

HE-2® Heavy Duty, High Viscosity Water Soluble Oil Concentrate

FEATURES

- High content of extreme pressure additives
- For the most severe metal removal applications
- Extend sump life, reduce consumption
- Ideal for long term use in recirculating systems
- Non Toxic – Non Corrosive
- Superior lubricity package
- Compatible with common machine tool components
- Operator Friendly

GENERAL DESCRIPTION

HE-2 combines a high viscosity mineral oil base with advanced Extreme Pressure additives to provide maximum performance. The result is an unmatched trio of physical film, chemical film and cooling properties that minimize tool wear. It is ideal for slower metal removal, severe deformation, difficult machining and finish intensive operations of all materials. It is ideal for those companies looking to replace straight oils.

APPLICATIONS

Application	Concentration	Application	Concentration
General Machining, Turning, Drilling	8% - 12%	Cold Sawing, Band Sawing	5% - 25%
Boring, Reaming, Burnishing	8% - 12%	Drawing	10% - 30%
Forming	5% - 25%	Stamping	10% - 30%
Broaching, Hobbing, Shaving	12% - 20%	Fine Blanking	10% - 30%
Roll Tapping, Cut Tapping, Thread Rolling	10% - 15%		

MATERIALS

Primary		Secondary	
Aluminum Alloys	Titanium & Tungston	Plastics	Steels: Bhn up to 350
Chromium Alloys	Molybdenum		
Nickel Alloys	Refractory Metals		
Stainless Steels: Bhn 350 to 450	Steels: Bhn 350 to 450		

MIXING INSTRUCTIONS & MAINTENANCE

Mixing Instructions: Always premix coolant before adding to the machine sump. For best results, Hangsterfer's Accu-Mix 26270 proportioning unit should be used. To maintain recommended concentration make-up should be added at one-half the desired concentration. For example, to maintain 6%, first charge the machine at 6%, then as needed add make-up at 3%. Never add straight water or concentrate directly to machine.

Maintenance: HE-2 is a biostable coolant, designed to control the growth of bacteria. Regular maintenance is required for maximum performance. Concentration should be monitored regularly with a calibrated refractometer. HE-2 gives a direct read on the refractometer (e.g. 5=5%). Tramp oils should be removed from the coolant surface regularly to prevent unwanted bacterial growth. Keep coolant system free of cleaners, solvents and other contaminants.

PRODUCT CHARACTERISTICS:	HE-2
Form	Liquid
Color	Green
Odor	Mild
Specific Gravity	0.99
Viscosity: SUS @ 100°F	1180
cSt @ 40°C	250
Flash Point, COC, °F/°C	320 / 160
Fire Point, COC, °F/°C	369 / 187
Pour Point, °F/°C	<0 / -18
Solubility in Water	100%
Boiling Point, °F/°C	379 / 193
Vapor Pressure, mm Hg @ 25°	<0.01
pH @ 10%	9.1
Chlorine	Added as EP Additive

Shipping Units:

HE-2 is available in 5 gallon, 55 gallon and Intermediate Bulk Containers (275 or 330 gallons).

All products are distributed worldwide.

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