



TECHNICAL DATA

102 Barton Street, St. Louis, Missouri 63104

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125 HONING OIL

Honing Oil is a very low odor, chlorine free, heavy-duty, active sulfur base low viscosity oil that is designed for the honing and super-finishing of ferrous and certain non-ferrous metals such as nickel and aluminum and aluminum alloys. Honing Oil is particularly recommended for use in the honing of engine blocks and cylinders. Honing Oil can also be used for general cutting, screw machine, tapping, reaming and grinding applications.

Honing Oil contains a unique extreme pressure and lubricity additive system and fatty oil additive that work synergistically to provide the Honing Oil with the following performance benefits:

1. Maximum cutting rates and abrasive life when honing difficult materials such as stainless steel
2. Prevention of welding and tearing of the work piece
3. Prevention of pick-up and galling
4. Excellent surface finishes
5. Prolonged abrasive and honing stone life
6. Prevention of load up on the honing stones
7. Excellent flushing of swarf in order to improve critical tolerances and finishes
8. Prevention of load-up by keeping the hones clean
9. Low viscosity and excellent wetting characteristics to reduce drag-out
10. Low odor and low misting

Typical Properties

Specific Gravity @ 60°F (15.5°C)	0.9
Viscosity, cSt @ 40°C (ASTM D-445)	19.5 - 25
Viscosity, SUS @ 100°F	102-130
% Active Sulfur	2% minimum
% Fatty Oil	10% minimum

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