

Cutting oil - inactive ISO L-MHE

SG[®] 32 N EKO

SG[®] 32 N EKO is inactive cutting oil containing refined mineral oil, corrosion inhibitors, lubricating additive, high pressure (EP) and antiwear (AW) additives.

ADVANTAGES

- The use of advanced additives enables lubrication at high pressures and reduced wear of tools, which provides better quality of treated surface,
- Lower viscosity allows better wetting and lower consumption of products,
- Low foam even at high speeds ensures reliable production,
- Good oxidation stability and filtrability extend product life,
- Low tendency of smoke/fog creation
- Good anti-corrosion properties guarantee interoperation protection against corrosion,
- It does not contain chlorine, so it can be treated as waste oil.

QUALITY LEVEL

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

APPLICATION

SG[®] 32 N EKO is intended for operations of turning, drilling, milling, cutting, planing. It does not contain active sulfur, therefore it is compatible with non-ferrous metals. This new generation oil is used in complex systems such as CNC machines, single-spindle and multiple-spindle automatons and copier milling.

| | Grey iron | Low-alloy steels | High-alloy steels | Non-ferrous metals and alloys | Light metals and alloys |
|----------------|-----------|------------------|-------------------|-------------------------------|-------------------------|
| Cutting | ** | ** | ** | *** | *** |
| Turning | ** | ** | ** | *** | *** |
| Drilling | ** | ** | ** | *** | *** |
| Milling | ** | ** | ** | *** | *** |
| Planing | ** | ** | ** | *** | *** |
| Thread rolling | * | * | * | ** | ** |

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

ADDITIVE CONTENT

| Esters | Sulfur | | P | Ca | Zn | Cl |
|--------|--------|----------|---|----|----|----|
| | active | inactive | | | | |
| + | - | + | + | + | + | - |

TYPICAL CHARACTERISTICS

| CHARACTERISTICS | UNITS | VALUES | METHODS |
|---|--------------------|-----------|-------------|
| Appearance | - | Clear oil | Visual |
| Density at 15°C | g/ml | 0,880 | EN ISO 3675 |
| Kinematic viscosity at 40°C | mm ² /s | 32 | ISO 3104 |
| Flash point | °C | min 185 | EN ISO 2592 |
| 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 | 0,47 | ASTM D 4172 |

Friction coefficient in the cutting zone: $\mu = 0,085 - 0,095$

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.

