

SUL-PERM 18
Sulfurized Sperm Oil Replacement
Lubricity and EP Additive

SUL-PERM 18 was developed as a replacement for sulfurized sperm oil. It provides excellent lubricity and is soluble in a wide variety of base oils, though it is particularly effective in heavy duty cutting oils for ferrous metals. **SUL-PERM 18** is applied in straight oil machining, drawing and stamping fluids. It can also be formulated into soluble oils.

SUL-PERM 18 contains active sulfur and is not recommended to be formulated into fluids that are used to work copper, brass or bronze. The following information represents typical, starting point formulation guidelines:

	<u>% Weight</u>
Straight Oil (Machining)	3-10
Straight Oil (Drawing and Stamping)	5-20
Soluble Oil (Machining)	3-10

SUL-PERM 18 should be stored in an original container or bulk storage tank. Exposure to 0°F for a prolonged time period causes solidification. Warming drums to 80-100°F should reverse this. Bulk tank storage temperature should be maintained between 80-100°F. Material in a heated bulk tank should be recirculated or mixed to avoid localizing overheating. Blending temperatures should not exceed 130°F.

TYPICAL PROPERTIES

Property	Result
Total Sulfur, % (Active %)	17.5 (5-6)
Copper Corrosion (10% in oil, 210°F, 3 hrs)	4b
Specific Gravity @ 25°C	1.02
Density (lb/gal)	8.5
Viscosity @ 100°F (210°F), SUS	3,100 (260)
Viscosity @ 40°C (100°C), cSt	590 (54)
Pour Point, °F (°C)	60 (16)
Acid Value, mgKOH/g	7.4
Flash Point, C.O.C., °F (°C)	>350 (>177)

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