

## Honing Oil 67 *Straight Honing Oil*

### FEATURES

- General Purpose
- Non-Toxic
- Lower Consumption
- Low Odor
- Superior Lubricity Package
- Non-Irritating

### GENERAL DESCRIPTION

Honing Oil 67 is specifically formulated as a multi-purpose honing oil. It is designed to keep the honing stones clean and free cutting with additives to support soft to hard materials. Hangsterfer's Honing Oil will maximize the abrasive life while allowing a free, smooth and clean cutting action. It can be used for all types of stones and machine configurations.

### APPLICATIONS

Primary	
Honing Stones Silicone Carbide	Honing Stones CBN
Honing Stones Aluminum Oxide	Honing Stones Diamond

### MATERIALS

Suitable For All Materials

### INSTRUCTIONS

To prepare a hone for fresh cutting oil follow the recommended procedure. Empty the machine of used fluid and chips. If the hone has a high pressure honing unit, remove all used filters and honing oil. Clean the hone sump and high pressure pump system by using Ozonic 203 as a rinse agent to remove any water or moisture left in the oil lines or conveyor. Empty the machine of Ozonic 203 (this can be used to clean several machines). Fill with fresh oil. Use a pail to catch the first product when starting the honing oil pump to clean out the lines. Machine Cleanout Procedures are available from Hangsterfer's Labs.

### MAINTENANCE

**Maintenance:** While straight cutting oils are not susceptible to the broad range of problems encountered with a water-based fluid, regular maintenance does improve their performance and extend their life. Honing Oil 67 is designed to reject foreign contaminants, such as metal fines.

If the performance of the oil begins to deteriorate, remove the oil from the machine and allow settling in an empty drum or settling tank for 3-7 days. Fines and contaminants will settle to the bottom. After settling, return the top 80% to the clean machine. In order to get the maximum life from your oil, keep the sump free of cleaners, solvents, rust inhibitors, coolants and other contaminants that may inhibit performance.

**Cleaning:** Hangsterfer's products are formulated to be cleaned in Aqueous, Semi-Aqueous, and Solvent based cleaning systems. Depending on the required level of cleanliness one or more cleaning systems might be required. Hangsterfer's neutral pH "Clean All" (Aqueous) and "Ozonic 203" (Solvent) can be used separately or part of a multistep cleaning system. Cleaning systems agitation, pressure, ultrasonic, time, and temperature greatly aid the efficiency.

## PRODUCT CHARACTERISTICS

Honing Oil 67	
Form	Liquid
Color	Golden
Odor	Bland
Specific Gravity	0.9
Viscosity: SUS @ 100°F	106
cSt @ 40°C	22
Flash Point, COC, °F/°C	334.4 / 168
Fire Point, COC, °F/°C	359.6 / 182
Pour Point, °F/°C	-0.4 / -18
Solubility in Water	<0.01
Vapor Pressure, mm Hg @ 25°	<0.01
pH @ 10%	N/A
Chlorine	0

## WASTE TREATMENT

While Hangsterfer's oils resist contamination and degradation, contamination may require the oil be disposed of. In the normal use of cutting oils, tramp oils enter the system that may change the disposal procedures. Some Hangsterfer's oils contain chlorinated additives that may be disposed of as non-hazardous if properly noted. Please verify with your local waste management company. Please comply with all local, state and government laws when disposing any oil.

## SHIPPING UNITS

All Hangsterfer's products are available in pails, drums and Intermediate Bulk Containers (275 or 330 gallons). All products are distributed worldwide.

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