

PC 20 / 28 / 45 *Straight Cutting Oils*

FEATURES

- Very High Flash Point (VHF) Technology
- Unsurpassed Lubrication for Tool Work Piece Interface
- Polar Cutting Technology
- Speeds and Feeds are Maximized
- Specially suited for Advanced Cutting Tool Material, i.e. Diamond, CBN Ceramet, Ceramic
- Enhances Metal Flow Conditions

Hangsterfer's introduces a new series based on Polar Cutting technology and advanced Very High Flash Point (VHF) chemistry. The combination of Polar technology and VHF chemistry takes the metalworking process to new heights. As speeds and feeds are maximized, the temperature in the work-piece zone is ever increasing. As a result, the VHF characteristics are well sought after because of their higher flash point. The PC Series not only lubricate the tool but they equally lubricate the metal being cut creating metal flow conditions that are unattainable with existing traditional technologies.

APPLICATIONS

Primary		Secondary
Swiss Style Screw Machining Centers General Machining	Honing Stamping Blanking	Grinding Swedging Forming

PC 20 is well suited for honing of ferrous and non-ferrous materials where chlorine additives are restricted and vegetable provides superior lubricity. It is non-staining and provides rust protection. The natural superior lubricity of the PC series provide flushing and pickup protection for the abrasive while providing superior finishes in ferrous and non-ferrous alloys. Honing is a cutting operation with very small chips.

PC 20 is suited for use on solid and expanding hones in all types of honing machines.

PC 20 is especially suitable for use on hone materials but not limited to: diamond and supper abrasives.

PC 20 is suitable for use with ceramic and silicone carbide hones

MAINTENANCE & CLEANING

Maintenance: While straight cutting oils are not susceptible to the broad range of problems encountered with a water-based fluid, regular maintenance does improve their performance and extend their life. The PC Series is designed to reject foreign contaminants, such as metal fines. If the performance of the oil begins to deteriorate, remove the oil from the machine and allow settling in a drum or settling tank for 3 – 7days. Fines and contaminants will settle to the bottom. After settling, return the top 80% to the clean machine. In order to get the maximum life from your oil, keep the sump free of cleaners, solvents, rust inhibitors, coolants, water and other contaminants, which may reduce performance.

Cleaning: The PC Series is formulated to minimize cleaning time. They are cleanable in both aqueous and solvent systems. For best results use a Hangsterfer's Ozonic series cleaner or recommended aqueous cleaner. Both style cleaners work best at removing the PC product when heated to 140°F (60°C).

PRODUCT CHARACTERISTICS			
Product	PC 20	PC 28	PC 45
Form	Liquid	Liquid	Liquid
Color	Golden	Golden	Golden
Odor	Mild	Mild	Mild
Specific Gravity	0.88	0.89	0.93
Viscosity: SUS @ 100°F	104	132	214
cSt @ 40°C	22	28	46
Flash Point, COC, °F/°C	338 / 170	369 / 187	442 / 228
Fire Point, COC, °F/°C	372 / 189	379 / 193	487 / 253
Pour Point, °F/°C	5 / -15	34 / 1	5 / -15
Solubility in Water	<0.01	<0.01	<0.01
Boiling Point, °F/°C	392 / 200	392 / 200	487 / 253
Vapor Pressure, mm Hg @ 25°	<0.01	<0.01	<0.01
pH @ 10%	NA	NA	NA
Chlorine	No	No	Yes
Sulfur	Yes	Yes	Yes

Shipping Units:

PC 20, 28 & 45 are available in 5 gallon, 55 gallon and Intermediate Bulk Containers (275 or 330 gallons).

All products are distributed worldwide.

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