



Product Data

Castrol Iloquench 395™

Accelerated hot quenching oil

Description

ILOQUENCH 395 is a blend of premium grades of solvent refined paraffinic mineral oils with cooling rate accelerators, surface conditioning additives and a high temperature stable anti-oxidant package. This combination of premium base oils and additives ensure brighter as-quenched components, free from carbeneous deposits, which are usually associated with low cost accelerated quench oils.

Application

- ◆ *Hardening of medium carbon and low alloy steels.*
- ◆ *Hardening of all types of fasteners after carburising.*
- ◆ *Hardening of "lean" steels.*

ILOQUENCH 395 is suitable for use in all types of furnaces, open quench tanks and after salt bath process'.

Advantages

Bright Quenching

- ◆ *The surface conditioning agent improves the surface cleanliness of the components making them easier to process through plating operations.*

Material Cost Reduction

- ◆ *The high severity of quench of ILOQUENCH 395 allows lower alloy steels to be used, by obtaining superior mechanical properties than would be obtained using a conventional quenching oil.*

High Severity of Quench

- ◆ *The cooling curve shows a high vapour - boiling transition temperature*
- ◆ *Avoiding incomplete transformations and a low enough boiling – convection transition temperature*
- ◆ *To ensure optimum hardening of steels with a low martensite start temperature.*

Castrol Iloquench 395
02.11.2006, Version Number 1.0
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Characteristics

Tests	Units	Standard	Typical Value
Appearance	-	BAM 300	Brown Fluid
Density @ 30°C	kg/m3	D 4052	840 - 870
Viscosity @ 40°C	Cst	D 445	34 - 40
Flash Point (COC)	°C	D 92	> 200
Fire Point (standard value)	°C	D 92	> 220
Water Content	%	D 95	< 0.05
Total Acid Number	mg KOH/g	D 974	< 0.30
Severity of Quench @ 50°C		NFT 60-178	
Transition Temperature:			
Vapour – Boiling	°C	-	710 - 740
Boiling - Convection	°C	-	320 - 350
Castrol Index @ 50°C	-	-	21 - 22
Operating Temperature:			
in open air	°C	-	30 - 80
under atmosphere	°C	-	60 - 150

The above data is typical and does not constitute a specification.

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