

SCILIA 22 VF-S



METALWORKING



TOTAL

Chlorine-free Cutting Oil for Moderate Machining and Machine Tool Lubrication.

APPLICATIONS

- **SCILIA 22 VF-S** is a low odor, non-staining, cutting oil dedicated to both ferrous and non-ferrous metals and to the lubrication of various machine parts: bearings, gears, and slideways.
- **SCILIA 22 VF-S** is widely used on cutting operations such as screw cutting on copper alloys, aluminum, low carbon steels, medium, hard, and stainless steels, bronze, tin, nickel, high nickel steel, and heat resistant alloys. It is recommended for all general machining operations especially for deep hole or gun drilling where its low viscosity enables it to penetrate to the cutting edges of the tool and flush out metal chips.
- **SCILIA 22 VF-S** can be utilized as a dual purpose oil in low pressure lube systems where cross contamination of cutting oil and lube oil is a problem.

ADVANTAGES

- Excellent anti-wear and extreme pressure performance.
- Promotes excellent surface finish.
- Excellent lubricity properties--Increases the tool life on a large scale of cutting parameters maintaining an additive layer on the chip / workpiece / tool surface.
- Excellent metal wetting ability.
- Non-staining.
- Anti-mist additive.
- Very good oxidation resistance.
- Excellent compatibility with seals and paints.
- Vanilla odor masking agent.

| TYPICAL CHARACTERISTICS | SCILIA 22 VF-S |
|-----------------------------|-------------------|
| | |
| Appearance | Light Pale Liquid |
| Color, ASTM D-1500 | 1.0 |
| Viscosity at 40°C, cSt | 20.0 - 24.0 |
| Density @ 60 °F, lbs./gal. | 7.22 |
| Specific Gravity @ 60/60 °F | 0.873 |
| Flash Point, COC, °F | 425 |
| Copper Strip Corrosion | 1A-1B |
| Lubricity Content, %wt. | 5.0 |
| Sulfur Content, %wt. | 0.7 |
| Chlorine Content, %wt. | Nil |
| Anti-mist Agent | Yes |

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