



Koolkut® Transparent

Phillips 66® Koolkut® Transparent is a high-quality, clear, non-staining cutting oil developed for light- to medium-duty machining of ferrous and some non-ferrous metals, such as mild steel, ductile iron, and aluminum. It is transparent for good visibility of the workpiece during machining operations, and is non-staining to both ferrous and non-ferrous metals.

Koolkut Transparent is specially formulated with high-quality, low-sulfur base oils and fortified with chlorinated paraffins that provide good anti-weld properties and reduced friction at the chip-tool interface, resulting in extended tool life and good surface finishes on the machined parts.

Applications

Koolkut Transparent is recommended for light- to medium-duty machining of ferrous and non-ferrous metals. Typical applications include:

- Automatic screw machines
- Drilling
- High-speed, low feed rate, precision machining
- Light- to medium-duty machining of ductile iron
- Sawing
- Tapping and threading of mild steel
- Turning

Features/Benefits

- Multipurpose cutting oil for light- to medium-duty machining operations
- Transparent for good visibility of the machining operation
- Good anti-weld properties
- Helps extend cutting tool life
- Good surface finish
- Controls heat buildup
- Protects against rust and corrosion
- Non-staining to aluminum

Non-Staining, Transparent Cutting Oil





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Typical Properties	
ISO Grade	32
Specific Gravity @ 60°F	0.890
Density, lbs/gal @ 60°F	7.41
Color, ASTM D1500	1.5
Flash Point (COC), °C (°F)	216 (420)
Pour Point, °C (°F)	-21 (-6)
Viscosity	
cSt @ 40°C	30.6
cSt @ 100°C	5.3
SUS @ 100°F	158
SUS @ 210°F	44.0
Viscosity Index	105
Copper Corrosion, ASTM D130	1a
Chlorine, wt %	1.95
Fatty Oil, wt %	Nil
Sulfur, Total, wt %	0.08
Sulfur, Active, wt %	Nil

Health & Safety Information

For recommendations on safe handling and use of this product, please refer to the Safety Data Sheet via <http://www.phillips66.com/EN/products/Pages/MSDS.aspx>.