

MOLYGULF SPECIALIZED LUBRICANTS

Ultimate High Performance Specialty Lubricants



SG-50 CLEAR THREAD CUTTING OIL



SG-50 Is a Clear Heavy Duty General Purpose Transparent thread Cutting Oil. It Is formulated from the finest quality severely hydro-treated base oils available. These severely hydro-treated base oils, unlike other naphthenic base oil, do not pose any cancer or other health hazard. Blended into these base oils is a highly specialized additive package that allows this product to exhibit very high performance.

APPLICATION:

Heavy duty general purpose transparent cutting oil that is recommended for use in applications where brass, bronze, all types of copper, cost types of aluminum, and high alloy, stainless and mild steels are being machined.

FEATURES:

1. Excellent cooling and lubricity, Excellent extreme pressure protection
2. Ability to machine at high speeds and feed rates, Improved surface finishes
3. Lower tool tip temperatures and prevention of chips from welding tool and work-piece.
4. Resistance to the formation of gummy residues.
5. Excellent corrosion inhibition, including vapor phase inhibition.
6. Excellent waste treatability in waste water systems.

Clear Cutting Oil is micro-emulsion synthetic metalworking fluid designed to machine a wide variety of alloys from aluminum to cast iron. It exhibits excellent bio-static control along with non-staining qualities. It is effective for milling, tapping, sawing, reaming, and other types of machining applications requiring moderate nozzle presses. Proprietary technology offers superior part quality, extended tool life, heat dissipation and fluid longevity. It does not contain any sulfur, chlorine, nitrites, phenols, Diethanolamine (DEA) or heavy metals. It also exhibits excellent corrosion protection, bio-resistance and biostability that allows for longer sump life. It is

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recommended for use in those machines that have coolant nozzle pressures up to 800 psi.

TYPICAL SPECIFICATIONS:

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| API Gravity | 26 |
| Specific Gravity | .8984 |
| Viscosity 100F SUS (ASTM D-445) | 150 |
| Viscosity 210F SUS (ASTM D-445) | 43.3 |
| Viscosity 100F Cst (ASTM D-445) | 31.90 |
| Viscosity 210F Cst (ASTM D-445) | 5.20 |
| Viscosity 40C (ASTM D-445) | 29.03 |
| Flash Point F/C (ASTM D-92) | 340/171.11 |
| Fire Point F/C (ASTM D-92) | 380/193.33 |
| Rust Test (ASTM D-465) | |
| Procedure A (Distilled Water) | Pass |
| Procedure B (Salt Water) | Pass |
| Copper Strip Corrosion Test (ASTM D-130) | |
| 3 hours | 1a |
| Falex EP (ASTM D-323) | |
| Failure Load, lbs. | 3500 |
| Total % Sulfur (inactive) | 1 |
| % Active Sulfur | None |
| Appearance | Clear |