

Product INFORMATION



RATAK 4330

A light viscosity general purpose neat cutting oil.

Description

Ratak 4330 is a light viscosity general purpose neat cutting oil compounded with extreme pressure additives to improve tool life and surface finish.

Ratak 4330 was developed by Fuchs Australia as a user friendly neat cutting oil, offering a clear fluid without the typical strong odour of a compounded product.

Ratak 4330 is suited for multi-spindle, index and automatic lathes where the oil must prevent cutting tip welding (B.U.E), remove heat and provide lathe lubrication as well.

Useful Hints

When tool is rubbing/wearing, decrease EP level, increase speed and feed decrease rake angle of tool.

When pick up occurs, increase EP and rake angle of tool, decrease feed and speed.

Note: Product will not stain copper at ambient temperatures although some staining may occur at elevated temperatures.

Characteristics

| Property | Unit | Value | Test Method |
|------------------------------|------|-------------|-------------|
| Appearance | | Clear fluid | Visual |
| Kinematic Viscosity at 40°C | cSt | 32 | ASTM D445 |
| Density @ 15°C | kg/L | 0.892 | ASTM D4052 |
| Flash Point, COC | °C | 200 | ASTM D92 |
| Four-Ball EP Test, Weld Load | kgf | 360 | ASTM D2783 |
| Odour | | Nil | |