

RATAK HFN 15B Honing Oil

Description

RATAK HFN 15B is a low misting honing oil based on a high grade solvent raffinate with a carefully balanced EP Combination.

RATAK HFN 15B has excellent flushing properties and it promotes rapid sedimentation of swarfs.

The use of special base oil and a specially selected combination of effective substances reduces the oil mist.

Application

RATAK HFN 15B is universal honing oil for hardened and normal steels, grey cast iron, spheroid graphite iron, non-ferrous metals, aluminium, magnesium, hard chromed surfaces and for all honing tools.

RATAK HFN 15B is suitable for carbide grinding operation, offering excellent filterability and thus long oil life.

Benefits

Low misting, leading to better hygiene, workshop cleanliness and consistency of product.
Synergistic blend of lubricity and Extreme pressure additives offer enhanced tool life
Optimised lubricity offers excellent surface finish
Fast settling of the grinding swarfs
Excellent filterability

Storage

Under proper sealed condition at ambient temperature, shelf life is 3 years.

RATAK HFN15B

Typical Characteristics

Properties	Typical Value	Test Method
Appearance	Clear Liquid	Visual
Density at 29.5°C, g/ml	0.82	ASTM D 4052
Viscosity @ 40°C, cSt	5.0	ASTM D 445
Flash Point, deg.C	136	ASTM D 92
Neutralisation Number, mg KOH/g	1.0 max.	ASTM D 974
Copper strip corrosion rating, degree	1	ASTM D 130
Four Ball Weld Load, kg	160	ASTM D 2783

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