

RELIACUT AX Series

Active Sulfur Type, Chlorine-free Anti-mist Cutting and Grinding Fluid

RELIACUT AX Series are chlorine-free anti-mist type cutting fluids blended with new active sulfurized extreme-pressure agents combined with new friction modifiers. **RELIACUT AX Series**, which contain far higher levels of active sulfurized extreme-pressure agents than **RELIACUT AH Series**, are the ideal oils for cutting of difficult-to-cut steel materials such as high-alloy steel, hardened steel and stainless steel, and are prepared for heavy cutting under severe conditions.

● Special Features

1. Excellent Cutting and Grinding Performance

Because **RELIACUT AX Series** are blended with highly refined base oils, new special active sulfurized extreme-pressure agents and friction modifiers, they provide improved finished surface precision and longer tool life in general machining and grinding processing.

2. Excellent Anti-mist Performance

RELIACUT AX Series contain special mist inhibitor that suppresses oil mist generated during the machining, thus can improve the working environment.

3. Low odor

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

4. Visualization of the Machining Point

The machining point can be easily observed, because of the reduced floating mist on the machining point.

● Applications

RELIACUT AX 15

Suited for lathe turning, reaming, boring, threading, deep hole drilling (BTA, gun drilling) and cutting of hard-to-cut materials such as heat-resistant alloys, steel materials including stainless steel and hardened steel, etc.

Suited for gear shaping and gear shaving processing of steel materials.

RELIACUT AX 25

Suited for tapping, automatic lathe processing and broaching of steel materials including stainless steel and hardened steel, etc.

● Containers

200-liter drum and 20-liter can

● Typical Properties of RELIACUT AX Series

		AX 15	AX 25
Appearance		Light brown	Light brown
Color (ASTM)		L2.5	L2.5
Density (15°C)	g/cm ³	0.895	0.905
Kinematic viscosity (40°C)	mm ² /s	16.1	24.3
Flash point (COC)	°C	176	180
Pour point	°C	-12.5	-15.0
Acid number	mgKOH/g	2.29	2.36
Copper strip corrosion (100°C, 1h)		4	4
Fatty oil content	mass%	10.0	10.3
Sulfur content	mass%	5.60	5.74

Note: The typical properties may be changed without notice. (June 2023)




Handling Precautions

▼ Follow these precautions when handling this product.

RELIACUT AX 15

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

RELIACUT AX 25

Composition :	Base Oil(s), Additives
Hazard pictograms:	
Signal word:	Warning
Hazard Statement:	Causes serious eye irritation
Precautionary Statements:	<ul style="list-style-type: none"> • Do not handle until all safety precautions have been read and understood. • Wear protective gloves/protective clothing/eye protection/face protection. • Do not allow the eyes to become exposed to the product. Do not swallow the product. • Wash hands thoroughly after handling. • Do not eat, drink or smoke when using this product.
Response	<ul style="list-style-type: none"> • IF SWALLOWED: Immediately call a POISON CENTER/doctor. • IF SWALLOWED: Rinse mouth. Do NOT induce vomiting. • If the eyes are exposed to the product: Rinse the eyes with plenty of running water and immediately contact a physician. • IF ON SKIN: Wash with plenty of soap and water. • IF IN EYES: Rinse cautiously with water for several minutes. • Remove contact lenses, if present and easy to do. Continue rinsing. • If eye irritation persists: Get medical advice/attention.
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