

## **HONING OIL 3540**

### **INDUSTRIAL HONING OIL**

#### **Description**

Honing Oil 3540 is found in numerous industrial finishing operations from engine cylinders to downhole pump tubing.

The product contains a blend of sulfurized ester and various hydrotreated oils for efficient metal removal, improved surface finish, and longer honing media life.

The unique chemistry of Honing Oil 3540 difluent oil provides a high flash point with low odor, eliminating surface flames and undesirable kerosene fumes often associated with honing shops.

Honing Oil 3540 is free of transition metals often found in honing materials. These metal ions create sulfur soap complexes, developing "blot like" structures overtime. These "blot like" structures block and blind filtering medium causing production inefficiencies.

#### **Features & Benefits**

- Efficient metal removal
- Excellent surface finish
- High flash
- Low odor
- Does not blind filters
- Low pour point esters

#### **Health & Safety**

See the most recent MSDS which is available directly from Precision Fluids, your local salesman, or authorized distributor. Precision Fluids uses only raw materials not listed as carcinogenic by IRAC.

#### **Physical Data**

Appearance:	Dark Brown
Solubility:	Oil
Odor:	Mild Industrial
API Gravity @ 60°F	30 - 32
Viscosity @ 100°F, SUS	63-68
Flash Point:	> 300°F
Sulfur %:	4.0
Ester %:	33.0

#### **Application & Usage**

Precision Fluids recommends using Honing Oil 3540 for all industrial honing operations when best in class finish is desired.

Best practices include draining current honing oil and flushing with line wash oil. The remaining oil should then be removed with an industrial sump vacuum to allow for best results.

Honing Oil 3540 is compatible with most honing oils for those instances where proper removal of competitive honing oil cannot be accomplished. Good practice calls for mixing small amounts of Honing Oil 3540 with the honing oil in the sump it will be replacing to assure no reactions occur that would form precipitates.

No special precautions are necessary with respect to seals or valves.

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