

# TECHNICAL DATA SHEET

## CUT-MAX® UP 1-74

### ADDITIVE CONCENTRATE

CUT-MAX® UP 1-74 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.

CUT-MAX® UP 1-74 is free from Chlorine.

### Applications

CUT-MAX® UP 1-74 gives excellent results on tapping, gear cutting, deep hole drilling from 6 mm diameter and extremely difficult operations, also in hardened steel. It gives high tool life when auto-lathe-machining small quenched and drawn steel components.

CUT-MAX® UP 1-74 is used for broaching steel up to 1000 N/mm<sup>2</sup> and at speeds up to 9 m/min. The specially developed additive package ensures high tool life, superior to chlorine-containing products.

### Recommendation For Use

Is added to adjust additive content in concentrations from 5 - 20% . Sump temperatures above 50°C should be avoided.

### Benefits

- For adjustment of neat cutting and deformation oils.
- Improves tool life
- Improves sump life

### 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.

### Typical Physical Properties

PROPERTY	TYPICAL VALUE	UNIT
Colour	yellow	
Specific Gravity @20°C	0.93	[kg/L] ASTM D4052
Kinematic Viscosity @40°C	18	[mm <sup>2</sup> /s] ASTM D7042
Flash Point COC	160	[°C] ASTM D92
Pour Point	-15	[°C] ASTM D97
Copper Corrosion	4c	ASTM D130

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