



MAKER IBERTEM 24

Description

Natural paraffin mineral oil with low viscosity, formulated with highly refined based oils and selected additives that increase the hardening speed and provide the properties required to overcome the difficult conditions needed in cold, high-speed steel hardening (bath temperature is between 40 and 80 °C). This kind of oil is formulated to achieve non-alloy steel parts with maximum hardness and minimum deformations and breaks.

Properties

- Contains additives to achieve good resistance to oxidation and sludge formation, thus prolonging its useful life.
- Provides a very short steam phase during hardening operations thus speeding transfer to the boiling stage and the quick cooling of the metal.
- Very good thermal stability and low volatility, which reduces smoke and the risk of fire.
- Good foam resistance.
- Uniform and lasting hardening capacity.
- Clean, tempered parts are achieved.

Technical specifications

	UNIT	METHOD	VALUE
Appearance	-	Visual	B & T
Colour	-	ASTM D1500	<4
Density at 15 °C	g/cm ³	ASTM D4052	0.875
Kinematic viscosity at 40 °C	cSt	ASTM D445	32
Kinematic viscosity at 100 °C	cSt	ASTM D445	5.5
Maximum cooling rate (MCR)	°C/s	ISO 9950	94,02
Temperature for MCR	°C	ISO 9950	652,27
Cooling speed at 300 °C	°C/s	ISO 9950	6,74
Time at 600 °C	s	ISO 9950	9
Time at 400 °C	s	ISO 9950	15,37
Time at 200 °C	s	ISO 9950	50,37
Cooling curve			Annex

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



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