MOL Acticut ME 20

cutting oil

MOL Acticut ME 20 is a high performance chlorine-free cutting oil developed for the high speed and high productivity machining of carbon steels and heavy-alloy steels. It is a highly refined mineral oil containing additives that improve lubrication, prevent wear, provide pressure resistance, inhibit corrosion and reduce formation of oil mist. It forms a boundary lubricating layer even at low cutting speeds and high machining forces, which significantly reduces the friction between the tool and the workpiece, as well as between the cuttings and the tool, thus ensuring a long tool life and an excellent surface quality. It has a good wetting and washing capability, which is beneficial for removing cuttings from the working area. Due to its moderate odour, it ensures better working conditions relative to the active cutting oils having similar performance. It does not contain PCB, PCT, heavy metal or barium compounds.

Application

All high productivity chip forming machining operations where the large cross-section of the removed chip (cutting depth and infeed) results in high cutting forces
Cutting technologies of various type and duty (turning, milling, drilling, thread machining, toothing processes etc.)
Processes on single- and multi-spindle automatic lathes or units
Alloy steels which are difficult to cut
Acid resistant and stainless steels
Automatic and easy-to-machine steel materials
Limited applicability for machining of yellow metals due to active sulfur content

Features and benefits

Excellent lubricity	Effective friction and wear reduction, giving a long life of tool edges Lower specific tool cost Cutting without edge overlay Reduced friction heat generation and improved removal of chips Higher productivity, so reduced manufacturing costs
Effective washing and rinsing properties	Excellent machined surface quality
Excellent temporary corrosion protection	Effective temporary corrosion protection of workpieces, giving reduced surface treatment costs
Low foaming tendency	Forms a continuous lubricating film, giving a balanced cooling effect and lubricity Excellent surface quality and high manufacturing precision
Low mist formation tendency	Safer and more comfortable working environments
Mild odour	More comfortable working environments

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Latest revision: 2019.06.20 8:58

Version: 010.000.002

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Specifications and approvals

	EMAG
	ISO 6743-7: L-MHF

Properties

Properties	Typical values
Appearance	yellow-brown, clear
Density at 15°C [g/cm3]	0,886
Kinematic viscosity at 40°C [mm2/s]	23
Pour point [°C]	-12
Flash point (Cleveland) [°C]	200

The characteristics in table are typical values of the product and do not constitute a specification.

Storage and handling instructions

Store in the original container in dry, properly ventilated area. Keep away from direct flame and other sources of ignition. Protect from direct sunlight.
During transport, storage and use of the product follow the work safety instructions and environmental regulations relating to mineral oil products.
For further details please read the Material Safety Data Sheet of the product.
In the original container under the recommended storage conditions: 12 months
Recommended storage temperature: max. 40°C

Ordering information

Custom Tariff Number 27101999

SAP code and packaging:
13007505 MOL Acticut ME 20 180KG 216.5 l steel drum (for order only)

Order booking:

Please contact your local distributor or sales partner for ordering details.