



CUTTING OILS—300 Series (Tripurpose Non-Staining Oils)

The 300 series of cutting oils are medium dark oils that are suitable for a wide variety of machining requirements.

CUTTING OIL 304 and 306 are non-staining dark oils designed for both ferrous and non-ferrous cutting applications. They contain special extreme pressure and lubricity additives to produce heavy-duty capability without active sulfur. **CUTTING OIL 304** effectively controls tool wear while providing superior surface finish.

CUTTING OIL 304 and 306 are also considered tri-purpose machine-tool lubricants since they can be used as a cutting oil, hydraulic oil or way oil. This makes **CUTTING OIL 304 and 306** ideal for automatic screw machines where a single oil is used for all three purposes.

CUTTING OIL 306 and HS 3080 are premium tri-purpose machine-tool lubricants. They contain an antimist agent and additional components to control EP and wear.

BENEFITS:

- MAXIMIZES TOOL LIFE
- MULTI-PURPOSE CAPABILITY
REDUCES INVENTORY
- IMPROVES SURFACE FINISH
- CONTAINS NO CHLORINE

APPLICATIONS:

CUTTING OILS 304 and 306 are recommended for a wide variety of machining operations and alloys.

CUTTING OIL 304, 306 and HS 3080 are designed for a general-purpose machine-tool lubricant and may be used as a cutting oil, hydraulic oil or way oil.

CUTTING OIL 300 series may be used for machining applications such as turning, boring, threading, tapping, milling, gear cutting of non-ferrous metals (aluminum, copper, magnesium, etc.) and their alloys. It can also be used for light to medium duty machining of iron and steel alloys.



CUTTING OILS—300 Series (Tripurpose Non-Staining Oils)

TYPICAL CHARACTERISTICS

Grade	304	HS 3080	306
Product Code	16801	16842	16806
API Gravity (ASTM D-1298)	24.0	31.1	31.4
Appearance	Medium	Medium	Medium
Color, ASTM D 1500	5.0	5.0	5.0
Viscosity (ASTM D-445):			
cSt @ 40°C	34	26	26
cSt @ 100°C	5.1	4.8	4.8
SUS @ 100°F	177	135	135
Pour Point (ASTM D-97) °F (°C)	-20 (-29)	-20 (-29)	0 (-18)
Flash Point (ASTM D-92) °F (°C)	350 (177)	395 (202)	395 (202)
Total added Sulfur, %	0.5	0.8	0.5
Active Sulfur, %	Nil	Nil	Nil
Fat Content, %	2.5	4.4	4.5
Tapping torque Test (1020 HR Steel) % Efficiency	96	na	Na
Antimist	No	Yes	Yes
Phosphorus	No	Yes	Yes

The above data is subject to usual manufacturing variation. For more information and availability, call 1-800-442-LUBE.
02/24/2006