



## Product Data

### Castrol Honilo 981 High-performance neat cutting oil

#### Description

Castrol Honilo™ 981 is a chlorine-free low viscosity neat cutting oil, which is sulphur- and heavy metal-free.

#### Application

Honilo 981 is designed for honing and superfinishing of ferrous and non-ferrous metals. It can also be used for grinding applications, drilling and general machining of aluminum and yellow metals.

	Cast Iron	Low-medium alloyed steel	High alloyed steel /nickel-chromium alloys	Titanium alloys	Aluminum alloys	Yellow metals
Honing/Superfinishing	✓	✓	✓	-	✓	✓
Grinding	✓	✓	✓	-	✓	✓
Drilling	-	-	-	-	✓	✓
Broaching/Gear manufacturing	-	-	-	-	-	-
General machining	-	-	-	-	✓	✓

#### Advantages

- Excellent flushing and lubrication properties extend honing stone life and enable high surface finish and dimensional accuracy.
- Low viscosity and excellent wetting characteristics reduce drag-out and can result in lower product usage.
- Good filtering characteristics and high oxidation stability help increase product lifetime.
- Our chlorine- and heavy metal free-formulation improves the environmental profile and reduces disposal costs.
- Low odor, light color and low mist aid in operator acceptability.

## Typical Characteristics

Properties	Unit	Standard	Data
Appearance	Visual	Visual	Yellow
Viscosity @ 40°C	mm <sup>2</sup> /s	DIN 51562	4.8
Viscosity@ 100°F	[SUS]	ASTM D 446	47
Density @ 15°C	kg/m <sup>3</sup>	DIN 51757 ASTM D 1298	831
	lbs/gal	Calculated	6.94
Flashpoint COC	°C	ISO 2592	> 125
	°F	ASTM D 92	> 255
Copper corrosion	3 hr at 100°C	ISO 2160	1b

	Ester	Active sulphur	Inactive sulphur	Phosphorous	Calcium	Chlorine	Zinc
Additives	+	-	-	-	-	-	-

Castrol Honilo 981  
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