

CC 332 (Straight Cutting Oil)

FEATURES

- Low Odor
- Low Mist
- Extend tool life
- Improves surface quality
- Increase speeds and feeds
- Reduce cycle times
- Non-toxic
- Non-irritating

GENERAL DESCRIPTION

CC 332 is a modern version of the classical heavily sulfurized and chlorinated cutting oils. The old style dark sulfur and strong odors have been replaced with modern technologies that are light color and low odor. There are specific operations that require sulfur-containing additives and CC 332 satisfies this need without compromise to the environment of the workplace. The classics are back and they are better than ever.

CC 332 is for applications that require extremely good, low and high temperature lubrication. These situations often include machining operations done in older and typically slower style machining centers, lathes, etc. If a built up edge is a problem or the surface condition of a particular threading operation cannot be achieved, CC 332 is an option in resolving this problem. CC 332 is especially suitable for carbon steel, tool steel and stainless steel on difficult gun drilling, threading and turning applications.

APPLICATIONS

Primary		Secondary	
Broaching	Drawing	Blanking	Fine Blanking
Forming	Gear Cutting	Burnishing	Piercing
Gun Drilling	Milling	Punching	Shaving
Thread Cutting	Thread Forming	Stamping	Shearing
Sawing	Swiss		

MATERIALS (Acceptable for ALL materials including these specialty Secondary's)

Primary		Secondary	
Suitable For All Materials		Cast Iron	Copper
		Glass	Graphite

INSTRUCTIONS

To prepare a machine for fresh cutting oil follow the recommended procedure. Empty the machine of used fluid and chips. If the machine has a high pressure cutting oil unit remove all used filters and cutting oil. Clean the machine sump and high pressure pump system by using Ozonics 203 as a rinse agent to remove any water or moisture left in the coolant lines or conveyor. Machine conveyors if not drained properly often hold 20 gallons / 76 liters of fluid. This could potential destroy cutting oil if not emptied. Empty the machine of Ozonics 203 (can be used to clean several machine). Fill with fresh oil.

Use a pail to catch the first product when starting the cutting oil pump to clean out the lines. A full version for machine cleaning is available from Hangsterfers's Labs.

MAINTENANCE

Maintenance: While straight cutting oils are not susceptible to the broad range of problems encountered with a water-based fluid, regular maintenance does improve their performance and extend their life. CC 332 is designed to reject foreign contaminants, such as metal fines.

If the performance of the oil begins to deteriorate, remove the oil from the machine and allow settling in an empty drum or settling tank for 3-7 days. Fines and contaminants will settle to the bottom. After settling, return the top 80% to the clean machine. In order to get the maximum life from your oil, keep the sump free of cleaners, solvents, rust inhibitors, coolants and other contaminants that may inhibit performance.

Cleaning: CC 332 is formulated to minimize cleaning time. It is cleanable in both aqueous and solvent systems. For best results use a Hangsterfer's Ozonic series cleaner or recommended aqueous cleaner. Both style cleaners work best at removing CC 332 when heated to 140°F (60°C).

PRODUCT CHARACTERISTICS

CC 332	
Form	Liquid
Color	Golden
Odor	Mild
Specific Gravity	0.88
Viscosity: SUS @ 100°F	148
cSt @ 40°C	32
Flash Point, COC, °F/°C	365 / 185
Fire Point, COC, °F/°C	392 / 200
Pour Point, °F/°C	0 / -18
Solubility in Water	<0.01
Boiling Point, °F/°C	435 / 224
Vapor Pressure, mm Hg @ 25°	<0.01
pH @ 10%	N/A
Chlorine	Added as EP Additive

WASTE TREATMENT

While Hangsterfer's oils resist contamination and degradation, contamination may require the oil be disposed of. In the normal use of cutting oils, tramp oils enter the system that may change the disposal procedures. Some Hangsterfer's oils contain chlorinated additives that may be disposed of as non-hazard if properly noted. Please verify with your local waste management company. Please comply with all local, state and government laws when disposing any oil.

SHIPPING UNITS

All Hangsterfer's products are available in pails, drums and Intermediate Bulk Containers (275 or 330 gallons). All products are distributed worldwide.

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