



## Kutwell 42

### Cutting Fluid

#### Product Description

Kutwell 42 is a premium quality soluble oil offering outstanding emulsion stability and rust inhibition. It emulsifies easily and resists oil-water separation in adverse operating conditions, such as poor water quality or contamination with dirt or tramp oil. Kutwell 42 also contains a bactericide to help guard against the formation of objectionable odors. Additionally, manufactured parts can be cleaned and protected against rusting by immersing them in a Kutwell 42 emulsion at 66-82 °C , then allowing the parts to dry.

#### Features and Benefits

- Excellent emulsion stability
- Excellent rust protection
- Outstanding lubricating properties
- Dependable cooling of tool and work

#### Applications

Kutwell 42 water-mix cutting and grinding fluid is suitable for a wide range of ferrous and non-ferrous metalworking operations. Dilution ratios for different applications are as follows:

- 2.5 - 5% for general machining
- 5 - 10% for heavy-duty cutting
- 2 - 3.5% for grinding
- 5% for use as a fire-resistant hydraulic oil

#### Typical Properties

Kutwell 42	Test Method	Unit	
CMCS Code			97S986
Appearance	Visual		Brown and Clear
Emulsibility	AM-S 99-003 7.1	Rating	2 (max)
pH (1% solution in distilled H2O)	E70		9.3 (max)
Kinematic Viscosity @ 40 °C	ASTM D445	mm <sup>2</sup> /s	40
Pour Point	ASTM D97	°C	-12
Foaming Tendency (150 ppm hard water)	AM-S 99-003 7.3	Rating	2 (max)
Emulsion Stability (500 ppm hard water)	AM-S 99-003 7.2	Rating	2 (max)
Corrosion Cast Iron, 50 ppm hard water 3% dilution	AM-S 99-003 7.4	Rating	Pass

#### Health and Safety

There are no unusual hazards in using lubricating oils and greases, provided ordinary care is taken to keep them off the skin and to avoid breathing their vapours or mists. However, repeated and prolonged skin contact with petroleum products, such as this grade, may result in skin irritation, dermatitis and low-incidence long-term skin disorders. Unnecessary skin contact should be avoided.

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Typical Properties are typical of those obtained with normal production tolerance and do not constitute a specification. Variations that do not affect product performance are to be expected during normal manufacture and at different blending locations. The information contained herein is subject to change without notice. All products may not be available locally. For more information, contact your local ExxonMobil contact or visit [www.exxonmobil.com](http://www.exxonmobil.com)

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