



FISKE BROTHERS REFINING COMPANY

NEWARK, NEW JERSEY 07105 • TOLEDO, OHIO 43605

FISKE'S DARL CONCENTRATE (Cutting Oil Additive)

Darl Concentrate is recommended as an additive to any brand of cutting oil wherever it is felt that longer tool life, better surface finish, faster speeds and feeds or holding dimensions closer to side would be possible with a superior lubricant. Such conditions generally exist in the more difficult machining operations such as broaching, threading or tapping of any metal and especially when having poor machinability such as stainless and alloy steels, high carbon steels, aircraft and tool steels, and the tougher non-ferrous metal -- monel, beryllium copper, phosphor, bronze, etc.

BENEFITS

- Greater Production** - Operating speeds and feeds of the machine may often be increased. This is where superior lubrication can really save you money.
- Easy to Add** - No need to dump your present cutting oil and replace it with another. Just add **Darl Concentrate** to the cutting oil in your reservoir. Dissolves almost immediately after recirculation.
- Non-Staining** - Can be used on all metals. Will not tarnish copper, brass, bronze, monel, aluminum, zinc or any ferrous metal.
- Safe** - No chlorinated solvents, lead compounds or other toxic materials present.
- Economical** - There is no less expensive way to fortify your present cutting oil for heavier duty work than to add **Darl Concentrate**.

Darl Concentrate can be added to any mineral type cutting oil. Starting suggestions are adding 1 gallon of Darl Concentrate to every 5 gallons of cutting oil. The additions should be made directly to the machine with the circulating system in operation. Dilutions can be varied from 1 to 3 to 1 to 10 depending on the severity of the operating conditions.

(Over)

TYPICAL CHARACTERISTICS:

Viscosity @ 100°F., SUS/cSt	2010/434
Flash Point °F./°C.	440/227
Fire Point °F. /°C.	480/249
API Gravity	19.1
Sulfur	Yes
Active Sulfur	No
Chlorine	No
Fatty Material	Yes
Color	Black

Darl Concentrate is available in the following:

<u>Packaging Available</u>	<u>Part Number</u>
5 gallon pail	F0518-060
55 gallon drum	F0518-062