



Koolkut® SCF

Koolkut SCF is a heavy-duty active cutting oil developed for deep-hole drilling or gun drilling of cast iron, steel, high-speed steel and other alloys. It is specially formulated with high-quality base oils and fortified with oiliness additives and sulfur-containing extreme-pressure additives that provide reduced friction and good antiweld properties at the chip-tool interface, resulting in extended cutting tool life and good surface finishes on the machined parts.

Gun drilling uses a tungsten-carbide cutting tool to produce accurate, deep-hole configurations. The length of a gun-drilled hole can be up to 250 times its diameter. Gun drilling also is used to drill difficult and hard materials up to 370 Brinell hardness that cannot be economically machined with other types of drilling. Koolkut SCF is ideal for this type of drilling.

Koolkut SCF also is recommended for honing cylinders, such as engine cylinders, clutch slave cylinders and brake wheel/master cylinders.

Koolkut SCF can cause staining of non-ferrous metals such as copper and copper alloys, and is **not** recommended for machining non-ferrous metals.

Applications

- Boring
- Broaching
- Deep hole drilling
- Heavy-duty machining of cast iron, steel and high-speed steel alloys
- Honing
- Milling
- Tapping
- Threading

Features/Benefits

- Excellent performance in most difficult machining operations
- Reduced friction
- Antiweld properties
- Helps extend cutting tool life
- Good surface finish
- Permits clear view of the workpiece

**Heavy-Duty
Cutting Oil For
Gun Drilling &
Cylinder Honing**

CONTACT INFORMATION

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Koolkut® SCF

Typical Properties

| | |
|-----------------------------|-----------|
| ISO Grade | 10 |
| Specific Gravity @ 60°F | 0.884 |
| Density, lbs/gal @ 60°F | 7.36 |
| Color, ASTM D1500 | 4.5 |
| Flash Point (COC), °C (°F) | 182 (360) |
| Pour Point, °C (°F) | -18 (0) |
| Viscosity, | |
| cSt @ 40°C | 14.4 |
| cSt @ 100°C | 3.3 |
| SUS @ 100°F | 79.7 |
| SUS @ 210°F | 37.4 |
| Viscosity Index | 95 |
| Copper Corrosion, ASTM D130 | 1b |
| Chlorine, wt % | 3.2 |
| Fatty Oil, wt % | 10.0 |
| Sulfur, Total, wt % | 2.1 |
| Sulfur, Active, wt % | 1.86 |

Health and Safety Information

For recommendations on safe handling and use of this product, please refer to the Material Safety Data Sheet via <http://w3apps.phillips66.com/NetMSDS>.

Typical properties are average values only and do not constitute a specification. Minor variations that do not affect product performance are to be expected during normal manufacture, and at different blending locations. Product formulations are subject to change without notification.

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