

### HONING OILS

#### IPOL ST CUT 40 SF

##### Description:

Honing is a finishing operation performed on the inner surface of cylinders for obtaining a smooth surface finish on them. It is carried out by grinding stones called as a "hone".

Honing cannot be strictly termed as a grinding operation since its objective is to generate sufficiently high spot temperatures so as to smoothen the "hill peaks"

##### Salient Features:

- IPOL ST Cut 40SF is a chlorine surface, free low viscosity neat cutting oil manufactured using additives to give excellent wetting characteristics.
- IPOL ST Cut 40SF meets IS 3065:1985, Type I - Grade I specification.

##### Application:

- Designed for honing and super finishing of ferrous and non-ferrous metals.
- It can also be used for grinding applications. Drilling and general machining of Aluminium and yellow metals.

##### Benefits:

- Excellent flushing and lubrication properties.
- High surface finish and dimensional accuracy.
- Excellent wetting characteristics, reduced drag out.
- Good filtering characteristics, high oxidation stability.
- Chlorine and heavy metal free.
- Environment friendly due to low mist, low odour properties.

## Product Data

### Typical Results: IPOL ST Cut 40SF

Characteristics	Test Methods IS 1448	Results
Appearance	Visual	Bright & Clear
Density @ 15°C	ASTM D 1298	0.852
Flash Point COC °C	P:69	128
Viscosity cSt at 40°C	P:25	5.2
Copper Strip Corrosion	P:15	< 1
EP Weld Load Kgs.	-	126

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