



TECHNICAL DATA

ROCOL RTD Metalcutting Liquid

Reaming, tapping and drilling lubricant

Description

Rocol RTD Metalcutting Liquid is a medium viscosity high performance metal cutting lubricant for all machining operations including reaming, tapping and drilling on all metals. It may be used neat or as an additive to boost the performance of conventional mineral cutting and forming oils, and may also be used as a die lubricant on severe drawing, punching and presswork operations.

Rocol RTD Metalcutting Liquid can be used to gain improved performance on all metal cutting operations where lubricant is applied direct to the work piece or as a flood coolant. The high concentration of EP additives makes it particularly suitable when cutting tough alloys, stainless and nimonic steels on the more arduous operations such as broaching, gear cutting, threading, deep hole drilling and form turning

Areas of application

- Reaming
- Tapping
- Drilling
- Metal forming
- Broaching

Features

- Easily applied to difficult areas
- Prolongs tool and die life
- Improves thread and surface finish
- Excellent penetration into deep holes and slots
- Prevents welding - ideal for difficult metals
- NZ MAF Approved C14 (fish, game, meat)

Directions for use

Rocol RTD Metalcutting liquid can be applied directly to the tool piece or metal surface using the convenient squirt top bottle. Rocol RTD Metalcutting Liquid can also be easily added to conventional neat mineral cutting oils to improve their performance. Add 1 part Ultracut with up to 100 parts of neat cutting oil depending on the workpiece material and severity of the machining operation. For severe operations a maximum dilution of 25:1 is recommended. It is not suitable as an additive to water based fluids.

Technical data

Appearance	Brown Liquid
Temperature Range	
Operating	-10°C to +250°C
Extreme Pressure Agent.....	Chlorinated and sulphurized compounds
Flammability.....	Non Flammable

The information enclosed in this Technical Bulletin is as up to date and correct as possible as at the time of issue. The data provided in this Technical Bulletin should be used as a guide only, as the performance of the product will vary depending on differing operating conditions and application methods.

The sale of any product described in this Technical Bulletin will be in accordance with ITW Polymers & Fluids Pty Ltd Conditions of Sale, a copy of which is available on request. To the extent permitted by law, ITW Polymers & Fluids Pty Ltd excludes all other warranties in relation to this product.

Health & safety information

The product is non-hazardous. A Material Safety Datasheet is available from the Rocol Customer Services Department upon request.

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