



Macson 2222CF Cutting Oil

Chlorine Free Oil

MACSON 2222CF is a chlorine free oil combining sulfur and phosphorus extreme pressure additives that eliminate chip welding and provide fine finishes on alloy steel. It should generally be used without dilution with mineral oil, but because it contains such a high percentage of base lubricants and polar additives, on some operations, it can be cut back with paraffin oil or used as an additive to increase the performance of inferior tool lubricants. The superior anti-weld qualities of this lubricant are readily shown by the ease with which it handles tapping, gear shaping and other difficult operations on alloy steels.

FOR:

*BROACHING	*ADDITIVIE FOR SCREW
*THREAD GRINDING	MACHINE OILS
*TAPPING	*GEAR SHAPING
*MACHINING HARD STEELS	* ARMORING
*THREADING	*FORM GRINDING

CUTTING SPEED – The low speed operations of broaching, tapping, threading and gear shaping will benefit most from the chemical lubricants in **MACSON 2222CF** oil. As machine speeds increase, the need for this chemical lubrication will decrease.

CONTROLLING CHIP WELDING – The anti-weld present in **MACSON 2222CF** oil eliminates tool pick-up and chip welding. **MACSON 2222CF** oil will help in obtaining low micro inch finishes, free of tearing. These additives are particularly necessary when working with the harder alloy steels.

THREAD AND FORM GRINDING – For thread and form grinding operations, **MACSON 2222CF** oil gives superior heat exchange characteristics, insures freedom from burning and provides longer wheel life.

METALS – High carbon alloy steels, stainless steels and hard to machine alloys will especially benefit from the chemical lubrication provided by **MACSON 2222CF** oil. **MACSON 2222CF** oil contains a high amount of active sulfur which will darken copper, brass or silver parts unless they are immediately degreased following machining operation. **EXERCISE CAUTION ON BRASS, BRONZE OR COPPER PARTS.**

OPERATOR SATISFACTION – The non-gumming, good cleaning characteristics of **MACSON 2222CF** oil provides a clean working area and safe conditions for the operators. These compounds contain no kerosene and are non-irritating to the skin and the pleasant working conditions it provides improves operator efficiency. Considerable reduction in smoke will also enhance operation throughout the facility.

SPECIFICATIONS

<u>GRADE</u>	<u>2222CF</u>
Viscosity @ 100° F., SUS	165 – 180
Flash Point, COC	340° F.
WT/Gal.	7.50
Sulfur, total % wt.	1.82
Sulfur, active, % wt.	1.26
Chlorine, % wt.	0
Phosphorus, % wt.	0.08
Recovered Fatty Acids, % wt.	6.5
Neutralization No. of F.A.	195-198
Anti-mist Additive	Yes