



METAL WORKING FLUID

NIPPON GREASE CO., LTD.
Toyosaki Bldg.,
18-21 Chayamachi Kita-ku Osaka 〒530
TEL(06)373-0171 FAX(06)373-0174

SUNHONE

SUNHONE is a sulfur-chlorine type oil additive for cutting oils to be classified to JIS 2-16 category. In cutting or grinding operations, conventional products or mineral oils alone may not give smooth finishing on worked materials, and longer service life of tools.

In those cases, the addition of 5 ~ 30% of **SUNHONE** additive to the oils in use can solve the problems without change of oils.

❖ APPLICATION

For works difficult to machine, such as steel alloy, stainless steel, etc., 5 – 30 % dosage of **SUNHONE** to the cutting oils is recommended to suppress the formation of welded tip on the tool tip, and to improve the surface roughness of the worked materials.

For honing works, kerosene or low viscosity mineral oils provided with 5 – 30 % dosage of **SUNHONE** can perform finer surface finishing of the worked materials and longer service life of honing stones.

❖ TYPICAL ANALYTICAL DATA

TEST ITEMS	TYPICAL PROPERTIES
Density 15°C g/cm ³	0.951
Viscosity 40 °C cSt	44.0
Flash point °C	196
Color, ASTM	D 8.0
Pour Point °C	Lower than -5
Copper Strip Corrosion	4
Friction Coefficient	0.13
EP Characteristics, 200rpm kg/cm ²	15.0
Fatty Material Content % wt	33.0
Chlorine Content (added) % wt	8.0
Sulfur Content (added) % wt	3.0