

# MOL Acticut ME 25

## environmentally compatible broaching oil



MOL Acticut ME 25 is a high performance chlorine-free cutting oil developed for heavy duty machining of carbon steel and high-alloy steel. It is a highly refined mineral oil containing additives that improve lubrication, prevent wear, provide pressure resistance, inhibit corrosion and reduce formation of oil mists. 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. It does not contain PCB, PCT, heavy metal or barium compounds.

### Application



Machining operations with extremely heavy loads - broaching, gear hobbing, xx, yy, etc.

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

Thread forming operations, thread calendaring or thread rolling

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

### Specifications and approvals

EMAG  
ISO 6743-7: L-MHF

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### Properties

Properties	Typical values
Appearance	yellowish brown, slight opalescence is permissible
Density at 15°C [g/cm <sup>3</sup> ]	0,889
Kinematic viscosity at 40°C [mm <sup>2</sup> /s]	26
Pour point [°C]	-20
Flash point (Cleveland) [°C]	220

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: 36 months

Recommended storage temperature: max. 40°C

### Ordering information

Custom Tariff Number 27101999

#### SAP code and packaging:

13009652 MOL Acticut ME 25 10LA

10 l plastic can (for order only)

13006006 MOL Acticut ME 25 180KG

216.5 l steel drum (for order only)

#### Order booking:

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