

DURALIFE® ACTIVE SULFUR NEAT CUTTING OILS

DURALIFE® ACTIVE SULFUR NEAT CUTTING OILS are the chlorine free, heavy duty active sulfur neat metalworking oils, specially formulated for a wide range machining operations with different extreme pressure requirements, where active oils are required and the advantages of transparent oils are desired. They have a wide range of viscosities and additive levels for individualized applications.

APPLICATIONS:

DURALIFE® ACTIVE SULFUR NEAT CUTTING OILS are recommended for machining tough ferrous alloys as well as mild steel, cast iron and all steels including low and medium carbon as well as nickel and chrome alloy types in such operations as milling, drilling, turning, grinding, broaching, thread cutting and tapping.

- ❖ **A 10** is highly active and has low viscosity for severe operations such as deep hole drilling where good chip flushing is needed.
- ❖ **A 20** has low additive and medium viscosity for mild general machining operations.
- ❖ **A 30** has medium additive and medium viscosity for medium-to low-machinability steel and titanium. It is also a good form- and thread-grinding oil for hard steels.
- ❖ **A 40** is highly active and has high viscosity for use on steels with the most difficult machinability, e.g. all types of stainless and heat-resistant steels. It can also be used in severe machining operations, such as gear shaping and internal broaching. Excellent form- and thread-grinding oil for the soft, tough, or stringy steel alloys.
- ❖ Since they contain a large amount of active sulfur, these oils are not recommended for machining copper, brass or aluminum due to potential staining problems.

BENEFITS:

- Transparent characteristic permitting a full view of the work.
- Provide excellent cooling and lubrication in a wide range of machining operations.
- High flash points help prevent smoking in service.
- Dramatically reduce oil mist in high-speed machine tools.

TYPICAL CHARACTERISTICS:

Test	Method	Typical results			
		A 10	A 20	A 30	A 40
Viscosity @ 40°C, cSt	ASTM D445	10.5	22	29	46
Flash Point, °C (° F)	ASTM D92	185 (365)	195 (383)	210 (410)	210 (410)
Pour Point, °C (° F)	ASTM D97	-25 (-13)	-15 (5)	-15 (5)	-25 (-13)
Active Sulfur @150 °C, % wt, min	ASTM D1662	1.7	0.7	1.0	1.7

The above characteristics are average values based on recent production. Minor variations which do not affect product performance are to be expected in normal manufacture.

WARNING :

Continuous contact with used oil has caused skin cancer in animal tests. Avoid prolonged contact. Thoroughly wash exposed areas with soap and water. Keep out of reach of children. Don't pollute. Conserve resources. Return used oil and bottle to collection centers

Reference SDS Number 12040 database on our website at www.amtecol.com OR scan the code for a direct link

