



TEXACO TRANSULTEX[®]

A, D, F, H

CUSTOMER BENEFITS

Texaco Transultex metalworking fluids deliver value through:

- **Excellent antiweld properties** from active sulfur and chlorine which reduce frictional heat, prevent welding of metal to the tool point, extend tool life and reduce power consumption in moderate to severe duty operations.
- **Transparent, light color** allows operator to better see the machined part during the cutting operation.
- **Antimist control** — Minimizes the amount of stray mist in the air around the machine and operator.

FEATURES

Texaco Transultex cutting oils are transparent, light color, low odor cutting oils containing chlorine and active sulfur. The product line varies in viscosity and EP level to cover the widest range of machining operations and conditions.

Texaco Transultex cutting oils contain effective antiweld additives that react at the chip-tool interface to form boundary lubricating films that reduce frictional heat and prevent welding of the tool and workpiece.

With the exception of Texaco Transultex D, the Texaco Transultex line of cutting oils contains fatty oil lubricity additives that provide better surface finish.

Texaco Transultex cutting oils are formulated with paraffinic base stocks with naturally high viscosity index. These cutting oils have high flash points, minimizing the potential for fire. They also contain an effective mist control agent that reduces stray mist around the machine. This improves shop cleanliness and reduces operator exposure to the cutting oil.

FUNCTIONS

Texaco Transultex metalworking fluids:

- provide excellent cooling and lubrication in a wide range of machining operations
- prevent welding of chip and tool
- flush chips away from the work area
- protect the finished work surfaces, tools and machines against rusting and staining
- dramatically reduce oil mist in high-speed machine tools

APPLICATIONS

Texaco Transultex cutting oils vary in viscosity and compounding levels to cover a wide range of machining operations and conditions.

Texaco Transultex A is a low viscosity cutting oil, particularly suited for deep hole drilling, grinding and other operations where a low viscosity oil is preferred.

Texaco Transultex D is recommended for a wide variety of moderate to severe machining operations. Transultex D contains no fatty oil and is particularly useful in operations where surface finish is not critical. Transultex D is also recommended for more severe grinding applications where products containing fat could result in loading of the grinding wheel.

Texaco Transultex F is recommended for a wide variety of moderate to severe machining operations where surface finish of the workpiece is important. Transultex F is particularly useful in form grinding applications and in deep hole drilling operations on difficult to machine metals and alloys.

Texaco Transultex H has the highest level of EP compounding and is recommended for the most severe cutting operations on the most difficult metals and alloys.

Texaco Transultex cutting oils contain active sulfur that is staining to yellow metals. Texaco Transultex cutting oils should not be used to machine copper and its alloys.

TYPICAL TEST DATA

	A	D	F	H
<i>CPS Number</i>	220482	220785	221557	221575
<i>MSDS Number</i>	14157	8906	8906	8906
API Gravity	32.2	28.9	28.0	24.5
Viscosity, Kinematic cSt at 40°C cSt at 100°C	12.1 3.0	35.4 5.9	35.1 6.0	52.2 7.7
Viscosity, Saybolt SUS at 100°F SUS at 210°F	70 36	182 46	180 46	269 52
Color	L 1.0	L 1.0	L 1.5	L 1.5
Sulfur	Present	Present	Present	Present
Chlorine	Present	Present	Present	Present
Phosphorus	None	None	None	Present
Fatty Oil	Present	None	Present	Present

Typical test data are average values only. Minor variations which do not affect product performance are to be expected in normal manufacturing.