

Description

Natural paraffin mineral oil with low viscosity, formulated with highly refined based oils and selected additives that increase the hardening speed and provide the properties required to overcome the difficult conditions needed in cold, high-speed steel hardening (bath temperature is between 40 and 80°C). This kind of oil is formulated to achieve non-alloy steel parts with maximum hardness and minimum deformations and breaks.

Properties

- Contains additives to achieve good resistance to oxidation and sludge formation, thus prolonging its useful life.
- Provides a very short steam phase during hardening operations thus speeding transfer to the boiling stage and the quick cooling of the metal.
- Very good thermal stability and low volatility, which reduces smoke and the risk of fire.
- Good foam resistance.
- Uniform and lasting hardening capacity.
- Clean, tempered parts are achieved.

Technical specifications

| | UNIT | METHOD | VALUE |
|----------------------------------|----------|-------------|------------------------|
| Appearance | | | Glossy and transparent |
| Colour | | ASTM D 1500 | < 4 |
| Density at 15 °C | g/mL | ASTM D 4052 | 0.875 |
| Viscosity at 40 °C | cSt | ASTM D 445 | 32 |
| Viscosity at 100 °C | cSt | ASTM D 445 | 5.5 |
| Viscosity index | | ASTM D 2270 | 95 |
| Flash point O/C | °C | ASTM D 92 | 200 |
| Aniline point | °C | ASTM D 611 | 95 |
| Neutralisation index | mg KOH/g | | 0.2 |
| Noack volatility, 1 hr at 150 °C | | DIN 51581 | 0.85 |

A safety data sheet is available on request.

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