

# Cutting Oil

## Oils and Lubricants



### DESCRIPTION

Application specific lubricants for both manual and machine metal working operations. Used for sawing, drilling, turning or thread cutting with all types of metals. These are superior quality cutting oils formulated to produce consistent results under all weather conditions. **Hercules Cutting Oils** contain activated sulfur to provide anti-weld properties, reduce friction and prevent excessive heat generation, thus minimizing material expansion resulting in ill-fitting joints. The high film strength of **Hercules Cutting Oils** maintains a continuous contact of the lubricant with the work assuring quick, accurate and high quality cuts with minimal tool wear. Lubricants contain no nitrosamine forming compounds or chlorinated oils.

#### Clear Cutting Oil

A blend of high quality mineral oils with sulfur base. Used for cutting clean, unbroken threads during manual or low rpm threading machine operations on small sizes of steel and brass pipe. Also applicable for hacksawing and light drilling. Will not stain copper or brass materials.

#### Dark Cutting Oil

Extra heavy blend of high quality mineral oils with sulfur-lard base. Compounded to keep tooling and work cool when used on high speed threading machines. Enables operators to cut clean, sharp threads on steel or brass pipe. Ideal for thread cutting, tapping, broaching, drilling or any application where high speeds and quality finishes are required. A superior quality product that significantly extends tool life and reduces labor time.

### SIZES AND PACKING

STOCK NO.	SIZE	PACKING	WEIGHT/CASE
<b>Clear</b>			
40-110	1 pt.	24	28.6 lbs.
40-115	1 qt.	12	28.0 lbs.
40-120	1 gal.	6	49.4 lbs.
40-125	5 gal.	1	40.2 lbs.
40-140	55 gal.	1	452.0 lbs.
<b>Dark</b>			
40-210	1 pt.	24	28.6 lbs.
40-215	1 qt.	12	28.0 lbs.
40-220	1 gal.	6	49.4 lbs.
40-225	5 gal.	1	40.2 lbs.
40-240	55 gal.	1	452.0 lbs.



Specifications

Cutting Oil

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### APPROVALS AND LISTINGS

USDA Listed

### SPECIFIC USES

Use **Clear Cutting Oil** for the cutting of clean, unbroken threads during manual or low rpm threading machine operations. Also for hack sawing or light drilling. Use **Dark Cutting Oil** for high-speed tapping/threading, broaching, turning or drilling applications.

### SPECIFIC APPLICATIONS\*

**Hercules Cutting Oils** are designed to improve quality and throughput of work, reduce friction, be an effective coolant and significantly increase tool life.

### PHYSICAL PROPERTIES

	Clear	Dark
Specific Gravity:	at 25°C .906	at 25°C .906
Solubility in water:	Insoluble	Insoluble
Boiling Point:	465-900°F	465-900°F
Appearance/color:	Light amber liquid	Dark brownish amber liquid
Odor:	Petroleum odor	Petroleum odor
Viscosity:	30-35 centipoises	45-50 centipoises

### WARNINGS OR CAUTIONS

- Read all cautions and directions carefully before using this product.
- **KEEP OUT OF REACH OF CHILDREN.**
- Avoid contact with eyes or skin. Prolonged or repeated skin contact may cause irritation.
- Avoid breathing vapor, mist or fumes. Use with adequate ventilation.
- Wash thoroughly after handling.

### DIRECTIONS FOR USE

1. Wear safety glasses with side shields to protect eyes from metal shavings.
2. Be sure to start the flow of oil before tooling is in contact with the work.
3. Oil flow should hit the point of friction for best results.
4. Always use properly ground chasers and dies with this quality cooling lubricant to obtain sharp, clean threads without burrs.



### MATERIAL SAFETY INFORMATION

**FOR MORE INFORMATION ON THIS PRODUCT, REQUEST MATERIAL SAFETY DATA SHEET- Clear (MSDS) #43**  
**MATERIAL SAFETY DATA SHEET- Dark (MSDS) #44**

For Delivery by Fax	Call 1-800-942-4636
Internet	See MSDS section of <a href="http://www.herchem.com">www.herchem.com</a>
Mail	Contact Hercules at address below or any Hercules representative

HMS Hazard Warning 1-1-0-A

#### CLEAR INGREDIENTS

	CAS#
Petroleum-Based Lubricating Oil	64742-53-6
or	64742-52-5
Sulfurized Aliphatic Hydrocarbon	67762-55-4

#### DARK INGREDIENTS

	CAS#
Petroleum-Based Lubricating Oil	64742-53-6
or	64742-52-5
Sulfurized Aliphatic Hydrocarbon	67762-55-4
Sulfurized Fatty Oil Esters	n/a

\* For special applications which may not be covered on this or other Hercules literature, please contact Hercules Technical Services Department by phone at 1-800-221-9330 or send a fax to 1-800-333-3456.



**Hercules Chemical Company, Inc.**

111 South Street, Passaic, NJ 07055-9100

Phone: 800-221-9330 • Fax: 800-333-3456

e-mail: [info@herchem.com](mailto:info@herchem.com)

<http://www.herchem.com>

