

390

Cutting Oil

TECHNICAL
CHESTERTON®
PRODUCTS

Description

Chesterton® 390 Cutting Oil is a heavy duty, multi-purpose cutting fluid designed to provide maximum tool life and superior parts finish in severe applications. It is a highly reinforced lubricant for faster, easier cutting of hard or soft metals.

Maximum lubricity means less wear on tool cutting edges and less down time, cleaner cuts and fewer rejects. The high viscosity oil clings to drills, taps, bores etc. and will provide maximum friction reduction especially when the tool is buried deep within a metal substrate.

The convenient aerosol package can be applied at any angle for flat or vertical overhead work. The clinging foam means no drip and no waste. Difficult applications such as the internal threading of pipes is facilitated as 390 Cutting Oil can be easily sprayed into such normally hard to lubricate areas. Many users report that an aerosol can of 390 Cutting Oil goes as far as a gallon of ordinary cutting oil because it is directed at the cutting area and stays there.

Composition

Chesterton 390 Cutting Oil was formulated with the extreme pressure and lubricating properties of sulfurized mineral

Typical Physical Properties

ISO Viscosity	(ASTM D 2422, DIN 51 519)	32
Appearance		Amber, Liquid
Odor		Mild Petroleum
Specific Gravity 20°C (68°F)		0.9
Viscosity, cSt at 40°C (104°F)	(ASTM D 445, DIN 51 361)	32
Pour Point	(ASTM D 97, ISO 3016)	-18°C (0°F)
Flash Point	(ASTM D 93, DIN 51 755)	170°C (338°F)

oil and chlorinated paraffins. It provides protection from corrosion and rancidity without the use of nitrites, nitrates or any nitrosamine forming compounds.

The additive package in 390 Cutting Oil was engineered for the most severe applications and the most difficult to machine metals. Sulfur and chlorine compounds are well recognized as providing superior extreme pressure properties. Each is most effective at a particular temperature range however. By the proper proportioning of these compounds in the 390 Cutting Oil, the ultimate in extreme pressure capabilities is provided throughout the entire cutting process. The product prevents microwelding of metal to metal which causes galling, built-up edges, and ultimately overall poor parts finish.

Applications

Lubricant for all types of metal cutting and forming. Use for broaching, deep drilling, sawing, reaming, milling, tapping, hack sawing, boring, countersinking. Excellent parts finish on cast and wrought iron, black steel, Alloy 20, Hastelloy*, Inconel**, and other Stainless and High Carbon Steels.

* Haynes International, Inc. Registered Trademark.

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Features

- Superior extreme pressure capabilities
- Excellent part finish
- Clings to vertical and overhead surfaces
- Cleaner cuts
- Protects from rust
- No unpleasant odor
- NSF H2, P1 - Registration number 134014 (bulk) and 134947 (aerosol)

Directions

Convenient aerosol can, can be sprayed directly to the cutting area where it will cling for economical, clean cuts.

Clean Up

Parts and tools are easily cleaned with water based degreasers such as Chesterton® 801 Industrial & Marine Solvent or solvent based products such as Chesterton 274 Industrial Degreaser.

Safety

Before using product, review the Material Safety Data Sheet (MSDS) or the appropriate safety sheet for your area.

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