



BASE 4212
Sulphurised Methyl Ester
Low Viscosity, Active Sulphur Additive

Base 4212 is a sulphurised methyl ester designed to be used in products where low viscosity, excellent base oil (especially highly refined paraffinic), stability, and high wetting characteristics are some of the more important features of the finished cutting oil.

Base 4212 can be utilized as a performance booster sump-side, as it will readily mix with currently used product in the system, if applied at a point of even mild agitation or circulation.

Base 4212 may find use in products designed for gun drilling, honing, and heavy duty grinding. The following information represents typical starting point formulation guidelines:

Straight Oils (machining applications)	2 – 15%
Grinding Oils	2 – 15%
Drawing and Stamping	3 – 10%
Soluble Oils (machining applications)	5 – 15%

Base 4212 contains active sulfur; it should not be used in products destined for applications on the yellow metals (copper, brass and bronzes).

Typical Properties

Property	Result
Appearance	Dark Brown Fluid
Specific Gravity @ 15.6°C	0.98
Density, lb/gal	8.17
Viscosity @ 100°F, SUS	325
Viscosity @ 40°C, cS	70
Sulfur Content, % wt.	17.0
Active Sulfur, % wt.	7.0
Neutralization Number, mgKOH/g	4.0
Flash Point, COC, °F	>350
Flash Point, COC, °C	>177

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