



LUBRICANTS



# Product Data Sheet

## Gulfcut® C-V Cutting Oils

### Light colored, high quality active sulfur

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.

### Features and Benefits

- Light Colored
- Excellent surface finish at high speeds
- High levels of lubricity
- Not recommended for yellow or non-ferrous metals

### Applications

- **Gulfcut® 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.
- **Gulfcut® 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.
- **Gulfcut® 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.
- **Gulfcut® 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	Test Method	C-V 40C	C-V 80C	C-V 190C	C-V 250C
Product Code		<b>335318</b>	<b>335320</b>	<b>335325</b>	<b>335330</b>
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	ASTM D 2783	500	500	620	620
Sulfur, %		Present	Present	Present	Present
Chlorine, wt%		Present	Present	Present	Present
Fat Oil, %		Present	Present	Present	Present
Phosphorus, wt%		None	None	None	Present

These properties are typical of current production, minor variations are to be expected in normal manufacturing.

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