

Supplier - SMART OIL  
**Smart Base 1238**  
*Sulfurized Olefin*  
*Dark Color Sulfurized Additives*

### Typical Properties

Appearance	Dark Brown Liquid
Specific Gravity@25°C	1.000 - 1.100
Viscosity@40°C, cSt	50 - 130
Sulfur Content (Active), %wt	33 - 38 (27)
Acid Value, mgKOH/g	≤ 8
Flash Point C.O.C., °C	> 180
Copper Corrosion+	4B
P <sub>B</sub> /P <sub>D</sub> , kg++	82 / 315

\*10% additive in SN150, 3h, 100

\*\*4 Ball Wear Test; 5% additive in SN150, Server Motor Speeds reach 1500rpm (P<sub>B</sub>) and 1760rpm (P<sub>D</sub>) in 0.03sec.

### Product Description

**SMART BASE 1238** is a high-sulfur additive suitable for severe metalworking operations; it can satisfy the jobs that require high-sulfur and low viscosity; including stainless and high-alloy steel operations.

**SMART BASE 1238** has good compatibility with other additives in formulations. It exhibits special synergistic effect when blended with other chlorinated, or chlorinated replacement additives.

**SMART BASE 1238** possesses relatively low odor and low viscosity, so blending is easy.

**SMART BASE 1238** has high content of active sulfur; so it is not suitable for use on non-ferrous metals such as red copper, bronze and brass.

#### Applications

Threading  
 Threading  
 Cold Heading  
 Cutting

#### Suggested Treat Rates, %wt

3 - 10  
 3 - 10  
 3 - 8  
 2 - 5

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