

VALONA 121 S



METALWORKING



TOTAL

Dual-Purpose Transparent Cutting and Lubricating Oil.

APPLICATIONS

- **VALONA 121 S** is a chlorine-free, transparent, cutting oil which is efficient over a wide working range of both metals and machining operations.
- **VALONA 121 S** is used on all cutting operations on all ferrous and non-ferrous metals: low carbon steels, brass, aluminum, bronze, copper, tin, nickel, and stainless steel.
- **VALONA 121 S** can also be utilized as a dual purpose oil in low pressure lube systems where cross contamination of the cutting oil and lube oil is a problem.
- Operations include: general machining such as drilling, turning, milling, reaming, tapping and threading of all free machining steels.

ADVANTAGES

- Very good extreme pressure performance due to the addition of inactive sulfur:
- 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 / workpiece / tool surface.
- Outstanding oxidation resistance.
- Non-staining.
- Permits operator surveillance of the workpiece at all times.
- Dual purpose capability.
- Anti-misting agent.

TYPICAL CHARACTERISTICS	VALONA 121 S
Appearance	Light Amber Liquid
Color, ASTM D-1500	1.5
Viscosity at 40°C, cSt	29.0 - 35.4
Density @ 60 °F, lbs./gal.	7.34
Specific Gravity @ 60/60 °F	0.879
Flash Point, COC, °F	400
Copper Strip Corrosion	1A-1B
Sulfur, %wt.	0.5
Lubricity Content, %	8.0

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