

# Shell TONNA® Oil V

## High tackiness machine tool slideway lubricants

Shell TONNA® Oils V are specially designed for the lubrication of machine tool slides and tables. They are based on highly refined mineral oils and contain additives to enhance tackiness, anti-wear and stick-slip characteristics. They are specially recommended in cases where high adherence is required.

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### Performance Features and Benefits

- **Excellent slideway adhesion**

The high tackiness agent content provides very effective adhesion to slideway surfaces, resisting wash-off by metalworking fluids and thus helping to reduce oil consumption and thereby giving more uniform working conditions for the machine.

- **Ready separation and high compatibility with water-extensible cutting fluids**

Separates readily from water-extensible metalworking oils allowing easy removal by skimming. The formulation prevents loss of performance in the presence of contamination.

- **Good frictional properties**

"Stick-slip" problems are overcome, allowing more accurate positioning. This provides benefits of improved finished surface quality and dimensional accuracy of workpieces.

- **Good anti-wear performance**

Provides anti-wear protection for slideways, gears, bearings and hydraulic system components.

- **Excellent corrosion prevention characteristics**

Provides effective protection of machine tool surfaces and components in the presence of water-extensible cutting fluids.

### Main Applications

- **Machine tool slideways, tables and feed mechanisms**

Developed for use on a wide range of materials used for machine tool slideway surfaces, including cast iron and synthetic materials.

Shell TONNA® Oil V 68 is intended for horizontal slideways and can be also be used in the hydraulic and gearbox system. For vertical slides use Shell TONNA® Oil V 220.

Advice on applications not covered in this handbook may be obtained from your Shell representative.

### Specifications, Approvals, and Recommendations

Shell TONNA® Oils V meet the following specifications:

Cincinnati Machine P-50 (220), P-47 (68)

### Handling and Safety Information

For information on the safe handling, storage, or use of this product, refer to its Material Safety Data Sheet at <http://www.epc.shell.com/>. If you are a Shell Distributor, please call 1+800-332-6457 for all of your service needs. All other customers please call 1+800-237-8645 for all of your service needs.

### Protect the Environment

Do not discharge into drains, soil, or water.

## Typical Physical Characteristics

Shell TONNA® Oil V	Test Method	68	220
Kinematic Viscosity @ 40°C cSt @ 100°C cSt	ASTM 445	6.8	220
		8.9	18.5
Viscosity Index	ASTM 2270	105	99
Density @ 15°C kg/L	ASTM 4052	880	895
Flash Point, COC, °C	ASTM D 92	225	250
Pour Point °C (ISO 3016)	ASTM 97	-24	-15

*These characteristics are typical of current production. While future production will conform to Shell specifications, variation in these characteristics may occur.*