

Performance you can trust

## V-cut™ Cutting Fluids High Quality Metal Working Fluids

### Range Overview

The V-cut range is a synergistic range of cutting fluids, hydraulic oils and slideway lubricant designed to deliver excellent results. V-cut is engineered to give maximum value to users whilst never compromising on performance due to its utilisation of the latest additive technology.

The V-cut technology is suitable for a wide range of metal working operations including turning, milling, grinding and drilling etc.

Suitable for ferrous and non ferrous materials and with smaller pack sizes available V-cut is the ideal complete range for small to medium sized machine shops.

The V-cut range has also been designed with the users safety in mind, safe and pleasant to use and with minimal hazards.

### V-cut MP

V-cut MP is a multi-purpose cutting fluid, a water mix fluid providing a milky emulsion designed to give excellent performance for all general purpose cutting operations.

- Very economical dilutions, up to 35:1
- Prolonged sump life
- Ideal for various metals, with excellent results on low to medium carbon steels.

### V-cut SS

V-cut SS is a semi-synthetic dual purpose cutting and grinding fluid, a water mix fluid providing a translucent green emulsion designed to give excellent performance for all general purpose cutting & grinding operations.

- Extremely economical dilutions, up to 65:1
- Prolonged sump life
- Ideal for use on most metals especially low to medium carbon steels.
- Allows a clear view of the work piece
- Allows rationalization to one product for cutting and grinding.

### V-cut EP

V-cut EP is an extreme pressure cutting fluid, a water mix fluid providing a milky type emulsion. Designed for medium to heavy duty cutting operations / materials.

- Very economical dilutions, up to 35:1
- Contains extreme pressure additives enabling best performance when machining harder materials such as hardened steels or similar tough alloys
- A blend of EP and anti-wear additives which prolongs tool life and enables faster machining rates providing excellent cost savings on expensive tooling
- Prolonged and predictable sump life.

### V-cut AL

V-cut AL is a cutting fluid ideal for cutting non ferrous materials such as aluminium, copper and their alloys. A water mix fluid providing a milky emulsion.

- Economical dilutions, up to 20:1
- Prolonged sump life
- Excellent performance even with severe aluminium machining operations
- Prevents staining or etching on sensitive alloys
- Promotes an excellent surface finishing and clean sharp threads on difficult operations

### V-cut NC

V-cut NC is a neat cutting oil, pale in colour and low odour.

- Ideal for medium to heavy cutting operations such as gear cutting, broaching, thread grinding and deep hole drilling.
- A blend of EP and anti-wear additives which prolongs tool life and enables faster machining rates providing excellent cost savings on expensive tooling
- Suitable for a wide range of materials including high tensile steels and hardened alloys.
- Enables a superior surface finish.

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EMS 67596



OHS 78173





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Property	V-cut MP	V-cut SS	V-cut EP	V-cut AL	V-cut NC
<b>Concentrate Appearance</b>	Straw	Green	Straw	Amber	Straw
<b>Emulsion Appearance</b>	Milky	Translucent green	Milky	Milky	N/A
<b>pH at 5% water</b>	9.5	9.5	9.5	9.0	N/A
<b>Viscosity at 40°C</b>	N/A	N/A	N/A	N/A	23 cSt
<b>Mineral Oil Content</b>	65 – 75%	20 – 30%	50 – 60%	50 – 60%	> 90%
<b>Storage</b>	Store in a cool (5°C to 30°C), well ventilated area				
<b>Recommended Dilution</b>	20:1 to 35:1	Grinding; 35:1 to 65:1 Cutting; 35:1 to 50:1	20:1 to 35:1	15:1 to 20:1	N/A

Values quoted above are typical and do not constitute a specification.

Dilution / refractometer reading	10:1	15:1	20:1	25:1	30:1	35:1	45:1	55:1	65:1	75:1
<b>V-cut MP</b>	9.5	6.6	5.0	4.0	3.4	2.9	2.3	1.9		
<b>V-cut SS</b>				2.7	2.1	1.9	1.5	1.2	1.0	0.9
<b>V-cut EP</b>	9.8	7.0	5.8	4.8	3.8	3.2	2.4	2.1		
<b>V-cut AL</b>	9.1	6.2	4.8	3.8	3.2	2.8				

Pack size / Part Code	V-cut MP	V-cut SS	V-cut EP	V-cut AL	V-cut NC
<b>5 L</b>	51546	51526	51536	51556	N / A
<b>20 L</b>	51543	51523	51533	51553	51563
<b>55 L</b>	51540	51520	51530	51550	N / A

### Safety Data Sheets

Safety data sheets are available for download from our website [www.rocol.com](http://www.rocol.com) or may be obtained from your usual ROCOL contact.

The information in this publication is based on our experience and reports from customers. There are many factors outside our control or knowledge which affect the use and performance of our products, for which reason it is given without responsibility.

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