



WATSON
SPECIALISED TOOLING

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Above and Beyond Honing

Why the correct honing oil can produce better results?

Sunnen honing oil is part of a system. Sunnen has designed the bond within its stones to react with the constituents of its honing oil.

Sunnen honing fluid produces a chemical reaction that lessens the adhesion of metal chips.

This keeps the particles from sticking to the cylinder wall and honing stone and prevents the stone from loading up which can produce random scratching of the cylinder bore, inconsistency in the surface finish and reduce cutting efficiency. The right fluid will also maximize stone life.

Sunnen has designed its honing oil to produce this catalyst with its stones and it is the reason the system works.

MB-30 Honing Oil

MB-30 is Sunnen's multi-purpose industrial honing oil. For over forty years, MB-30 has set the standards by which other honing oils are judged. High performance lubricity agents combined with sulfur extreme pressure additives prevent welding and tearing of the work piece and keep the abrasive clean. MB-30 delivers maximum cutting rates and abrasive life when honing difficult materials like stainless steel, and features a much higher level of surface active lubricity agent than other petroleum based machining oils. The MB-30 formula contains metal deactivators to prevent staining of copper containing alloys. MB-30 is also very effective as a general cutting oil for screw machines, drilling, tapping, and reaming. MB-30 works on virtually any metal from aluminium to zirconium.

MAN-845 Honing Oil

MAN-845 is formulated for general purpose automotive machine shop honing. It is excellent for con rods, piston pins, king pins, cylinder bores or general shop honing. MAN-845 can be boosted if necessary for occasional honing of more difficult materials (like aluminium or high nickel cast iron) by adding a small amount of Sunnen Industrial Honing Oil. It is petroleum based, containing high performance lubricity agents in combination with both sulfur and chlorine extreme pressure additives. The low viscosity creates less oil "carry off" and makes cleaning easier. MAN-845 is also an excellent screw machine and general purpose cutting oil. MAN-845 is compatible with the oil and filter system of all Sunnen honing machines and other manufacturers' machine tools in which petroleum oils are normally used.

MAN-852 Honing Oil

MAN-852 is a non-hazardous, ecologically responsible, unregulated honing oil composed entirely of natural surface active lubricity agents. Because this product does not use additives, it is ideally suited for applications where additives are restricted, such as the aerospace and nuclear industries. MAN-852 hones most materials satisfactorily, however, when used with materials such as soft copper, may produce stone loading. MAN-852 is approved by Boeing Aircraft Company and is used to hone critical parts where classic cutting oil additives such as sulfur or chlorine have been shown to cause micro-corrosion, resulting in part failure. MAN-852 has a mild odour and is very gentle to the operator's skin. It is very popular with operators who are sensitive to additives used in regular cutting oils.

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