

## CUTTING AND DRAWING OILS **OLTEC**

Base oil	Viscosity at 40°C (mm <sup>2</sup> /s)	Flash point (°C)	Copper Strip Corrosion Test	Cl	AW/EP	Steel	Stainless steel hard metals	Alu	Copper alloys	Main uses
<b>Chlorine-free range</b>										
<b>OLTEC Draw 32 SNA</b>	mineral / vegetable	32	> 180	1b	no	**	✓✓	✓✓	✓✓	Cutting, drawing and punching of ferrous and non-ferrous metals. Wire drawing of aluminium wires. Thread forming
<b>OLTEC Draw 60 SNA</b>	vegetable	60	> 110	1b	no	*	✓✓	✓	✓✓	
<b>OLTEC Draw S 46</b>	mineral	46	> 110	4c	no	**	✓✓	✓✓		Difficult cutting and drawing of steel, including alloy and high-alloy steel. Cold heading, drawing, extrusion and rolling. Cutting and drawing on medium and thick sheet metals. Substitute for chlorinated neat oils for difficult drawing operations. Fine cutting of hard carbon steels and deep drawing operations
<b>OLTEC Draw S 50</b>	mineral	66	> 110	4c	no	**	✓✓	✓✓		
<b>OLTEC Draw 90 CF</b>	vegetable	90	> 110	4c	no	**	✓✓	✓✓		
<b>OLTEC Draw 210</b>	mineral	210	> 200	4c	no	***	✓✓	✓✓		
<b>OLTEC Draw 420</b>	mineral	420	> 190	4c	no	***	✓✓	✓✓		
<b>Chlorinated range</b>										
<b>OLTEC Draw V 031</b>	semi-synt.	31	> 200	1b	yes	****	✓✓	✓✓	✓	Very difficult cutting and drawing of steel, including alloy and stainless steel. Deep drawing, drawing, cambering and thread forming. Can be used as an additive (10%) to enhance drawing oils
<b>OLTEC Draw V 033</b>	semi-synt.	110	> 200	1b	yes	****	✓✓	✓✓	✓	
<b>OLTEC Draw V 036</b>	synth.	550	> 200	1b	yes	****	✓✓	✓✓	✓	

✓✓ : Recommended use

✓ : Potential use