

# Product Data Sheet

No. **27020** - 05/23

## CUTTING OIL

CARB VOC % <25% Aerosol, <3% Bulk (cutting or tapping oil)

PRODUCT NUMBERS: 7020

Product number plus letter designation is as follows:

G = 2 one-gallon cans per case; F = 1 five-gallon pail; D = 50-gallon drum

### I. GENERAL DESCRIPTION

**Description:** A light-colored, petroleum-based, heavy duty oil for machining, cutting and grinding of hard ferrous metals. This cutting oil is transparent on the surface. It can be used as a general recirculating fluid where misting can be controlled.

**Benefits:** Reduces down-time and sharpening needs. Extends tool life. Protects tools and machined parts against rust and other corrosion. Provides maximum lubricity for ferrous and non-ferrous machining. Clings at any angle. Safe for hard and soft metals. Easy to remove with cleaners.

**Application:** This cutting oil is designed for applications requiring cooling and lubricating at the point of work. Used for sawing and drilling metal. Excellent for difficult operations (grinding and deep drawing and forming). Use on pipe threaders, gear cutters, grinders, drill presses, automatic screw machines and turret lathes.

**Directions:** For aerosol application hold can 12 to 14 inches from surface to be sprayed. Vary spray pressure for density of coating. Keep at room temperature for best results. For bulk application apply with oil can, sprayer, or by dipping. Best when used at room temperature (70°F). Do not use on electrical equipment or machinery while in operation.

**Limitations:** Please refer to the Safety Data Sheet for specific information on material hazards, etc.

#### Packaging:

Aerosol:	Cans (16 oz.)	10.5 oz. net wt. (298 grams)	14.7 fl. oz. (435 ml)
	12 cans/case	12 lbs. (5.4 kg)	0.47 CF (0.013 CM)
	1 case of 2 gallons (mt. F)	18 lbs. (8.2 kg)	0.50 CF (0.014 CM)
	5-gallon pail (m/r)	41 lbs. (18.6 kg)	1.2 CF (0.034 CM)
	50-gallon drum (m/r)	407 lbs. (184.6 kg)	8.5 CF (0.241 CM)



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## II. CHARACTERISTICS & PROPERTIES

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**Specifications:**

None

**Appearance:**

Non-foaming liquid

**Color:**

Light brown

**Dry Schedule:**

Not applicable

**Performance and Chemical Properties:**

	<b>Aerosol</b>	<b>Bulk</b>
Weight per gallon .....	6.5 lbs.....	7.3 lbs.
Specific gravity .....	0.78 .....	0.88
Viscosity in centipoise @ 70°F (21°C).....	Not applicable.....	17 cPs@60rpm Sp#2
Flammability: Label marking .....	Extremely Flammable.....	Non Flammable
Flash point.....	<0° F (-18° C).....	380°F (193°C)
Active ingredients by weight.....	83% .....	100%
EPA VOC% limit .....	Not regulated.....	Not regulated
CARB VOC% limit (cutting or tapping oil) .....	25% .....	3%
SCAQMD VOC limit (cutting or tapping oil).....		<75 g/L
Operating temperature range.....	40° to 110°F (5° to 43°C).....	40° to 110°F (5° to 43°C)
Pour point.....	Not applicable.....	<0°F (-18°C)
Dielectric strength .....	Not applicable.....	Not applicable
Lubricity (FALEX FLC test).....	50 ft. lbs.....	50 ft. lbs.
Penetrating ability.....	Excellent.....	Excellent
Corrosion protection.....	Good.....	Good
Food contact rating .....	Not applicable.....	Not applicable

**Base Materials**

.....	Petroleum Oil.....	Petroleum Oil
Propellant system.....	Hydrocarbon.....	Not applicable

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## III. SHIPPING, STORAGE AND HEALTH

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	<b>Aerosol</b>	<b>Bulk</b>
UN number.....	UN1950.....	N/A
Proper Shipping Description .....	Aerosols .....	Non Regulated Material
Hazard Class.....	2.1.....	N/A
Packing Group .....	N/A.....	N/A
Limited Quantity .....	Yes.....	N/A
Warehouse storage level number .....	NFPA 30B Level 1.....	N/A
Storage temperature .....	32° to 120°F (0° to 49°C).....	32° to 120°F (0° to 49°C)
Shelf life .....	1 to 5 years.....	3 to 5 years
HMIS ratings		
Health.....	1.....	1
Fire .....	2.....	1
Reactivity.....	1.....	0

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## IV. MISCELLANEOUS

Contains no Ozone Depleting Substances (O.D.S.)

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## V. WARRANTY

1-year performance warranty on all products from date of purchase. Report to home office or local Aerove representative for examination. Because Seller cannot control Buyer's handling or use of product, Seller makes no warranty expressed or implied when not used or stored in accordance with directions. Seller shall not be liable for cost of labor, incidental or consequential damages, and this warranty is limited to replacement of product or credit of purchase.