



# TECHNICAL DATA

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## #128N ODORLESS SULFURIZED CUTTING OIL

128N Odorless Sulfurized Cutting Oil is a very low odor, chlorine free, heavy-duty, active sulfur base cutting oil that is designed for use in moderate to severe machining operations such as broaching, gear tapping, and threading of ferrous metals and alloys with low machine ability ratings. 128N Odorless Sulfurized Cutting Oil can also be used in the machining of certain non-ferrous metals such as nickel and certain types of aluminum and aluminum alloys.

128N Odorless Sulfurized Cutting Oil contains a unique synergistic extreme pressure additive system and fatty oil additive. This combination of the unique synergistic extreme pressure additive system and fatty oil additive allows the 128N Odorless Sulfurized Cutting Oil to have the ability to readily react at the chip-tool interface in order to form an extremely effective high lubricity, boundary lubricating film that reduces frictional heat and prevents metal-to-metal contact between the tool and work piece. These additive systems provide the 128N Odorless Sulfurized Cutting Oil with the following performance benefits:

1. Exceptional lubricity and extreme pressure properties.
2. Increased cutting speeds, feel and depth of cut.
3. Longer tool life, and increased machine tool output.
4. Superior surface finish on the work piece and parts.
5. Closer tolerances
6. Minimized machine downtime
7. Low to no odor properties
8. Low to no smoke/mist tendencies

### TYPICAL PROPERTIES

API Gravity 15.6°C	26.0 – 32.0
Specific Gravity 15.5°C (ASTM D-287)	.902
Viscosity 40°C cSt (ASTM D-445)	28.8 – 35.2
Viscosity SUS 100°F (ASTM D-445)	136 – 165
% Active Sulfur (ASTM D-1662)	2.0 min
% Fatty Oil (FTIR)	10 min
Total Acid Number (ASTM D-974)	2.0 mg KOH/g max

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