

# RUGGEDCUT DARK CUTTING AND THREADING OIL RD-SPEC

## PRODUCT DESCRIPTION

### PRODUCT

#### RUGGEDCUT Dark Cutting and Threading Oil

### TYPE

**RUGGEDCUT Dark Cutting and Threading Oil** is a lard base cutting and threading oil containing a high percentage of active sulphur content. Absorbs and throws off heat generated by friction in machining metal or cutting threads. Reduces friction and prevents galling. Cools the cutting teeth of the dies therefore increasing tool and die life. Produces a smooth cut finish.

The highly visible dark oil allows for positive recognition of oil on the cutting surface.

**RUGGEDCUT Dark Cutting and Threading Oil** is formulated to prevent chip welding and prolong tool and die life at high or low speeds by reducing frictional heat and tool wear, as well as power consumption. It also improves surface finish and pushes away metal filings and chips.

Rust and corrosion protection of the metal is also provided.

## RECOMMENDED USES

**RUGGEDCUT Dark Cutting and Threading Oil** is recommended for tough machining operations such as threading and tapping, broaching, and for alloys that are difficult to machine.

## COLOR/CONSISTENCY

Semi-Transparent Dark Brown Oil

## FLASH POINT, COC

390°F (198°C)

## POUR POINT

+15°F (-9°C)

## SPECIFIC GRAVITY° API

26.8

## VISCOSITY cSt at 40°C

32.3

## RD-SPEC

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This product is manufactured in the U.S.A.

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## ENVIRONMENTAL STATEMENT

**RUGGEDCUT Dark Cutting and Threading Oil** is formulated to be nonhazardous to the skin and inhibits growth of all germs and infectious organisms within the oil.

**RUGGEDCUT Dark Cutting and Threading Oil** is free of toxic ingredients, such as poly chlorinated biphenyls and poly nuclear aromatic compounds.

**SEE MATERIAL SAFETY DATA SHEET (MSDS) FOR COMPLETE PRECAUTIONS FOR SAFE HANDLING AND USE.**

## PACKAGING

### U.S. Measure:

Stock Code	Size
<b>Plastic Jug w/Spout</b>	
RD32	1 quart (.95 L)
<b>Plastic Jug w/Spout</b>	
RD1	1 gal. (3.785 L)
<b>Pail w/Handle</b>	
RD5	5 gal. (18.9 L)
<b>55 Gallon Steel Drum</b>	
RD55	55 gal. (208 L)

## WEIGHT PER U.S. GALLON

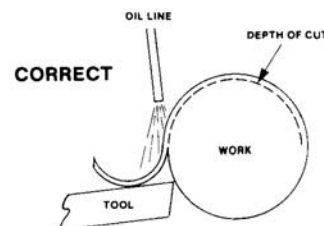
7.6 lbs. (3.5 kg) ± 0.2

## SHIPPING WEIGHT PER CASE

Stock#	Case Weight	#/Case
RD32	27 lbs. (12.2 kg)	12/case
RD1	48 lbs. (21.8 kg)	6/case
RD5	39 lbs. (17.7 kg)	1 each
RD55	454 lbs. (205.9 kg)	1 each

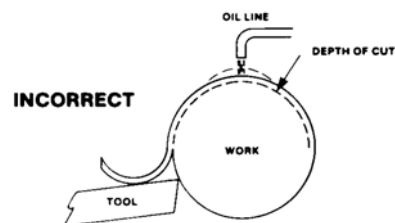
## DIRECTIONS FOR USE

1. Start the flow of oil before dies are in contact with the pipe.
2. Flood the area being cut or threaded to insure against occasional dry cutting periods. Failure to keep surface oiled can result in damage to cutting tools and grinding wheels.
3. Keep the flow of oil on the work zone until the operation of cutting or threading is complete.



**CORRECT**

Showing the correct manner in which cutting fluids should be applied to the tool and work in order that best results may be accomplished.



**INCORRECT**

When oil is applied in this manner, it can neither cool nor lubricate tool or work with any degree of satisfaction.

NOTE: All Whitlam Cutting and Threading Oils are nonsmoking and non fogging. Smoking or fogging of any Whitlam Cutting and Threading Oils can only occur if the fluid is overheated due to inadequate or misdirected oil flow.



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