

TECHNICAL DATA SHEET

PROCUT 65 LIGHT CUTTING AND GRINDING OIL

PROCUT 65 is a low viscosity, light cutting oil containing active sulfur. In addition, this oil contains a synergized fatty additive that has proven itself far superior to previous fatty oil technology.

Applications

PROCUT 65 has a combination of active sulfur and wetting agents that provide excellent extreme pressure properties when cutting, gun drilling, deep hole drilling, threading, and tapping.

Recommendation for Use

PROCUT 65 is used neat as supplied. Due to the content of active sulfur the oil may discolor yellow metals.

Additional Product Data

Product should be stored under cover in clean, dry conditions and protected from frost. Recommended storage temperature is between 5°C and 35°C.

Benefits

- Free of heavy metals
- Excellent oxidation stability
- Good tool life and improved surface finish
- Light color and odor
- High flushing power and detergency

Health, Safety and Handling

Please consult the Safety Data Sheet (SDS) for information on storage, safe handling and disposal. The conditions or methods of handling, storage, use and disposal of the product are beyond our reasonable control - we assume no liability for any ineffectiveness of the product or any injury or damage, arising out of or in connection with these conditions.

Properties

PROPERTY	TYPICAL VALUE	UNIT
Appearance	Clear Amber Liquid	
Specific Gravity	0.87	
Kinetic Viscosity at 40°C	13	cSt
Flash Point	154	°C

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TECHNICAL DATA SHEET

GARIA® 601 M-12

NEAT CUTTING OIL

GARIA® 601 M-12 is based on hydro treated mineral oil with low aromatic content. A combination of polar, extreme pressure and anti-wear additives provide the oil with high load carrying properties. The oil provides good surface finish of the machined work pieces.

GARIA® 601 M-12 contains active sulfur content the oil may discolor yellow metals.

Applications

GARIA® 601 M-12 is recommended for machining of high alloyed steels, stainless, heat resistant or austenitic steels and aluminium or magnesium alloys.

GARIA® 601 M-12 gives excellent results with many difficult operations such as deep-hole drilling, tapping, shaping or shaving of gears.

Recommendation for use

Prior to making any fresh fill, we highly recommend full cleaning of all system components which will be in contact with the oil.

Advice for keeping optimal oil performance and longer oil sump life:

- Avoid water contamination.
- Minimize pollution with aqueous metalworking coolants or cleaners.
- Minimize pollution with tramp-oil (hydraulic oils, slideway oils, etc.....).
- Use proper filtration unit to remove swarf and chips.
- Avoid overheating.

*Please consult a Quaker Houghton representative for any additional information.

Benefits

- Free of Chlorine
- Mild odor
- Free of heavy metals (zinc free)
- Excellent lubrication properties

Health, Safety and Handling

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This product has a recommended shelf life of: 24 months

Properties

PROPERTY	TYPICAL VALUE	UNIT
Appearance / Colour	Clear Amber	[-]
Viscosity	12	mm ² /s @ 40°C
Density	850	kg/m ³ @ 20°C
Flash point (COC)	175	°C
Pour point	-18	°C
Copper corrosion	4c	ASTM D 130

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TECHNICAL DATA SHEET

QUAKERCUT® 010 EP MACHINING AND GRINDING NEAT OIL

QUAKERCUT® 010 EP is a superior performance neat cutting oil based on advanced ester technology from renewable raw materials. It is designed for aggressive metalworking operations in multi-metal applications.

Applications

High polar additives provide optimal wetting and lubricating properties ensuring high surface finish quality and improved tool life. The product is intended to be used neat.

Health and Safety Benefits

Mineral oil based cutting oils with viscosities below 20 cSt must be classified by law as "May be fatal if swallowed or enters airways" and must show the GHS warning pictogram on the SDS and product label (Aspiration Hazard). The 100% natural, renewable esters used in the QUAKERCUT® XP and EP series are totally free of the Aspiration Hazard warning. Likewise, the much higher flash point of these natural esters also provides a higher level of safety and worker health benefits.

