



HONING OILS

(Light Viscosity Metalworking Fluids)

HONING OILS are a series of low viscosity oils that vary in compounding.

HONING OIL A is a non-staining, lightly-colored oil containing a moderate amount of lubricity additive. It is suitable for light duty honing operations. **HONING OIL A** may be used as a base fluid for making heavy duty honing oils.

HONING OIL B is dark-colored, low-viscosity oil that is suitable for a wide variety of machining requirements.

HONING OIL B is a non-staining oil designed for both ferrous and non-ferrous cutting applications. It contains special antiwear and lubricity additives to produce medium-duty capability without active sulfur. **HONING OIL B** effectively controls tool wear while providing superior surface finish.

BENEFITS:

- MAXIMIZES TOOL LIFE
- MULTI-USE (BENDING, GRINDING, HONING, LAPPING)
- EXCELLENT SURFACE FINISH
- CONTAINS NO CHLORINE

APPLICATIONS:

HONING OIL B may be used for machining of non-ferrous metals (aluminum, copper, magnesium, etc.) and their alloys. It can also be used for light to medium duty machining of iron and steel alloys.

HONING OIL B may be used as a drawing compound for light-duty operations such as tube bending, forming, cold stamping or wire drawing.

TYPICAL CHARACTERISTICS

| Grade | Honing Oil A | Honing Oil B |
|------------------------------------|--------------|--------------|
| Product Code | 13917 | 13918 |
| API Gravity (ASTM D-1298) | 28.0 | 26.4 |
| Appearance, visual | light liquid | dark liquid |
| Viscosity, cSt @ 40°C (ASTM D-445) | 5.2 | 7.6 |
| Flash Point (ASTM D-92) °F (°C) | 255 (124) | 245 (118) |
| Fatty oil | yes | yes |
| Total additive sulfur, % | 0 | 1.5 |

The above data is subject to usual manufacturing variation. For more information and availability, call 1-800-442-LUBE.
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