

KEYCUT[®] 101 – Valona 4984 S

Dark Sulfur-Based Cutting Oil

Keycut 101 (Valona 4984 S) is specifically designed to tackle tough cutting operations on a wide range of metals and applications including thread cutting of tough, stringy carbon steels. Active sulfur and chlorine compounds are combined with special fatty compounds to provide cooler workpieces, superior finishes, long tool life, smoke/fog control, and high production rates. Keycut 101 (Valona 4984 S) provides high anti-weld and extreme pressure properties. **Do not use Keycut 101 (Valona 4984 S) on copper or copper alloys – use Keycut 101 (Valona 4984 S) for these applications.**

Features

- Active Sulfur And Chlorine Compounding
- Reduces Heat
- Extreme Pressure Additives
- High Lubricity Compounding
- Works On A Wide Range Of Metals And Operations

Performance

- Improves Finishes
- Prolongs Tool Life
- High Load Carrying Capacity
- Cooler Work Pieces
- Reduces Inventory Costs

Applications

Types of Metals

- Carbon Steels
- Stainless Steels
- Nickel
- Other Chromium
- Alloyed Steels

Machines

- Single and Multi-function Screw Machines
- Chuckers
- Turret Lathes
- Drilling
- Milling

Machining Operations

- Turning
- Reaming
- Tapping
- Drilling
- Milling
- Threading
- Gear Cutting
- Shaping
- Broaching

Typical Properties

Product Code #	200564	Copper Strip Corrosion ASTM D 130	4C
Appearance	Opaque, Dark, Brown	Pour Point, ASTM D97, °F	-15
Gravity, API @ 60°F	22.9	Flash Point, C.O.C., ASTM D92, °F	330
Density, lbs/gal., @ 60°F	7.66	Lubricity Constituents	Yes
Viscosity, SUS @ 100°F	180	Sulfur, Anti-Weld %	2.3
Viscosity, SUS @ 210°F	44	Chlorine, Extreme Pressure %	0.5
Color, ASTM D-1500	8+	Fat, %	6.0

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