal.	7.53
Specific Gravity @ 60/60 F	0.904
Viscosity @ 100°F SUS	97
Color, ASTM	8.0
Flash Point, COC, F	310
Pour Point, F	25
Sulfur Content, % wt.	3.7
Chlorine Content, % wt.	10.8
Saponification No., mg KOH/ g	30.4

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