



## TARMOND PCF 535

### THREAD CUTTING OIL

#### Product Description:

TARMOND PCF 535 is a pure cutting oil developed by blending high-tech additives and quality mineral base oils to be used in threading and broaching operations of ferrous metals, cast iron and low-medium-high alloyed steel. It is especially recommended for deep hole drilling and high-speed internal broaching as it has a very high EP additive content. It has good lubricating properties, good corrosion protection, low foaming and high vapor and oil mist protection.

#### Applications:

It is recommended for all heavy duty machining operations including gear cutting, tapping, pressing, broaching on difficult to machine materials. This product is not suitable for non-ferrous metals.

#### Benefits:

- ❖ Advanced additive technology gives high extreme pressure (EP) lubricity properties and lowering production costs through extended tool life
- ❖ Improved surface finish and increased cutting speeds leads to improvement of process efficiency
- ❖ High level of machining performance
- ❖ Increased production resulting from improvement in tool life and a reduction in downtime for tool changes
- ❖ Wide range machining capability reduces product inventories
- ❖ Improved surface finish and dimensional accuracy results in fewer rejects
- ❖ The high extreme pressure content of the product allows cutting speeds and feeds to be maximised
- ❖ No staining of ferrous slideway parts or fixtures
- ❖ Anti-mist additive reduces misting and oil usage in high speed operations giving a clean and pleasant working environment

#### Technical Data:

TARMOND PCF 535	TEST METHOD	
Colour	Visual	Brown
Density at 15°C gr/cm <sup>3</sup>	ASTM D 4052	0.86-0.87
Viscosity at 40 °C	ASTM D 445	32 - 35
Flash point °C	ASTM D 92	225
Pour Point °C	ASTM D 97	-36
Copper corrosion at 100 °C	ASTM D 130	1b

Above values are the typical values of the products and may vary with each batch.