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**TECHNICAL SPECIFICATION**

**DARK THREAD CUTTING OIL**



**TECHNICAL SPECIFICATION:** Oatey Dark Thread Cutting Oil is formulated with activated sulfur to wet, lubricate and cool dies during threading process. Dark Thread Cutting Oil is designed for use with high rpm machine operations for threading steel and brass pipe.



**COMMON APPLICATIONS**

Oatey Dark Thread Cutting Oil is designed for use with high-rpm pipe threading machines. Can also be used with hand threading tools.

Consult Oatey Technical Department for applications not specifically referenced above.

**INGREDIENTS**

Petroleum Hydrocarbon Mixture

**PHYSICAL/CHEMICAL PROPERTIES**

Specific Gravity	0.92
Solubility in Water	Insoluble
Flash Point	325° F (minimum)
Shelf Life	1 year from manufacture date
Appearance	Dark Brown Liquid
Odor	Petroleum odor
Viscosity	150 Saybolt Univ. @ 100° F

**DIRECTIONS FOR USE**

Cover the surface with oil before the dies come into contact with the pipe. Oil flow should hit the point of friction for best results.

**PRECAUTIONS**

Read all cautions and directions carefully before using this product. Wear safety glasses with side shields to protect eyes from metal shavings. Do not wear loose gloves or clothing around rotating equipment. 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. NOT FOR USE ON STAINLESS STEEL OR SOFT METALS SUCH AS ALUMINUM. Keep container closed when not in use. DO NOT REUSE EMPTY CONTAINER. KEEP OUT OF REACH OF CHILDREN.

Refer to material safety data sheet for more information.  
For emergency first aid help, call 1-303-623-5716 COLLECT.

PRODUCT NUMBER	DESCRIPTION	PACK	CARTON WEIGHT
30203	16 oz. Dark Cutting Oil	12	13 lbs.
30204	32 oz. Dark Cutting Oil	12	26 lbs.
30205	Gallon Dark Cutting Oil	6	50 lbs.