

Product Data Sheet

MUSCLE-CUT™ 3-IN-1 CUTTING OIL™

General Information

- Tri-purpose: Machine tool lubricant, hydraulic system lubricant, & the cutting fluid
- Utilizes a synthetic EP agent, anti-mist additives, plus rust & corrosion inhibitors
- For use on free to moderate machining metals, as well as brass, copper & their alloys

Muscle-Cut™ 3-in-1 Cutting Oil™ is a transparent, light-colored cutting oil. It is formulated utilizing a synthetic extreme-pressure agent in replacement of chlorine.

3-in-1 Cutting Oil™ was designed to act as a lubricant for the machine tool and the hydraulic system, as well as the cutting fluid. The use of one oil eliminates the dilution of the lubricating oils by the cutting fluid, which typically occurs on automatic screw machines when leakage from one system to another may occur.

Key Features & Benefits

- Anti-mist (5 mg/m³ maximum)
- 3-in-1 functionality: cutting, hydraulic & machine lubricant
- Non-staining (no active sulfur)
- Process visibility
- Prevents rust & corrosion
- Prevents varnish build up

Typical Applications

- Ferrous & nonferrous metals: low carbon steel, copper, brass & their alloys
- Mild to moderate machining
- Screw machine applications: drilling, sawing, boring & turning

Availability

- 1-gallon
- 37-lb. pail
- 110-lb. & 405-lb. drums
- Tote bins & larger containers upon request

Typical Properties

Viscosity, cSt 40°C	35.2
Viscosity, cSt 100°C	6.26
Viscosity, SUS 104°F	164.9
Viscosity, SUS 212°F	47.0

Viscosity Index	128
Flash point (D-92 COC)	410°F/210°C
Pour point (D-97)	-5°F/-15°C
API Gravity @ 60°F	28.2
Density, lbs./gal.	7.378
Color (D-1500)	< 2
Chlorine %	0
Fat %	0
Total Sulfur %	0
Active Sulfur %	0

Material Safety Data

- **Ingestion:** Do not induce vomiting. Call a physician immediately.
- **Eye Contact:** Flush with water for 15 minutes. Call a physician if irritation persists.
- **Skin Contact:** Wash thoroughly with soap & water. Call a physician if irritation occurs.
- **Storage:** Keep away from sparks & open flames.
- For additional information, please refer to Material Safety Data Sheet (MSDS).

Freight Classification

- **Classification:** Lubricating Oil
- **Hazard Class:** Nonhazardous
- **Packing Group:** N/A



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