



# MAKER IBERTEM 34

## Description

A natural paraffin mineral oil with low viscosity, formulated with highly refined base oils and specially selected additives, which provide the properties required to overcome the difficult conditions needed for hot, rapid steel hardening; where the bath temperature is between 85 and 125 °C, and in an enclosed atmosphere above 95 °C. This kind of oil is used with non-alloy or low alloy parts.

## Properties

- High cooling speed.
- Contains additives to achieve good resistance to oxidation and sludge formation, thus prolonging its useful life.
- Very good thermal stability and low volatility, which reduces smoke and the risk of fire.
- Good foam resistance.
- Uniform and lasting hardening capacity.

## Technical specifications

	UNIT	METHOD	VALUE
Appearance	-	Visual	B & T
Colour	-	ASTM D1500	<3
Density at 15 °C	g/mL	ASTM D4052	0.890
Viscosity at 40 °C	cSt	ASTM D445	65
Viscosity at 100 °C	cSt	ASTM D445	8.3
Maximum cooling rate (MCR)	°C/s	ISO 9950	54.53
Temperature for MCR	°C	ISO 9950	568.87
Cooling speed at 300 °C	°C/s	ISO 9950	6.45
Time at 600 °C	s	ISO 9950	12.37
Time at 400 °C	s	ISO 9950	17.75
Time at 200 °C	s	ISO 9950	53.37
Cooling curve			Annex

The above mentioned characteristics are typical values and should not be considered product specifications.



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