

Product Data Sheet

No. **2890** - 09/21

CUTTING OIL

CARB VOC % <25% Aerosol, <3% Bulk (Cutting or Tapping Oil)

PRODUCT NUMBERS:
890 - 13 OZ. NET. WT. AEROSOL

Product number plus letter designation is as follows:
G = 2 one-gallon can; F = 1 five-gallon pail; D = 50 gallon drum

I. GENERAL DESCRIPTION

Description: Aervoe Cutting Oil is a non-flammable, water-based, industrial strength lubricant formulated to improve metal cutting operations. It is reinforced with high viscosity oils and sulfur free extreme pressure additives. Adheres to the surface, and resists run off or breakdown. Prolongs tool life and cutting edge by lubricating and cooling at the cutting point.

Benefits: Keeps cutting and drilling tools cooler, thereby lengthening useful life. Carries heat away from the tool and cutting edge. The aerosol version allows for precision application. An extension tube is included for hard to reach places and applies directly to work areas, reducing waste. Water based formula provides for low odor, and washes off easily with commercial cleaners, and/or warm water. Contains no ozone depleting substances.

Uses: Use Aervoe Cutting Oil on turret lathes, gear cutters, broaches, and automatic screw machines, and for sawing, tapping, machining, threading, and drilling. Effective on both ferrous and nonferrous metals.

Directions: Aerosol: Shake well before use. Attach extension tube for pinpoint control, and direct spray pattern 3 to 5 inches from the surface to be coated. Apply as often as necessary to maintain cooling action. Bulk: Apply with any type of hand pump applicator, cloth, brush, or automated sump system. Add water as needed for thinning. Washes off easily with commercial cleaners and/or warm water and cloth. Use safety glasses to protect against spatter inherent in application mode. Do not use on electrical equipment or machinery while in operation.

Limitations: Please refer to the Safety Data Sheets for specific information on material hazards, etc. Should not be used on magnesium because of fire danger with water contact. This product can and may discolor copper and copper based metal compounds.

Packaging:

| | | | |
|----------|---------------------------|--------------------|-----------------------|
| Aerosol: | Cans (16 oz.) | 13 net wt. (369 g) | 13.0 fl. oz. (384 ml) |
| | Case (12/case): | 14 lbs. (6.4 kg) | 0.47 CF (0.013 CM) |
| Bulk: | 1 case of 2 gallons (p/f) | 19 lbs. (8.6 kg) | 0.50 CF (0.014 CM) |
| | 5-gallon pail (p/rd) | 46 lbs. (20.9 kg) | 1.2 CF (0.034 CM) |
| | 50-gallon drum (p/rd) | 459 lbs. (208 kg) | 8.5 CF (0.241 CM) |

II. CHARACTERISTICS & PROPERTIES

Specifications:

None

Appearance:

Thin, non foaming

Color:

White, milky

Odor:

Mild

Dry Schedule:

Not applicable

Performance and Chemical Properties:

| | Aerosol | Bulk |
|---|---------------------------------|--------------------------|
| Weight per gallon | 8.28 lbs..... | 8.33 lbs. |
| Specific gravity | 0.99 | 1.0 |
| Viscosity in centipoise @104°F (40°C) | Not applicable..... | 31 |
| Viscosity in centipoise @ 212°F (100°C) | Not applicable..... | 21 |
| Flammability: Label marking | Non-flammable | None |
| Flash point..... | <0°F (-18°C)..... | 300°F (149°C) |
| Active ingredients by weight..... | 95%..... | 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..... | 50° to 90°F (10° to 32°C) | 35° to 90°F (2° to 32°C) |
| Pour point..... | 33°F (1°C) | 33°F (1°C) |
| Dielectric strength | Not applicable..... | Not applicable |
| Lubricity (FALEX FLC Test)..... | >100 ft. lbs..... | >100 ft. lbs. |
| Penetrating ability..... | Good..... | Good |
| Corrosion protection..... | Good..... | Good |
| Food contact rating | Not applicable..... | Not applicable |

Base Materials:Water, Emulsifiable OilWater, Emulsifiable Oil**Propellant system:**1,1-DifluoroethaneNot applicable

III. SHIPPING, STORAGE AND HEALTH

| | Aerosol | Bulk |
|--------------------------------------|-----------------------|------------------------|
| 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 | Max 120°F (49°C)..... | Max 120°F (49°C) |
| Shelf life | 1 to 5 years..... | 3 to 5 years |
| HMIS ratings | | |
| Health | 1..... | 1 |
| Fire..... | 2..... | 1 |
| Reactivity | 1..... | 0 |

IV. MISCELLANEOUS

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

V. WARRANTY

1-year performance warranty on all products from date of purchase. Report to home office or local Aervoe 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.