INDUSTRIAL OIL

Semi Synthetic Cutting Oil

Cools and lubricates the cut

Water-miscible semi-synthetic metalworking fluid

PRODUCT DESCRIPTION

Motoforce Semi Synthetic Cutting Oil is a water-miscible metalworking fluid for machining operations. Cutting fluids do two jobs at once — carrying heat away from the cutting zone and lubricating the tool-workpiece contact — which is what protects tool life and surface finish. Semi-synthetic fluids sit between straight mineral and fully synthetic types. Supplied in 26 litre packs.

APPLICATIONS

- Turning & Milling
- Drilling
- General Machining

SPECIFICATIONS

- Water-miscible semi-synthetic metalworking fluid

PACK SIZES

26L

FEATURES & BENEFITS

- Mixes with water to form a stable, translucent emulsion.
- Removes heat from the cutting zone while lubricating the tool–workpiece contact.
- Corrosion inhibitors protect machined parts and machine tools.
- Good emulsion stability and resistance to bacterial breakdown.

TYPICAL PROPERTIES

Property	Test Method	Unit	Typical Value
Appearance (concentrate)	Visual	—	**Clear amber liquid**
Appearance (5% emulsion)	Visual	—	**Translucent**
Density @ 15 °C (concentrate)	ASTM D4052	g/cm³	**0.98**
pH (5% emulsion)	ASTM E70	—	**9.0 – 9.5**
Refractometer Factor	—	—	**1.2**
Corrosion Test (5% emulsion, cast iron chips)	IP 287	—	**Pass**

RECOMMENDATIONS

- Always add concentrate to water (not water to concentrate) while stirring.
- Typical dilution 3–5% (1:30 to 1:20) for general machining; up to 10% for heavy-duty work.
- Check concentration regularly with a refractometer and top up with pre-mixed emulsion.

HEALTH, SAFETY & STORAGE

Store sealed in a cool, dry, covered place away from sunlight and ignition sources. Avoid prolonged skin contact. Dispose of used product and containers only through an authorised collector — never into drains or soil. See the MSDS for full health and safety information.

The typical values above are obtained under normal production conditions and do not constitute a specification. Minor variations that do not affect product performance are to be expected. Motoforce Lubricants reserves the right to modify products and this information without notice. For the latest version, visit motoforcelub.com or contact us.