

DIVYOL HONING OILS

Applications:

Divyol Honing Oils of grade 980 and 981 are very low viscosity oils with excellent lubricity for machining operations, like honing, turning, drilling, tapping, broaching and boring of all ferrous and non-ferrous metals and their alloys, where non-staining type, light coloured, low viscosity oil is required. They are especially recommended for honing or micro finishing applications on toughened steels, e.g. bearing steels and nickel alloys. They are also suitable for light drawing and forming applications of aluminium components.

Standards:

Divyol Honing Oils of grade 980 and 981 meet performance standards as per IS:3065 Type I Grade II.

Advantages:

Divyol Honing Oils are most efficient at swarf flushing and possess good heat carrying capacity. They impart excellent surface finish to machined components and improve critical tolerances. Their low viscosity and excellent surface coverage reduces drag-out. The blend causes a negligible odour and less misting resulting in better visibility of work piece. Regular usage leads to maximum cutting rates and service life of the abrasive and honing stone, even when working on difficult materials like stainless steel.

Typical properties:

| Sr. No. | Characteristics | Test Method | Divyol Honing Oils | |
|---------|---|-------------------|---------------------|---------------------|
| | | | DIVYOL HONE OIL 980 | DIVYOL HONE OIL 981 |
| 1 | Appearance | Visual | Bright and clear | Bright and clear |
| 2 | Colour | ASTM D 1500 | Red | Red |
| 3 | Flash point COC, °C min. | ASTM D 92 | 120 | 115 |
| 4 | Pour point, °C max. | ASTM D 97 | -3 | 3 |
| 5 | Kinematic viscosity at 40 °C, cSt, min. | ASTM D 445 | 4.5 | 5 |
| 6 | Polar compounds (1%) | - | Yes | Yes |
| 7 | Copper strip corrosion | IS:1448 P:16-1976 | 1a | 1a |
| 8 | Acidity, mg KOH/g | IS:1448 P:2-1967 | 0.3 | 0.3 |

The above properties are typical values and do not constitute specification of the product.

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