CUTTING OIL

ISO 22

REXOIL CUTTING OIL ISO 22 is a high-quality mineral-based cutting oil developed for effective lubrication, heat control and protection of metal surfaces during metalworking and machining operations. Formulated with highly refined mineral base oils and a balanced additive system, it helps reduce friction and heat generation during cutting, minimize cutting tool wear and improve the quality of machined surfaces. Its low-viscosity **ISO VG 22** formulation provides rapid penetration into the cutting zone, ensuring smooth and consistent lubrication.

REXOIL CUTTING OIL ISO 22 is recommended for turning, milling, drilling, reaming, threading, tapping, sawing and general-purpose machining operations. It is suitable for machining ferrous and non-ferrous metals where the rapid penetration, effective lubrication and heat control provided by a low-viscosity cutting oil are required. Its formulation also helps protect tools and machine components against rust and corrosion, contributing to equipment reliability and extended service life.

Features and Benefits

- **Excellent Lubrication Performance** – Helps reduce friction between the cutting tool, workpiece and chips, contributing to improved machining efficiency.
- **Excellent Tool Protection** – Helps reduce cutting tool wear and extend tool service life.
- **Improved Surface Finish** – Provides smoother cutting conditions and contributes to achieving a high-quality machined surface.
- **Effective Heat Dissipation** – Helps dissipate heat generated during machining and reduce excessive temperature buildup in the cutting zone.
- **Excellent Rust & Corrosion Protection** – Protects machine components, tools and machined metal surfaces against rust and corrosion.
- **Good Oxidation Stability** – Resists oil degradation and helps minimize the formation of sludge and deposits.
- **Good Chip Removal Properties** – Helps efficiently remove chips from the machining zone, contributing to a cleaner working environment.

Approval and Specifications

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Technical Specifications

Test	Method	Typical Properties
ISO GRADE		**22**
Kinematic Viscosity (40°C), [cSt]	ASTM D445	19,8 – 24,2
Viscosity Index	ASTM D2270	Min. 95
Flash Point, °C	ASTM D92	Min.190
Pour Point, °C	ASTM D97	Max. -18

Health and Safety

This product does not pose a significant health or safety risk when used appropriately. For detailed safety information, please refer to the Safety Data Sheet (SDS).

Storage & Handling

Store in a cool, dry, and well-ventilated area, away from direct sunlight and moisture. Keep containers tightly closed to prevent contamination. Dispose of contents and containers in accordance with local regulations.

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