

**TECHNICAL DATA SHEET****TCO-14™ DARK    TCO-16™ LIGHT**  
**THREAD-CUTTING OILS****Description:**

Relton's TCO-14 and TCO-16 are a high quality mineral oil (used alone by many machine shops as a general-purpose cutting oil), plus an additive package including sulfur, enhancing the EP properties of the mixture.

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**Typical Uses:**

- Recommended for most machining operations, e.g. drilling, milling, threading, broaching, boring, turning, tapping, engraving reaming, sawing, pipe-threading, (machine or hand).
  - Recommended for high-speed automatic machines, turret lathes, milling machines, lathes and general machine shop equipment.
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**Typical Inspections:**

	<u>TCO-14</u> Dark	<u>TCO-16</u> Light
API Gravity, @ 60°F:	22.7	22.8
Specific Gravity, g/cc, 60°F:	0.9176	0.9170
Pounds per gallon:	7.641	7.646
Viscosity @ 40°C, cst:	23.1	21.1
Flash Point, COC, °F:	350	350
Pour Point, °C:	-10	-10
VOC	nil	nil
Color:	dark brown	amber
Appearance/form:	dark, cloudy/liquid	amber/ liquid

Features:

contain:

- anti-weld properties for improved surface finish
- anti-mist agent to reduce oil mist in the work place
- anti-corrosion agent to block rust and other corrosion of tools or work piece
- anti-foaming agent
- Provide excellent boundary lubrication
- Have excellent metal-wetting properties
- Simplify inventory as multi-purpose cutting oils
- Increase productions rates
- Extend tool life
- Greatly improve surface finish

Caution: contain active sulfur; should not be used to machine copper or copper alloys, such as brass or bronze.

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TCO-16 }  
2/10/97 7/22/05

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