



Product Bulletin



Gulf CUT (AC) ACTIVE CUTTING OILS

Gulf CUT Active Cutting Oils (AC) are dark colored, straight cutting fluids that contain a well balanced blend of extreme pressure (EP) additives in the form of active sulfur along with elevated amounts of fat that provide excellent surface finish, promotes longer tool life, greater production and reduced labor cost.

FEATURES AND BENEFITS:

The wide viscosity range and various compounding levels formulated into **Gulf CUT (AC) Active Cutting Oils** make them an ideal choice for a wide range of ferrous metalworking applications where high speeds, smooth finishes and long tool life is a must.

- **Gulf CUT AC 60C** is a low viscosity fluid fortified with anti-weld properties making it an ideal choice for deep hole drilling applications on difficult to machine metals and alloys.
- **Gulf CUT AC 120** is a non-transparent heavy duty fluid formulated to provide strong performance where moderate to severe machining is required. The high level of extreme pressure (EP) additive coupled with fatty oils make this product ideal for threading, tapping and internal grinding and where a high level of surface finish is a must.
- **Gulf CUT AC 150C** contains active sulfur, chlorine and fat. This balanced blend of components makes this product well suited for a wide range of ferrous metalworking applications where high speeds, smooth finishes and long tool life are critical.
- **Gulf CUT AC 180** is a versatile, general purpose cutting oil for use with carbon steels and alloy steels where light to moderately-severe machining service is required. Threading, tapping, drilling and gear shaving are some of the activities well suited for this oil.
- **Gulf CUT AC 315** is an outstanding dark pipe threading oil. This product is well suited for the toughest machining operations on some of the most difficult metals and alloys.

Typical Properties

Grade		AC 60C	AC 120	AC 150C	AC 180	AC 315
Product Code	Test Method	335220	335222	335224	335225	335226
Viscosity SUS @ 100°F	ASTM D-2161	60	120	150	180	315
Flash Point, COC, °F	ASTM D-92	275	350	315	350	>300
Sulfur, %		3	5	2	2	5
Active Sulfur, %		1	3	1	1	3
Chlorine, wt%		2	--	1		
Fat, %		10	10	7	6	12
Phosphorus, wt%						1

Note: **Gulf CUT AC Cutting Oils** contain elevated amounts of active sulfur that will stain soft metals such as brass, bronze, copper and aluminum. Their use in machining applications where these metals are present and staining is an issue should be avoided.

AVAILABILITY:

Gulf CUT Active Cutting Oils are available throughout Gulf's marketing area. Your Gulf representative can provide specific information. Need additional information? Call Gulf @ 1-800-566-GULF (4853) or visit Nu-tierbrands.com.

NU-TIER BRANDS, INC.

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