



HGL Industrial

Product Data Sheet

Products for Industry, Office & Home

INDUSTRIAL

Unicut Cutting Oils

HG Laboratories, LLC
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Unicut Light Duty HGO is recommended for machining operations that are not severe. It contains no active sulfur and is safe for machining copper bearing metals.

Unicut Medium Duty GPO provides outstanding performance in general-purpose machine operations. It is recommended for nearly all machining operations on ferrous metals, except heavy-duty operations where tolerance and finish are critical, or for operations such as deep-hole drilling where a low-viscosity oil is needed. It is suitable for all kinds of steel under normal cutting duty. Where staining is not critical, it may be used on brass, bronze, or other copper-bearing alloys

Unicut Heavy Duty TCO is recommended for more severe operations, such as heavy-duty threading, tapping, and broaching on difficult-to-machine metals. Unlike many conventional heavy-duty cutting oils, however, **Unicut Heavy Duty TCO** will operate efficiently on less-difficult materials. Where staining is not critical, it may be used on brass, bronze, or other copper-bearing alloys.

Unicut Dark HDO is a dark, heavy duty cutting oil and is recommended for more severe operations, such as heavy-duty threading, tapping, and broaching.

Physical Characteristics

TEST	METHOD	LIGHT DUTY HGO	MEDIUM DUTY GPO	HEAVT DUTY TCO	DARK HDO
Specific Gravity	ASTM D-287	0.86	0.85	0.86	.89
Flash Point C	ASTM D-92	200	465	480	365
Pour Point C	ASTM D-97	-15	-40	-25	-30
cSt @ 40C	ASTM D-445	23.0	29.9	33.8	40.0
cSt @ 100C	ASTM D-445	4.9	5.4	5.8	5.9
Rust Test	ASTM D-665A	Pass	Pass	Pass	Pass
Viscosity Index	ASTM D-2270	105	110	142	87
Copper Strip Corrosion	ASTM -130	1B	1B	1B	1B

Available packages:
1 gallon bottle-4/case
5 gallon pail
55 gallon drum
275 gallon bulk tank

