



## Koolkut® Spectrum

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

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

### ***Applications***

Koolkut Spectrum is recommended for medium- to heavy-duty machining of cast iron, stainless steel and high-speed steel alloys. Typical applications include:

- Boring
- Broaching
- Drilling
- Milling
- Tapping
- Threading

### ***Features/Benefits***

- Excellent performance in most difficult machining operations
- Good antiweld properties
- Helps extend cutting tool life
- Good surface finish
- Transparent for good visibility of the machining operation

## **General-Purpose Cutting Oil**

### **CONTACT INFORMATION**

**Phillips66  
Lubricants.com**

U.S. Customer  
Service:  
**1-800-368-7128**

Technical Hotline:  
**1-877-445-9198**

International  
Customer Service:  
**1-832-765-2500**

E-mail address:  
**lubricants@  
p66.com**



## Koolkut® Spectrum

### Typical Properties

<b>ISO Grade</b>	<b>32</b>
Specific Gravity @ 60°F	0.885
Density, lbs/gal @ 60°F	7.37
Color, ASTM D1500	1.5
Flash Point (COC), °C (°F)	216 (421)
Pour Point, °C (°F)	-20 (-4)
Viscosity,	
cSt @ 40°C	32.0
cSt @ 100°C	5.4
SUS @ 100°F	165
SUS @ 210°F	44.4
Viscosity Index	102
Copper Corrosion, ASTM D130	1b
Chlorine, wt %	1.18
Sulfur, Total, wt %	1.08
Sulfur, Active, wt %	0.7
Fatty Oil, wt %	Nil

### 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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