

# VALONA 139 S



METALWORKING



**TOTAL**

**Chlorinated Cutting Oil for Severe Machining.**

## APPLICATIONS

- **VALONA 139 S** is a chlorinated, neat cutting and grinding oil **ONLY** dedicated to ferrous metals.
- **VALONA 139 S** is used on all cutting operations on all ferrous and ferrous alloy metals: turning, shaping, milling, grinding. **NOT TO BE USED** on copper alloy metals (stain risk on workpieces after cutting operations).
- Operations include: severe machining such as wire drawing, broaching, drilling, turning, screw cutting, boring, milling, threading, reaming, tapping, and grinding.

## ADVANTAGES

- Very good extreme pressure performance due to the combination of active sulfur and chlorine.
- 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.
- Low mist oil formation.
- Permits operator surveillance of the workpiece at all times.
- Light viscosity means good flushing ability.

| TYPICAL CHARACTERISTICS     | VALONA 139 S        |
|-----------------------------|---------------------|
|                             |                     |
| Appearance                  | Clear Yellow Liquid |
| Color, ASTM D-1500          | 0.5                 |
| Viscosity at 40°C, cSt      | 11.7 - 14.3         |
| Density @ 60 °F, lbs./gal.  | 7.38                |
| Specific Gravity @ 60/60 °F | 0.886               |
| Flash Point, COC, °F        | 320                 |
| Copper Strip Corrosion      | 4C                  |
| Sulfur, %wt.                | 2.6                 |
| Active Sulfur, %wt.         | 1.8                 |
| Lubricity Content, %        | 12.0                |
| Phosphorus, ppm             | Nil                 |
| Chlorine, %wt.              | 1.7                 |

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