

## **#174 HI-FILM EXTRA TACKY CUTTING OIL**

Hi-Film Extra Tacky Cutting Oil is a heavy duty general purpose transparent colored 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.

Hi-Film Extra Tacky Cutting Oil is formulated from the finest quality severely hydro-treated naphthenic base oils available. These severely hydro-treated naphthenic base oils, unlike other naphthenic base oils, do not pose any cancer or other health hazard. Blended into these naphthenic base oils is a highly specialized additive package that allows this product to exhibit the following performance characteristics:

1. Excellent extreme pressure and anti-wear properties.
2. Excellent rust inhibition.
3. Non-corrosive. Corrosion and discoloration of copper, nickel, silver, phosphor-bronze, copper-beryllium, and other non-ferrous metals is eliminated.
4. Excellent stability.
5. Increased speeds and feeds. The extreme pressure agents used in this product absorb onto metal surfaces rather than reacting with them. This results in the formation of a barrier film that allows more pressure to be applied to the workpiece, since friction is greatly reduced. This results in more parts being produced.
6. Longer tool life.
7. Improved surface finish. This results in less surface distress, and welding and plowing of the metal surface.

Also blended into these naphthenic base oils and highly specialized additive package is an adhesive-cohesive additive. This adhesive-cohesive additive assures that the HI-Film Extra Tacky Cutting Oil will not sling off and mist, especially during high speed cutting operations.

HI-Film Extra Tacky Cutting Oil does not contain any active sulfur, chlorine additives, nitrites, phenols, phosphorus compounds, heavy metals or any other compounds that have been found to be objectionable by the EPA or OSHA.

Typical Properties on Next Page

TYPICAL PROPERTIES

API Gravity	26
Specific Gravity	.8984
Viscosity 100°F SUS (ASTM D-445)	150
Viscosity 210°F SUS (ASTM D-445)	43.3
Viscosity 100°F Cst (ASTM D-445_	31.90
Viscosity 210°F Cst (ASTM D-445)	5.20
Viscosity 40°C (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

Packaging: #174 Hi-Film Extra Tacky Cutting Oil is available in 55 gallon drums, 30 gallon drums and 5 gallon pails.