

YOKOHAMA / CUTTING OIL

NEAT CUTTING OILS

ISO VG 22 / 32 / 46 / 68

PRODUCT DESCRIPTION

YOKOHAMA CUTTING OIL is a range of neat cutting oils supplied in ISO VG 22, 32, 46 and 68, intended for metal-removal processes without water dilution. The oil is designed to establish a lubricating film in the cutting zone, helping control friction and machining heat. Consistent supply supports chip evacuation, dimensional consistency and the quality of machined surfaces. Lower-viscosity grades favour fluid delivery, while higher grades provide a more substantial lubricating film where suitable.

APPLICATIONS

For appropriate turning, drilling, reaming, threading and cutting operations on steel, alloy steel and cast iron in machines designed for neat cutting oils. ISO VG 22 and 32 suit applications favouring more fluid circulation; VG 46 and 68 provide higher-viscosity options. Material-additive compatibility, staining and corrosion risk should be assessed before machining copper alloys, aluminium or other sensitive materials. Maintain oil cleanliness, filtration and chip removal.

MACHINING CHARACTERISTICS

Lubricating film at the cutting edge · Control of friction and heat · Support for surface finish · Chip removal assistance · Viscosity selection suited to the machining process.

TYPICAL TECHNICAL CHARACTERISTICS

PROPERTY	UNIT	TYPICAL VALUE			
		VG 22	VG 32	VG 46	VG 68
ISO Viscosity Grade	—	22	32	46	68
Kinematic Viscosity at 40°C	mm ² /s	22.33	31.34	46.00	68.00
Viscosity Index	—	100.00	98.00	96.50	97.50
Flash Point (Open Cup)	°C	203.00	220.00	226.00	215.00
Pour Point	°C	-15.00	-12.00	-12.00	-10.50

Note: The values shown in this table are typical values and do not constitute product specifications. Minor variations may occur between production batches due to normal manufacturing tolerances.