

PRODUCT DATA SHEET

Royal Cutting Fluids – Staining *Heavy Duty Cutting Fluid*



PRODUCT DESCRIPTION:

Royal Cutting Fluid – Staining is a clear, active, general purpose cutting oil for ferrous metals. This outstanding product uses a combination of active sulfur and chlorine for excellent cutting efficiency and improved tool life.

KEY FEATURES:

- Clear Color - Allows visual inspection of both tool and parts during machining process

CUSTOMER BENEFITS:

- Heavy-Duty - Formulated with high concentrations of active ingredients, this product provides excellent performance in the most severe applications

APPLICATIONS:

Machining Operations

PACKAGING:

Totes and Drums

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Royal Cutting Fluids – Staining Heavy Duty Cutting Fluid



Typical Properties

| Royal Cutting Fluids – Staining | | | | | |
|---------------------------------|---------|---------|---------|---------|-------------|
| Product Number | 506 | 508 | 516 | 520 | Test Method |
| API | 23.24 | 21.86 | 22.63 | 18.92 | |
| Specific Gravity | 0.91446 | 0.92267 | 0.91805 | 0.94067 | ASTM 4052 |
| Lbs/Gal | 7.616 | 7.684 | 7.646 | 7.834 | |
| Density | 0.91395 | 0.92216 | 0.91754 | 0.94014 | |
| Flash Point °F | 159 | 157 | 153 | 161 | ASTM D92 |
| Pour Point °F | -18 | -18 | N/A | -18 | ASTM D97 |
| Color | <1.0 | <1.0 | <1.0 | <1.0 | ASTM D1500 |
| Viscosity@100°C cSt | 5.339 | 5.336 | 4.233 | 6.35 | ASTM D445 |
| Viscosity@40°C cSt | 30.85 | 32.41 | 22.13 | 41.34 | ASTM D445 |
| Viscosity Index (VI) | 102 | 95 | 90 | 101 | ASTM D2270 |

Typical Properties are typical of those obtained with normal production tolerance and do not constitute essentially a specification. Variations that do not affect product performance are to be expected during normal manufacture and at different blending locations. The information contained herein is subject to change without notice.

Health and Safety:

When used for its intended application, this product is not expected to have any adverse health implications. For complete information on safe handling, as well as physical and chemical characteristics please refer to the Material Safety Data Sheet (MSDS) found on our website, www.royalmfg.com, or call 918-584-2671. Do not use this product for purposes other than its intended use. Please be responsible to the environment when disposing of used product.