

# RELIACUT AY25

## Active Sulfur Type, Non-chlorinated Anti-mist Cutting Fluid

**RELIACUT AY25** is a chlorine-free anti-mist type cutting fluid blended with new active sulfur type extreme pressure agents, friction modifiers, and multiple oiliness agents. It is suitable for lathe turning, broaching, tapping and rolling of difficult-to-cut materials such as heat-resistant alloys, stainless steels and hardened steels. It is also prepared for automatic plate processing (Peterman type) of steel materials including stainless steel. **RELIACUT AY25** corresponds to JIS type N4, No.8 (JIS K 2241).

### ● Special Features

#### 1. Excellent Cutting and Grinding Performance

Because **RELIACUT AY25** is blended with highly refined base oils, special active sulfurized extreme-pressure agents and friction modifiers, it provides improved finished surface roughness and longer tool life in the general machining of ferric metals.

#### 2. Excellent Anti-mist Performance

**RELIACUT AY25** contains special mist prevention agents that reduce the amount of oil mist formed during machining. The result is an improved working environment. It also contributes to make a readily visible cutting position since it is light-colored and decreasing oil mist.

#### 3. Low odor

Since the additives of **RELIACUT AY25** are low odor, the work environment is improved.

#### 4. Contribution to the viewing of the processing point

**RELIACUT AY25** can enable to watch the processing point easily because of the reduced floating mist and light oil color.

### ● Applications

Lathing, broaching processing, tapping processing, and rolling processing of difficult-to-cut materials such as heat-resistant alloy, stainless steel and hardened steel

Automatic plate processing of steel materials including stainless steel (excluding Peterman type)

### ● Containers

200-liter drums and 20-liter cans

### ● Typical Properties of RELIACUT AY25

|                             |                    |             |
|-----------------------------|--------------------|-------------|
| Appearance                  |                    | Light brown |
| Color(ASTM)                 |                    | L3.5        |
| Density(15°C)               | g/cm <sup>3</sup>  | 0.924       |
| Kinematic viscosity(40°C)   | mm <sup>2</sup> /s | 26.8        |
| Kinematic viscosity(100°C)  | mm <sup>2</sup> /s | 5.52        |
| Flash point(COC)            | °C                 | 176         |
| Pour point                  | °C                 | -12.5       |
| Acid number                 | mgKOH/g            | 3.69        |
| Copper corrosion(100°C, 1h) |                    | 4           |
| Fatty content               | mass%              | 20          |
| Sulfur content              | mass%              | 4.23        |

Note: The typical properties may be changed without notice. (February 2012)



## Handling Precautions

▼ Follow these precautions when handling this product.

|                                  |   |
|----------------------------------|---|
| <b>Composition :</b>             | Base Oil, Additives   |
| <b>Precautionary pictograms:</b> |   |
| <b>Signal word:</b>              | Warning   |
| <b>Hazard Statement:</b>         | Causes skin irritation<br>Causes serious eye irritation   |
| <b>Precautionary Statements:</b> |   |
| <b>Prevention</b>                | <ul style="list-style-type: none"><li>• Do not handle until all safety precautions have been read and understood.</li><li>• Wear protective gloves/protective clothing/eye protection/face protection.</li><li>• Do not allow the eyes to become exposed to the product. Do not swallow the product.</li><li>• Wash hands thoroughly after handling.</li><li>• Do not eat, drink or smoke when using this product.</li></ul>  |
| <b>Response</b>                  | <ul style="list-style-type: none"><li>• IF SWALLOWED: Immediately call a POISON CENTER or doctor/physician.</li><li>• IF SWALLOWED: Rinse mouth. Do NOT induce vomiting.</li><li>• If the eyes are exposed to the product: Rinse the eyes with plenty of running water and immediately contact a physician.</li><li>• IF ON SKIN: Wash with plenty of soap and water.</li><li>• Take off contaminated clothing and wash before reuse.</li><li>• If skin irritation occurs : Get medical advice/attention.</li><li>• IF IN EYES: Rinse continuously with water for several minutes. Remove contact lenses if present and easy to do. Continue rinsing.</li></ul> |
| <b>Storage</b>                   | <ul style="list-style-type: none"><li>• The product must be stored in a cool, well-ventilated location where it will not be exposed to direct sunlight.</li><li>• Containers that have been opened must be tightly sealed.</li></ul>  |
| <b>Disposal</b>                  | <ul style="list-style-type: none"><li>• Dispose of contents/container in accordance with local/regional/national/international regulations.</li><li>• If there are any doubts about proper methods of handling the product, contact the point of purchase before proceeding with usage.</li></ul>   |