

**YUMAN® DS-50**  
**Premium Quality**  
**Deep Hole Machining Oil**

**PRODUCT DATA SHEET**

**GENERAL DESCRIPTION:**

**YUMAN® DS-50** is a straight metalworking oil specially formulated for deep hole machining operations such as; gun drilling, gun reaming, B.T.A. & ejector drill operation. **YUMAN® DS-50** contains chlorine and sulfur extreme pressure additives that yield good lubricity and reduce built-up edge. **YUMAN® DS-50** may also be used for general machining of steel alloys, stainless steel and aluminum alloys.

**BENEFITS:**

- **EXTENDED TOOL LIFE**
- **BETTER FINISH**
- **REDUCES BUILT-UP EDGE**
- **FACILITATES EASY MACHINING OF DIFFICULT FERROUS AND ALLOY STEELS**

**TYPICAL APPLICATION:**

- **HIGH SPEED STEEL OR CARBIDE TOOLING**
- **GUN DRILLING, GUN REAMING, B.T.A. AND EJECTOR DRILLING**
- **GENERAL TURNING TO HEAVY CUTTING OPERATIONS**
- **BROACHING & TAPPING OF CAST IRON**

**PROPERTIES:**

Appearance.....	Light Yellow Liquid
Color (ASTM) .....	1.0
Viscosity (40 °C).....	12.5mm <sup>2</sup> /s
Specific Gravity (15°/4 °C) .....	.088
Flash Point (COC).....	154 °C
Copper Corrosion (100 °C - 1 hour).....	Inactive

**USING PROCEDURES:**

Use as received.

**MATERIAL SAFETY:**

Safe on ferrous metals when used as directed.

**CONCENTRATION CONTROL:**

Not applicable.

**STORAGE:**

Store in a cool dry area away from heat and flames.

**PRECAUTIONS:**

Please refer to the label and Material Safety Data Sheet for all warnings recommendations for safety equipment and other regulatory information.

**AVAILABILITY:**Pails, Drums, Totes, Bulk