

# VALONA 166 S



METALWORKING



**TOTAL**

Chlorine-free Cutting Oil for Severe Machining.

## APPLICATIONS

- **VALONA 166 S** is a chlorine-free, light colored cutting oil designed to handle the most severe metal removal jobs by either cutting or grinding. Its low viscosity provides good heat transfer from the tool/chip interface.
- **VALONA 166 S** is used on all cutting operations on all ferrous metals: low carbon steels, stainless steel, high nickel steel, and heat resistant alloys.
- Operations include: broaching, tapping, threading, gun drilling, high speed and center-less grinding operations.

## ADVANTAGES

- Very good extreme pressure performance due to the combination of sulfur and phosphorus.
- Increases tool life, prevents ridging, promotes good surface finish.
- Excellent lubricity properties--Increases the tool life on a large scale of cutting parameters maintaining an additive layer on the chip / work piece / tool surface.
- Outstanding oxidation resistance.
- Good anti-misting properties.
- Permits operator surveillance of the work piece at all times.
- Good flushing ability.

TYPICAL CHARACTERISTICS	VALONA 166 S
Appearance	Light Amber Liquid
Color, ASTM D-1500	1.5
Viscosity at 40°C, cSt	16.0 - 18.0
Density @ 60 °F, lbs./gal.	7.30
Specific Gravity @ 60/60 °F	0.875
Flash Point, COC, °F	340
Copper Strip Corrosion	4C
Total Sulfur, %wt.	2.4 min.
Active Sulfur, %wt.	1.7
Chlorine, %wt.	None
Phosphorus, %wt.	0.09
Lubricity Content, %wt.	2.0

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