

# CHEMCUT CF 135

THREADING AND CUTTING OIL - NON-CHLORINATED

## ▶ PRODUCT DESCRIPTION

**Chemcut CF 135** is a high performance, non-chlorinated cutting oil for moderate duty machining of ferrous metals. The Chemcut 135 is formulated using a blend of mineral oils that enhance solubility of the product's additive package while remaining economical to use.

## ▶ FEATURED BENEFITS

- Utilizes a non-chlorinated lubricity package that maximizes performance
- Extends tool life
- Better surface finish
- Contains an anti-mist additive
- Contains an anti-oxidant additive
- Light color for good piece part visibility
- Low odor for good operator acceptance
- Non-staining to ferrous metals
- Easy to remove/clean
- Recyclable

## ▶ APPROVALS

- Compliant for California SCAQMD Rule 1144

## APPLICATION



### COMPATIBLE METALS

Cast Iron  
Carbon Steel  
Tool Steel

### MACHINING CAPABILITIES

Tapping  
Threading  
Broaching  
Turning  
Facing

### ALL METAL SAFE

No

### FOAMING CHARACTERISTICS

Low

### FILM TYPE

Oily

### RUST PROTECTION

None



## TYPICAL PROPERTIES

Fluid Type	Straight oil, mild to moderate alkaline cleaner
Appearance	Clear amber liquid
Odor	Mild
Weight, 60°F (15.6°C)	7.26 lbs/gal.
Specific Gravity, 77°F (25°C)	0.867
Viscosity, 100°F	135 SUS
Flash Point, COC	350°F (177°C)
Sulfur	Present
Fat, weight	2.2%
Phosphorus	Present
Copper Corrosion, 3 hours, 212°F (100°C)	1a
VOC, ASTM E 1868	5.2 grams/liter

## PRODUCT APPLICATION / USAGE

Chemcut CF 135 is recommended for the general machining of steels with machinability ratings greater than 60%. For more difficult applications such as broaching, tapping, and threading it can be used on steels with machinability ratings greater than 70%. Chemcut CF 135 is also an excellent product for the machining of titanium.

## PRODUCT CODE

2546500000

## HEALTH AND SAFETY

For health and safety guidance, please refer to the Chemtool SDS (Safety Data Sheets).