

ISODUR 220

normal quenching oil



Application

ISODUR 220 is applied for tool-steel quenching as well as for quenching of carburized gears, shafts etc.

Physical data

Density/20°C	DIN 51757	approx. 0,860	g/cm ³
Flash point	EN ISO 2592	195	°C
Fire point	EN ISO 2592	232	°C
Viscosity	DIN 51562		
at 20°C		46,0	mm ² /s
at 40°C		19,0	mm ² /s

Quenching properties

ISODUR 220 does not show an extremely short vapour phase as high-performance, fast-quenching oils (ISORAPID, MARQUENCH etc.) do.

The final quenching rate is low, therefore ISODUR 220 avoids resp. reduces thermal stresses in the final cooling stage (stage of martensitic transformation).

It is not suitable for quenching bigger cross-sections of pieces made from lean-alloyed or plain carbon steel.

Alloyed tool-steels achieve a good hardness with ISODUR 220.

Aging stability and service life

ISODUR 220 possesses an extraordinarily good aging and oxidation stability and provides long service life.

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Cleaning of the workpieces after quenching

Residues from ISODUR 220 can easily be removed in soaking or spray washing machines with aqueous hot cleaners (e.g. FEROCLEAN N-SF). It can also be removed with all kinds of solvents.

If the ISODUR 220 E-version is applied, it can be washed off with pure water. Ask for special information on E-quenching oils.

Control

The recommend temperature range for ISODUR 220 is 40 - 70°C. For short periods temperatures up to 100°C may be applied. Bath temperatures below 30°C and above 100°C should be avoided.

Take care: Keep the oil always free from water!

Only valid in combination with EC Safety Data Sheet

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