



Power Cutting Oil PC-10™

Designed for dual functionality: Use as straight insoluble oil or a supplemental coolant additive for a wide range of cutting and drilling applications

Key Features & Benefits

- Reduces friction-related heat and wear for extended tool life
- Increases cutting speeds and production rates
- Provides more metal extraction per cut
- Improves surface finishes
- Reduces tool head and metal surface temperatures
- Causes less drag on the metal, reducing power consumption
- Excellent extreme-pressure properties
- Provides process visibility
- Inhibits rust and corrosion
- Can be used in a wide range of cutting and drilling applications
- Reduces unnecessary downtime and scrap caused by premature tool failure
- Contains no solid lubricants, active sulfur, sulfonated ash or chlorinated solvents
- Contains ionic bonding, lubricity enhancement and extreme-pressure agents that are activated in the cutting zone for continuous lubrication to the work and tool
- Contains **Muscle Metal Treatment MT-10®** technology for increased lubricity and boundary film lubrication

Typical Applications

- Full-strength, undiluted cutting oil
- Supplemental additive to insoluble oils to boost coolant performance
- Use in machining operations such as: broaching, drilling and deep drilling, threading and tapping, cutting, milling,

shaving, sharpening, planing and shaping, turning and grinding

NOTE: PC-10™ is not water soluble. If the operation requires a soluble fluid, use **Muscle Soluble Cutting Oil SC-10™**.

Directions for Use

- Use undiluted as a full-strength cutting oil
- Add to the existing insoluble coolant in a 10 - 25% by volume ratio
- Not recommended for use with water glycol compounds or triphenol butylated phosphate oils

Technical Data

Appearance.....	Light amber liquid
Odor.....	Mild petroleum
Pour point.....	- 27.4°F (- 33°C) D97
Initial boiling point.....	220°F (104°C) D86
Flash point	324°F (162°C) D93
Specific gravity @ 60°F, g/cm ³	0.9956 D1298
Density @ 15°C, g/cm ³	0.9946 D1298
Lbs per gal (U.S.).....	~ 8.300
Solubility.....	Insoluble (water)
Viscosity @ 40°C	114.33 cSt D445
Viscosity @ 100°C	9.46 cSt D445
Viscosity index	35 D2270
Rust test, 4 hr.....	Pass (no rust) D665A
Timken extreme pressure OK load.....	60+

The above properties are typical values and do not constitute a product specification.

Container Availability

Item PC-10-16.....	16 oz. bottle (473 mL)
Item PC-10-128.....	1 U.S. gallon (3.7 L)
Item PC-10-5G.....	5 U.S. gallon (18.9 L)
Item PC-10-55G.....	55 U.S. gallon (208 L)

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Additives and Lubricants Engineered for Performance

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