



## Mach™ Grinding Oils



### WHAT IT DOES:

Commonwealth Oil's **Mach™ 5 & Mach™ 12** Grinding Oils are active, staining, sulfurized grinding oils specifically formulated for use with Cubic Boron Nitride (CBN) grinding wheels. They contain a mixture of thermally stable, high-performance additives blended into oxidatively stable, highly refined base oils.

### WHERE TO USE IT:

**Mach™ 5 & Mach™ 12** Grinding Oils are the product of choice when machining titanium, Hastalloy, Inconel, Waspalloy, and other exotic alloys used in aerospace and nuclear applications. These products are non-chlorinated, and will not cause Rehbinder embrittlement common among chlorinated products.

#### How to use it:

**Mach™ 5 & Mach™ 12** Grinding Oils are fully formulated, ready to use CBN grinding oils. Simply add to the sump and begin machining. We do not recommend adding these oils on top of existing oils in the system due to potential incompatibility issues. Call our customer service team for sump cleaning suggestions when changing oils.

### PERFORMANCE BENEFITS:

**Mach™ 5 & Mach™ 12** Grinding Oils employ the latest, thermally stable additive technology available today. They are oxidation resistant, even when exposed to the exceptionally high temperatures encountered in CBN grinding. These oils are non-chlorinated, and will not contribute to potential Rehbinder embrittlement and fatigue-cracking like many chlorinated products. **Mach™ 5 & Mach™ 12** allow cooler running temperatures which greatly increase wheel life in CBN grinding applications.



**Do not add any other product containing active sulfur or calcium sulfonates to these products. All previous products that may have contained active sulfur or calcium sulfonates must be completely removed from the machine before charging with fresh oil.**



## TECHNICALLY SPEAKING:

Test	Mach™ 5	Mach™ 12
Viscosity: cSt @ 40°C	7.5	12.5
Appearance	Clear yellow liquid	Clear yellow liquid
Copper Corrosion	4C	4C
Flash Point, COC °C	> 130	> 130
Flash Point, COC °F	> 266	> 266
Active Sulfur %	1.2%	1.2%
Total Sulfur %	1.65%	1.65%
Chlorine %	None	None
Phosphorous	Present	Present
Density, lbs./US Gallon	7.01	7.09
Specific Gravity	0.84	0.85

These are typical figures and do not constitute a specification.

### Handling & Safety Information

For information on the safe handling and use of this product, refer to the Material Safety Data Sheet obtainable from Commonwealth Oil Corporation.



**Available in Pails, Drums and One-Way Bulk Containers**

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