



**BASE 18 V**  
***Sulfurized Fatty Compound***  
***Lubricity/Extreme Pressure Additive***

**Base 18 V** is a low cost sulfurized compound that offers extreme pressure protection and lubricity to straight oil and water dilutable metalworking fluids. **Base 18 V** contains 7% active sulfur and is thus not recommended for use in materials destined for applications involving yellow metals (copper, brass, or bronze).

**Base 18 V** can be utilized in straight oil machining, drawing and stamping, as well as a soluble oil component. Below are typical starting guidelines for usage:

|                                 | <u>% Weight</u> |
|---------------------------------|-----------------|
| Straight Oil Machining          | 5-15            |
| Straight Oil Drawing & Stamping | 3-10            |
| Soluble Oil Machining           | 2-5             |

**Base 18 V** may be stored in an original container or bulk storage tank. Prolonged exposure to 0°F may result in solidification. If the product solidifies, warming to 100-110°F will reconstitute the product. Recommended blending temperatures range from 100-130°F.

**TYPICAL PROPERTIES**

| Property                                    | Result      |
|---------------------------------------------|-------------|
| Total Sulfur % (Active %)                   | 18 (7)      |
| Copper Corrosion (10% in oil, 3 hrs, 210°F) | 4a          |
| Specific Gravity @ 25°C                     | 1.0         |
| Density, lb/gal                             | 8.2         |
| Viscosity @ 210°F, SUS (100°C, cSt)         | 315 (67)    |
| Acid Value, mgKOH/g                         | 5           |
| Flash Point, C.O.C, °F (°C)                 | >350 (>177) |

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