

Cutting oil - inactive ISO L-MHE

HSF[®] 81 L

HSF[®] 81 L is inactive low viscosity cutting oil containing refined mineral oil, lubricating additives, high pressure (EP) additives and antiwear (AW) additives.

ADVANTAGES

- It takes away very well big amount of heat from the processing zone,
- Low foam at high speeds ensures reliable production,
- High quality and precision of treated items,
- It has high rinsing power,
- Good filtrability prolongs product life,
- It does not have effect on grinding tools,
- It does not have effect on non-ferrous metals,
- Good anticorrosion protection properties guarantee interoperational protection.

QUALITY LEVEL

ISO 6743-7, L-MHE,
ISO/TS 12927

APPLICATION

HSF[®] 81 L is primarily intended for honing and superfinishing operations in severe processing modes. It is especially suitable for machining roller bearings ways, rotary pump sets, honing of the internal combustion engine cylinders and piston pump cylinders.

Type of processing	Grey iron	Low-alloy steels	High-alloy steels	Non-ferrous metals and alloys	Light metals and alloys
Honing	**	**	**	***	***
Superfinishing	***	***	***	**	**

*** the best, ** acceptable, * satisfactory, - not satisfactory

ADDITIVE CONTENT

Esters	Sulfur		P	Ca	Zn	Cl
	active	inactive				
+	-	+	+	-	+	-

TYPICAL CHARACTERISTICS

CHARACTERISTICS	UNITS	VALUES	METHODS
Appearance	-	Clear oil	Visual
Density at 15°C	g/ml	0,850	EN ISO 3675
Kinematic viscosity at 40°C	mm ² /s	4,5	ISO 3104

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Flash point	°C	min 110	EN ISO 2592
Copper corrosion (100°C/3h)	degree	1a	EN ISO 2160
Corrosion on steel	-	No corrosion	ISO 7120
EP test (Four ball method) - welding point	N	> 4000	ASTM D 2783

STORAGE

Store in covered area. If stored outdoors, it is necessary to place the drums in a horizontal position to prevent the accumulation of water on the surface of the drum. Do not store at elevated temperatures or in locations exposed to direct sunlight, nor at the temperatures below 0°C.

All necessary instructions can be found in the product SDS. It contains the details of possible hazards, warnings and first aid measures, as well as the impact on the environment and the necessary measures for the storage and handling.

PACKING

Plastic pails of 20 L, tin drums of 180 kg.

Data are orientational, manufacturer reserves the right to make changes in order to improve product quality.

