



Product Bulletin

GULFCUT® ACTIVE CUTTING OILS

Gulfcut® Active Cutting Oils (AC) are 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:

The wide viscosity range and various compounding levels formulated into **Gulfcut® (AC) Active Cutting Oils** make them an ideal choice for a wide range of ferrous metalworking applications where high speeds, smooth finishes and long tool life is a must.

- **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 | | AC 60C | AC 120 | AC 150C | AC 180 | AC 315 |
|-----------------------|-------------|--------|--------|---------|--------|--------|
| Product Code | Test Method | 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 |

Note: **Gulfcut® AC Cutting Oils** contain elevated amounts of active sulfur that will stain soft metals such as brass, bronze, copper and aluminum. Their use in machining applications where these metals are present and staining is an issue should be avoided.

AVAILABILITY:

Gulfcut® Active Cutting Oils are available throughout Gulf's marketing area. Your Gulf representative can provide specific information. Need additional information? Call Gulf @ 1-800-566-GULF(4853) or visit Nu-tierbrands.com.

NU-TIER BRANDS, INC.

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