



## Dark Cutting Oil

### DESCRIPTION

**Black Swan Dark Cutting Oil** is a heavy duty sulfurized-chlorinated base oil that helps cut clean, sharp threads on steel and brass pipe. It is formulated to reduce friction during the machining process. By reducing this friction heat generation is minimized. The results are cleaner, sharper threads, better fitting joints and longer tool life.

**Dark Cutting Oil** is formulated to work on high speed machines. For hand threading applications use **Black Swan Light Cutting Oil**.

**Dark Cutting Oil** is an anti-mist lubricant. Weather conditions will not affect the oil. The quality of the oil is guaranteed to be uniform at all times. The oil is also ideal for stripping, broaching , or milling applications.

### PICTOGRAMS:



Irritant

### CONTENTS

**Dark Cutting Oil** is formulated with 100% virgin petroleum oil, sulfur, chlorine and fat.

Sulfur and chlorine are utilized to minimize tool wear and improve part finish. In these oils, the sulfur and chlorine are attached to the same molecule to achieve a synergistic effect. Thus, these heavily fortified cutting oils are even more powerful than the sulfur and chlorine content would indicate. The presence of fat combines with the sulfur and chlorine to provide exceptional performance in high speed, light duty operations as well as low speed, heavy duty operations. The highly aggressive nature of these oils prevent their use on copper alloys unless black staining is acceptable.

### SPECIFICATIONS

SUS @ 100° F	200
Pounds/Gallon	7.7
Flash Point, F	350
Pour Point, F	0
Sulfur, wt. %	1.8
Chlorine, wt. %	1.6
Fat, wt. %	6.5
Color	BLACK
Copper Corrosion	
ASTM-D 130	4 c

### FUNCTIONS

Primarily, a cutting fluid contributes in three ways to a machining process. First, it acts as a lubricant. By reducing friction, it reduces the heat generated. Second, because frictional heating cannot be completely eliminated - and often not even substantially reduced - the cutting fluid must also act as an effective coolant. Finally, it should act as an anti-weld agent to counteract the tendency of the work material to weld to the tool under heat and pressure. In addition to these primary functions there are other secondary but important requirements that cutting fluids must satisfy.

1. They should flush chips away from the work area.
2. They should protect the finished work surfaces, the tools and the machine against rust and stain.
3. They should not smoke or fog in use.
4. They should not be toxic or produce dermatitis.

### DIRECTIONS

1. Make sure equipment and dies are in good working order.
2. Start flow of oil before dyes are in contact with pipe.
3. Oil flow should hit point of friction for best results.

### CAUTION

Avoid contact with eyes or skin. Prolonged or repeated skin contact may cause irritation. Avoid breathing vapor, mist, or fumes. Wash thoroughly after handling. Use with adequate ventilation. Do not take internally. Keep out of reach of children.

FIRST AID

In case of eye contact, flush eyes with plenty of water for at least 15 minutes. If contact with skin, wash with soap and water. If inhaled, move to fresh air. If swallowed, do not induce vomiting. Get medical attention.

UPC Number and Carton Information

STOCK NO.	SIZE	UPC NUMBER	CARTON CUBIC FEET
05002	pt.	0 54647 05002 7	.358
05005	qt.	0 54647 05005 8	.649
05010	gal.	0 54647 05010 2	1.38
05015	5 gal.	0 54647 05015 7	1.375
05020	55 gal.	0 54647 05020 1	10.72