

Cutting oil – inactive ISO L-MHE

HP[®] 515

HP[®] 515 is inactive cutting metalworking oil containing refined mineral oil, lubricating additives, high pressure (EP) additives, corrosion inhibitors and antiwear (AW) additives.

ADVANTAGES

- The use of advanced additives allows lubrication at high pressures and reduced tool wear,
- Excellent lubricating and EP properties,
- Good adhesion to metal surfaces,
- Minimal loss of oil due to removal with shavings,
- Good removal of the sawdust from the cutting zone,
- Good oxidation stability and filtration extend product life,
- High quality and precision of the workpiece and in the harsh processing modes,
- Good anticorrosion protection properties guarantee interoperational protection.

QUALITY LEVEL

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

APPLICATION

HP[®] 515 is inactive cutting oil used for horizontal broaching operations characterized by medium and heavy processing modes. It is also suitable for calibration operations for cold-drawn steel rods.

Type of processing	Grey iron	Low-alloy steels	High-alloy steels	Non-ferrous metals and alloys	Light metals and alloys
Horizontal broaching	-	**	**	***	***
Calibration of cold-rolled steel profiles	-	***	***	-	-

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

ADDITIVE CONTENT

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

TYPICAL CHARACTERISTICS

CHARACTERISTICS	UNITS	VALUES	METHODS
Appearance	-	clear	visual
Density at 15°C	g/ml	0,900	EN ISO 3675
Kinematic viscosity at 40°C	mm ² /s	40	ISO 3104
Flash point	°C	min 190	EN ISO 2592

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Copper corrosion (100°C/3h)	degree	1a	EN ISO 2160
Corrosion on steel	-	no	ISO 7120
EP test (Four ball method) - welding point	N	> 4000	ASTM D 2783
AW test (Four ball method) - wear diameter	mm	0,4	ASTM D 4172

Friction coefficient in the cutting zone: $\mu = 0,08 - 0,09$

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 and plastic container of 850 kg.

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

