



TRI-PURPOSE CUTTING FLUID

Metal Working Fluid
Designed for Automatic Screw Machines



REV: 07.11.2017



DESCRIPTION

Gard Tri-Purpose Cutting Fluid is a general purpose light to medium duty, extreme pressure, metal working fluid for a variety of metal removal and also finishing operations. It has a low odor and is amber in color, allowing better operator acceptance and workpiece visibility. It is formulated to be environmentally favorable product.

Gard Tri-Purpose Cutting Fluid is suitable for automatic screw machines, lathes and other metalworking applications where the cutting fluid lubricates the workpiece, hydraulic pumps, motors, and gears.

Gard Tri-Purpose Cutting Fluid is ideal for machining a wide variety of metals from steels to harder materials such as titanium and inconel. Using a chlorine free formulation it is noncorrosive to copper alloys and offers good rust protection for ferrous metals.

BENEFITS

- ❑ Low viscosity for maximum penetration
- ❑ Has no corrosive chlorine
- ❑ Protects cutting tools
- ❑ Reduces cutting temperatures
- ❑ Superior workpiece visibility
- ❑ Improves the quality of machined and stamped surfaces

APPLICATION

- Boring
- Broaching
- Drilling
- Grinding
- Milling
- Shaping
- Screw Machines
- Tapping

TYPICAL PROPERTIES

METHOD

TRI-PURPOSE CUTTING OIL

Specific Gravity at 15.6°C	D-1122	0.9117
Viscosity, cSt at 40°C	D-445	22.2
Flash Point, °C (°F)	D-92	172
Pour Point, °C (°F)	D-97	-45
Acid Number, mg KOH/g	D-974	0.06
Sulfur, mass%	D-2622	0.376
Copper Corrosion	D-130	1A
Four Ball Test - Welding Load	DIN-51350-2	2200-2400 N
Four Ball Test - Scar	DIN-51350-3	0.80 mm
Brugger Load Capacity		65 N/mm ²



NOTE:

The information on this Product Data Sheet is believed to be accurate and is typical of current production. Specifications are subject to change without notice. For additional qualifications, please contact Martin Lubricants Technical Service Department.

Health And Safety Information See separate Safety Data Sheets available on request.

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