

6.4 极压-添加剂-复合包

产品 **Additive EP 340 N**

(用于钢的切削油的通用添加剂复合包)

特性

EP 340 N 是一款协同极压剂复合包，适用于非水溶性金属加工油。成分中不含锌和磷。可溶于石蜡和环烷矿物油，加氢裂化油和 PAO。该产品低气味，色泽明亮。EP 340 N 通常不适用于黄色金属加工。（-> EP 9180）。

	典型 数值	规格 最小	最大	
颜色	: 棕黄			
外观 20°C	: 液体			
密度 20°C (g/ml)	: 0.968	0.958	0.978	DIN 51 757
粘度 40°C (mm ² /s)	: 32	28	36	DIN 51 562-1
总硫分(wt.%)	: 5.8	5.3	6.3	calculated
铁屑滤纸测试 100°C (10% in SN 100)	: 4-100-A-3			DIN EN ISO 2160

	Welding load 4-Ball-Machine (N)	Scar diameter (mm)	
20% in mineral oil	: 5500-6000	0.413	DIN 51 350-2/3
5% in mineral oil	: 2800-3000	0.622	DIN 51 350-2/3

应用

3 – 5 wt.% 适合应用于高流动性矿物油中用于研磨和珩磨油。

7 – 9 wt.% 适用于自动机床的中型应用。

18 – 20 wt.% 适用于石蜡溶剂精制的矿物油在 40°C 时粘度为 18 或 22mm²/s 的重载应用。

典型应用：自动加工，钻孔，车床，铣削，攻丝，螺纹切削，拉削，铰孔，滚齿，刮

为避免油雾和起泡，推荐添加 Tac-Oil AMW (1%) 和消泡剂 ES 9227 (0.05– 0.01%)

存储

EP 340 N 可以在干燥且无霜的状态下以正确密封的原始包装储存至少 6 个月。

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Typical Formulations for Neat Oils based on Additive EP 340 N**Heavy duty machining of steel**

18 – 20 wt.% Additive **EP 340 N** in paraffinic solvent refined oil of viscosities of 18 mm²/s or 22 mm²/s @ 40°C

Deep hole drilling (< 20 mm diameter)

(single flute-, ejector and BTA method)

20 wt.% EP 340 N in base oil, adjustment to V40 = 8 - 10 mm²/s

(Antimist agent Tac-Oil AMW 1% and Defoamer ES 9227 0.05 - 0.01% to be added optionally)

Deep hole drilling (> 20 mm diameter)

(single flute-, ejector and BTA method)

20 wt.% EP 340 N in base oil, adjustment to V40 = 16 - 18 mm²/s

(Antimist agent Tac-Oil AMW 1% and Defoamer ES 9227 0.05 - 0.01% to be added optionally)

Heavy duty tapping, threading, milling, broaching, cutting, gearwheel machining

20 wt.% EP 340 N with 80 wt.% base oil, adjustment to V40 = 20 mm²/s

Heavy duty gear wheel milling, hobbing and grinding

20 wt.% EP 340 N in base oil, adjustment to V40 = 10 - 15 mm²/s

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