



TIER ONE
LUBRICANTS
PRODUCT DATA SHEET

Tier One™ Tri-Purpose Cutting Fluid 32

Performance

Tier One Lubricants™ Tri-Purpose 32 Cutting Fluid is a non-staining fluid designed for both ferrous and non-ferrous cutting applications. This product contains special EP and lubricity additives to produce heavy duty capability without active sulfur and allows for faster machining rates without use of phosphorus, zinc, and heavy metals. It helps prevent sludge and varnish formation, and provides rust and corrosion protection for the cutting tools, machine, and parts. Tier One™ Tri-Purpose 32 Cutting Fluid also helps reduce mist and smoke and provides good oxidation stability.

Applications

Tier One™ Tri-Purpose 32 Cutting Fluid is considered a tri-purpose machine tool lubricant since it can be used as a cutting oil, hydraulic oil, or way oil. This makes it ideal for automatic screw machines where a single oil is used for all three purposes. It is recommended for a wide variety of machining operations and alloys.

Typical Analysis*

Test	Results	Test Method
Viscosity at 40°C, cSt	32.0	D445
Viscosity at 100°C, cSt	5.73	D445
Flash Point, min °F	350	D92
Sp. Gravity	0.866	D4052
Active Sulfur	present	
Chlorine	present	
Pour Point, °F	5	D97

*The values shown here are representative of current production. Some are controlled by manufacturing specifications while others are not. All of them may vary within modest ranges.