

## ***DURACUT D-SERIES CONVENTIONAL CUTTING OILS ACTIVE SULFURIZED LARD/ESTERS FOR DIFFICULT MACHINING***

The **DURACUT D- SERIES** line of conventional cutting oils comprise a series of red to dark amber, premium quality, "active" sulfurized-fatty oils. These oils do not contain chlorinated paraffin(CP).

Each oil is formulated using a carefully balanced blend of lubricating additives and highly-refined extreme-pressure components in various combinations to promote optimum performance in the specific service for which each is recommended. Anti-mist additives are utilized in products with finished viscosities below 200 SUS @ 100°F to suppress fogging.

A blend of severely hydro-treated, paraffinic base-stocks are incorporated into this **DURACUT** line of conventional cutting oils. They exhibit characteristics such as a lower tendency to generate smoke / mists; and enhanced thermal stability in high speed machining. They also display lower pour points to facilitate handling at lower temperatures.

**DURACUT D- SERIES CUTTING OILS** are designed to provide long tool life and superior finish in all types of machining operations on ferrous metals, from free machining steels . . . to the most difficult to machine alloys.

### **PRODUCTS:**

#### **DURACUT 110-D, 180-D, and 220-D**

General purpose cutting oils for ferrous metals in normal machining operations. An excellent choice when working free machining steels or for use in light machining on alloy steels.

#### **DURACUT 250-D, 320-D, and 340-D**

These metalworking oils will satisfy 80% of all ferrous metal machining requirements and are recommended for a superior finish on most metal alloys. **DURACUT 320-D** with a viscosity of 140 SUS @ 100°F is recommended over **DURACUT 340-D** where a light viscosity oil with a moderately high sulfur content is required. An excellent choice for most machining operations including threading, lathe work, drilling, shaping and many hobbing and broaching operations.

#### **DURACUT 380-D and 410-D**

This group of oils exhibit the highest content of extreme-pressure additives in Maxim's standard metalworking oil line. These oils are recommended for use in operations involving the most difficult to machine alloys including stainless, titanium and high nickel steels in such difficult operations as gear hobbing and internal broaching. These oils are also recommended for the threading of pipe with outside diameters larger than 3 inches.

