



Gulf Cut Soluble Oil

Product Description

Gulf Cut Soluble Oil combines the good features of a compounded cutting oil with those of regular emulsions to produce a fluid with maximum cooling ability, excellent lubricity and antiweld properties. It offers a high degree of emulsion stability, corrosion protection, control of rancidity, staining of non-ferrous metals.

Application requirements

Modern tooling and high machining speeds demand the maximum cooling effect of water. At the same time, they require the good feature of petroleum cutting oils: lubricity, antiweld properties and corrosion protection. By combining these qualities, it is possible to obtain longer tool life, higher production and better finishes even on tough-to-machine materials. In addition to these basic qualities, preferred soluble oils are also fortified with an effective germicide to control bacteria growth, rancidity and odor. Other additives are used to control corrosion and foaming.

Recommendations

Gulf Cut Soluble Oil offers six specific advantages which make it exceptionally suitable for tough machining jobs:

- It combines maximum cooling ability with excellent lubricity and antiweld properties. These qualities lead to greater accuracy because tools and workpieces are cooled efficiently.
- It contains an effective germicide which controls bacteria growth, rancidity and odor.
- It provides exceptional corrosion control.
- Gulf Cut Soluble Oil can be diluted to a much greater extent than can general purpose emulsifying oils, thus lowering cutting fluid costs
- At all dilutions, its emulsions remain homogenous, even in hard water, and an effective antifoam agent controls foaming when soft water is used.
- It can be used for machining nonferrous metals without serious staining or corrosion resulting. Each specific combination of metal machinability, tool set-up, feed and speed dictates its own optimum dilution ratios. In general, the richest dilutions range from (oil to water) 1:15 to 1:30 for most difficult jobs. Free machining steels and other materials with high machinability ratings commonly use emulsions of 1:30 to 1:50. Because grinding usually requires maximum cooling with less emphasis on lubrication, dilution ratios of 1:60 to as high as 1:150 yield excellent results in both finish quality and length of wheel life.

Typical Properties

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Viscosity @ 100 °C, cSt	7.82
Pour Point, deg C	-21
Rust Preventive Test	Pass
Copper Corrosion Test	Pass
Falex Wear test	Pass

Properties mentioned above are typical only and minor variations, which do not affect the product performances, are to be expected in normal manufacturing. The above information is based on past history of the grade only and must not be construed as a guarantee of performance. Follow equipment manufacturer's recommendations for performance level and viscosity grade. The Material Safety Data Sheet for this product is available from your nearest Gulf Distributor.

Gulf Oil International

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