



Koolkut® ACM

Phillips 66® Koolkut® ACM is a low-viscosity, chlorine-free, inactive cutting oil developed for light-duty machining of aluminum, copper, magnesium, and other soft, non-ferrous metals. It is specially formulated with high quality base oils to provide good cooling and wetting of the cutting tool and workpiece, while penetrating and protecting them against corrosion and the formation of oxides.

Koolcut ACM is clear, allowing good observation of the machining operation. It is non-corrosive to copper and copper alloys and non-staining to aluminum, magnesium, and other soft metals.

Applications

- Grinding
- Milling
- Rolling
- Turning

Features/Benefits

- Excellent performance in machining soft metals
- Non-corrosive and non-staining
- Helps extend cutting tool life
- Good surface finish
- Non-corrosive to copper and copper alloys
- Chlorine-free for reduced environmental impact
- Clear for good visibility of the machining operation

**Chlorine-Free,
Light-Duty
Cutting Oil
for Aluminum,
Copper &
Magnesium**

KEEPING THE
WORLD
RUNNING
SMOOTHLY. 



Koolkut® ACM

Typical Properties	
ISO Grade	10
Specific Gravity @ 60°F	0.901
Density, lbs/gal @ 60°F	7.50
Color, ASTM D1500	1.5
Flash Point (COC), °C (°F)	154 (310)
Pour Point, °C (°F)	-57 (-70)
Viscosity	
cSt @ 40°C	10.3
SUS @ 100°F	63
Copper Corrosion, ASTM D130	1a
Chlorine, wt %	Nil
Fatty Oil, wt %	Nil
Sulfur, Total, wt %	0.02
Sulfur, Active, wt %	Nil

Health & Safety Information

For recommendations on safe handling and use of this product, please refer to the Safety Data Sheet via <http://www.phillips66.com/EN/products/Pages/MSDS.aspx>.

07-12-16

Typical properties are average values only and do not constitute a specification. Minor variations that do not affect product performance are to be expected during normal manufacture, and at different blending locations. Product formulations are subject to change without notification.

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