

**Typical Properties**

Appearance	Dark Brown Liquid
Specific Gravity@25°C	1.000 - 1.100
Viscosity@40°C, cSt	50 - 130
Sulfur Content (Active), %wt	33 - 38 (27)
Acid Value, mgKOH/g	≤ 8
Flash Point C.O.C., °C	> 180
Copper Corrosion+	4B
P <sub>B</sub> /P <sub>D</sub> , kg++	82 / 315
Std Packaging (NW / GW, Kg)	230.0 / 213.0

**Product Description**

**SMART BASE 1238** is a high-sulfur additive suitable for severe metalworking operations; it can satisfy the jobs that require high-sulfur and low viscosity; including stainless and high-alloy steel operations.

**SMART BASE 1238** has good compatibility with other additives in formulations. It exhibits special synergistic effect when blended with other chlorinated, or chlorinated replacement additives.

**SMART BASE 1238** possesses relatively low odor and low viscosity, so blending is easy.

**SMART BASE 1238** has high content of active sulfur; so it is not suitable for use on non-ferrous metals such as red copper, bronze and brass.

**Applications**

Threading  
Threading  
Cold Heading  
Cutting

**Suggested Treat Rates, %wt**

3 - 10  
3 - 10  
3 - 8  
2 - 5

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