



LUBRICANTS



Product Data Sheet

Gulfcut® Active Cutting (AC) Oils

Active Metal Removal Fluids for Severe Machining

Dark colored, straight cutting fluids that contain a well-balanced blend of extreme pressure (EP) additives in the form of active sulfur along with elevated amounts of fat that provide excellent surface finish, promotes longer tool life, greater production and reduced labor cost.

Features and Benefits

- Wide range of viscosities
- High levels of lubricity
- Smooth Finishes
- Long tool life

Applications

- **Gulfcut® AC 60C** is a low viscosity fluid fortified with antiweld properties making it an ideal choice for deep hole drilling applications on difficult to machine metals and alloys.
- **Gulfcut® AC 120** is a non-transparent heavy-duty fluid formulated to provide strong performance where moderate to severe machining is required. The high level of extreme pressure (EP) additive coupled with fatty oils make this product ideal for threading, tapping and internal grinding and where a high level of surface finish is a must.
- **Gulfcut® AC 150C** contains active sulfur, chlorine and fat. This balanced blend of components makes this product well suited for a wide range of ferrous metalworking applications where high speeds, smooth finishes and long tool life are critical.
- **Gulfcut® AC 180** is a versatile, general purpose cutting oil for use with carbon steels and alloy steels where light to moderately-severe machining service is required. Threading, tapping, drilling and gear shaving are some of the activities well suited for this oil.
- **Gulfcut® AC 315** is an outstanding dark pipe threading oil. This product is well suited for the toughest machining operations on some of the most difficult metals and alloys.

Typical Properties

Grade	Test Method	AC 60C	AC 120	AC 150C	AC 180	AC 315
Product Code		335220	335222	335224	335225	335226
Viscosity SUS @ 100°F	ASTM D-2161	60	120	150	180	315
Flash Point, COC, °F	ASTM D-92	275	350	315	350	>300
Sulfur, %		3	5	2	2	5
Active Sulfur, %		1	3	1	1	3
Chlorine, wt. %		2	--	1		
Fat, %		10	10	7	6	12
Phosphorus, wt. %						1

These properties are typical of current production, minor variations are to be expected in normal manufacturing.

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