OPERATIONS		MATERIALS	
Turning	●	Cast-Iron	●
Milling	●	Steel	●
Drilling	●	High alloy steel	●
Deep hole drilling	●	Stainless steel	●
Tapping-threading	●	Aluminum alloys	●
Reaming	●	Aero Aluminum alloys	●
Broaching	○	Copper alloys	●
Sawing	○	Titanium	●
Grinding	●	Carbide tool	●

● = Main Application ○ = Possible Application

Benefits

- Mineral oil free neat oil technology, sourced from renewable resources
- Long tool life resulting in increased productivity
- Higher flashpoint (410°F) than typical mineral oil based products for improved plant safety
- Low consumption and low mist

Health, Safety and Handling

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Properties

PROPERTY	TYPICAL VALUE	UNIT
Appearance	Clear Amber	
Density at 15°C	7.44	lbs/gal
Pour Point	-8	°C
Flash Point via COC	210 410	°C °F
Copper Corrosion	1b	
Viscosity at 40°C	11	cSt



QUAKERCUT® 010 EP

MACHINING AND GRINDING NEAT OIL

Fluid Maintenance

Prior to making any fresh system charge, Quaker Houghton highly recommends full cleaning of all system components which will be in contact with the QUAKERCUT® 010 EP.

Advice for keeping optimal product performance and extend sump life:

- Avoid water contamination
- Minimize contamination with aqueous metalworking coolants and cleaners
- Minimize contamination with tramp oils
- Use/maintain proper filtration to remove swarf and chips

Please consult a Quaker Houghton representative for any additional information.

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TECHNICAL DATA SHEET

WC 75

NEAT GUN DRILL OIL

WC 75 is a low viscosity, light cutting oil containing active sulfur. In addition, this oil contains a synergized fatty additive that has proven itself far superior to previous fatty oil technology.

Product should be stored under cover in clean, dry conditions and protected from frost. Recommended storage temperature is between 5°C and 35°C.

Applications

WC 75 has a combination of active sulfur, chlorine, and wetting agents that provide excellent extreme pressure properties when cutting, gun drilling, deep hole drilling, threading, and tapping.

Recommendation For Use

WC 75 is used neat as supplied.

Benefits

- Light color
- Light odor
- High flushing power
- High detergency
- Excellent oxidation stability
- Good tool life and improved surface finish.
- Due to the content of active sulfur the oil may discolor yellow metals

Health, Safety and Handling

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Typical Physical Properties

PROPERTY	TYPICAL VALUE
Appearance	Clear Yellow Liquid
Specific Gravity @ 20°C	0.93
Kinetic Viscosity @ 40°C, cSt	13
Flash Point COC °C	166

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TECHNICAL DATA SHEET

CUT-MAX® 634-8 NEAT CUTTING OIL FOR GUN DRILLING

CUT-MAX® 634-8 is a low viscosity, chlorine free light cutting oil containing active sulfur. In addition, this oil contains a synergized fatty additive that has proven itself far superior to previous fatty oil technology.

CUT-MAX® 634-8 has a combination of active sulfur and wetting agents that provide excellent extreme pressure properties when cutting, gun drilling, deep hole drilling, threading, and tapping.

Applications

CUT-MAX® 634-8 has a combination of active sulfur and wetting agents that provide excellent extreme pressure properties when cutting, gun drilling, deep hole drilling, threading, and tapping. Due to the content of active sulfur the oil may discolor yellow metals.

Recommendation for Use

CUT-MAX® 634-8 is used neat as supplied. Due to the content of active sulfur the oil may discolor yellow metals.

Benefits

- Free of heavy metals
- Excellent oxidation stability
- Good tool life and improved surface finish
- Light color and odor
- High flushing power and high detergency

Health, Safety and Handling

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Properties

PROPERTY	TYPICAL VALUE	UNIT
Appearance	Light Amber Liquid	
Specific Gravity	0.88	
Kinetic Viscosity at 40°C	8.3	cSt
Flash Point	177	°C

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