

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 _B /P _D , kg++	82 / 315

*10% additive in SN150, 3h, 100

**4 Ball Wear Test; 5% additive in SN150, Server Motor Speeds reach 1500rpm (P_B) and 1760rpm (P_D) 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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