DOVER
applied chemistry solutions

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.

	% Weight
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 <40°F for a prolonged time period causes solidification. Warming drums to 100-120°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 localized overheating. Blending temperatures should not exceed 130°F.

TYPICAL PROPERTIES

Property	Typical Result
Total Sulfur, % (Active%)	17.5 (5-6)
Copper Corrosion	4b
Specific Gravity @ 25C	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)

The information contained on this data sheet is believed to be reliable. Since the conditions of application and use of our products are beyond our control, no warranty is expressed or implied regarding accuracy of the information, the results obtained from the use of the product, or that such use will not infringe on any patent. This information is furnished with the express condition that you will conduct your own tests to determine the suitability of the product for your particular use. (insert date)

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