



Product Bulletin



Gulf CUT C-V CUTTING OILS

Light colored, high quality active sulfur cutting oils

Gulf CUT C-V Cutting Oils are light colored, active cutting oils designed for use in moderate to severe machining operations. These new *clear view* cutting oils are formulated with optimum levels of extreme pressure (EP) additives in the form of sulfur and chlorine. These EP additives react with the metal surface under high temperature and pressure to form a protective surface film at the chip-tool interface.

C-V Cutting Oils are formulated with a new synthetic wetting agent that helps significantly in holding down friction while providing an excellent surface finish on materials with low machinability rating. **Gulf CUT C-V Cutting Oils** offer a new *clear view* forward in cutting oil technology.

FEATURES AND BENEFITS:

- **Gulf CUT C-V 40C** is a low viscosity cutting oil particularly suited for deep hole drilling, grinding, and other metalworking applications where a low viscosity, EP cutting oil is required. Loss of oil due to carry off is minimal.
- **Gulf CUT C-V 80C** is a low viscosity cutting oil compounded with excellent anti-weld properties making it an ideal choice for deep-hole or gun drilling applications on difficult to machine metals and alloys. It is transparent on the work piece, allowing good visual inspection of machined parts.
- **Gulf CUT C-V 190C** is an active, light colored, severe duty fluid formulated to provide strong performance where moderate to severe machining is required. The high level of extreme pressure (EP) additive coupled with synthetic fatty oil make this product ideal for a broad range of machine tool operations, including: threading, tapping, broaching, milling and where a high level of surface finish is a must.
- **Gulf CUT C-V 250C** has the highest level of EP of all the products in this series and can be used where most other cutting oils fail. Contains active sulfur, chlorine and other anti-weld components along with high level of lubricity.
*Recommended for severe machining operations such as broaching, tapping and cold-heading

Typical Properties

| Grade | | C-V 40C | C-V 80C | C-V 190C | C-V 250C |
|------------------------------|-------------|---------|---------|----------|----------|
| Product Code | Test Method | 335318 | 335320 | 335325 | 335330 |
| Viscosity cSt @ 40°C | ASTM D 445 | 8.2 | 15.0 | 39.0 | 53.0 |
| Viscosity SUS @ 100°F | ASTM D 2161 | 40 | 75 | 190 | 250 |
| Flash Point, COC, °F | ASTM D 92 | 290 | 305 | 325 | 360 |
| Specific Gravity, 60°F | | 0.839 | 0.851 | 0.863 | 0.878 |
| Four Ball EP Weld Point, kgf | ASTM D 2783 | 500 | 500 | 620 | 620 |
| Load Wear Index | | 86 | 86 | 95 | 95 |
| Sulfur, % | | Present | Present | Present | Present |
| Chlorine, wt% | | Present | Present | Present | Present |
| Fat Oil, % | | Present | Present | Present | Present |
| Phosphorus, wt% | | None | None | None | Present |

Note: **Gulf CUT C-V 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 C-V 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 www.gulflubricants.net.