



Product Information:

MARCIA F

MULTI-PURPOSE NEAT CUTTING OIL

Description

Marcia F has been developed as a low viscosity, extreme pressure neat oil, suited to a wide variety of applications, particularly involving ferrous alloys. Its low viscosity makes it particularly suited to high speed operations on ferrous feedstocks, but it is also suited to a number of deep hole drilling, tapping and honing applications.

The low viscosity of Marcia F ensures excellent penetration and swarf flushing whilst the extreme pressure and lubricity additives help reduce tool wear and give improved surface finish.

Note: Marcia F contains active sulfur and may stain yellow metals such as copper and cuprous alloys, particularly at elevated temperatures.

Features

- Very Low Viscosity
- High EP Loading
- Low Misting
- Low Odour
- Good Workpiece Visibility
- Excellent flushing characteristics
- Active Sulfur

Applications

Gear Cutting	Ferrous Alloys up to and including medium tensile steels.
Broaching & Deep Hole Drilling	Low to medium tensile steels and other free cutting ferrous alloys.
Honing	Ferrous alloys up to and including stainless steels.
Grinding	Ferrous alloys up to and including stainless steels.
Automatic & high speed applications	Free cutting ferrous alloys up to and including medium tensile steels.

Physical Characteristics

Appearance	Straw liquid
Relative Density @ 15.6°C	0.877
Kinematic Viscosity @ 40°C (cSt)	7.73
Closed Flash Point (°C)	130
Copper Corrosion (3 hours @ 100°C)	4a

Figures based on average production values

Part No.s: MAF205, MAF025

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