

SULFOFREZOL 1

GENERAL FEATURES:

Sulfofrezol 1 machining oil is manufactured basing on mineral oils, mainly paraffin-base crude oil distillates with the viscosity of $3\div 5^{\circ}\text{E}$ at 20°C with the additive of deseparator and sulphurised mineral oils.

APPLICATION:

- Sulfofrezol 1 sulfurised oil is mainly applied as off-the-shelf cooling and lubricating fluid in high-speed machining of steel and cast iron at high temperatures of the cutting edge and in machining of high strength steel and heat-resistant steel.
- Sulfofrezol 1 is not recommended for machining of non-ferrous metals where high surface quality is required.
- Application period depends on the range of mechanical impurity and sulphur content which should not be lower than 0.4% (m/m).

STANDARDS, APPROVALS. SPECIFICATION:

The oils were successfully tested in the Institute of Advanced Manufacturing and Technology in Krakow.

PARAMETERS	UNIT	TYPICAL VALUES
Solidification point	$^{\circ}\text{C}$	-16
Ignition temperature	$^{\circ}\text{C}$	162
Kinematic viscosity at 50°C	mm^2/s	15.7
Corrosiveness to steel at $100^{\circ}\text{C}/3\text{h}$	-	tough

NOTE:
Physicochemical parameters listed in the table are typical values. Real values are stated in quality control certificates attached to each product lot.

