

rhenus EP 22 S

Low emission, highly activated, ester based cutting oil

rhenus EP 22 S is a low emission, highly activated, EP-cutting oil, based on oxidation stable esters for universal use. The product is free of chlorine and heavy metals like lead and barium.

Application

rhenus EP 22 S is the first choice where normal and heavy-duty machining operations of normal to high alloy steel will be performed, but also on non-ferrous metal alloys and aluminium alloys.

The universal applicable **rhenus EP 22 S** can be used for demanding drilling operations also for slow speed difficult machining operations like milling, form milling, hobbing and shaving.

Because of its performance, deep drilling of small diameters and thread cutting is also achievable with **rhenus EP 22 S**.

rhenus EP 22 S is also used for metal forming processes like deep drawing of aluminium, ends reducing of thick walled steel or aluminium tubes with smaller diameters and collaring operations (T-Drilling) on steel, stainless steel or aluminium tubes.

This product incorporates polar additives providing high wettability and good adhesiveness on metal surfaces. Due to its chemical structure **rhenus EP 22 S** is low in mist.

For the application please observe the valid VDI guidelines 3035, 3397 sheets 1 - 3.

On use of special cable isolations or seal compatibility seek advice from the supplier.

Protect against frost, heat and direct sunlight. Recommended storage and transport temperature: 5 - 40 °C.

Technical Data

Colour	Viscosity 40 °C (mm ² /s)	Density 20 °C (g/ml)	Flash point (°C)	Copper corrosion Grade
light brown	22,4	0,90	216	1b

Remark

The pour point of **rhenus EP 22 S** is situated at approx. -9 °C.

The storage condition should not be below 5 °C otherwise components of the native ester can crystallize.

water hazardous class 1 (self-assessment according to VwVwS of 17.05.1999)

Non-ferrous metals will not be discoloured by **rhenus EP 22 S**.

rhenus EP 22 S is not subject to identification regulations under EC Directives and the Ordinance on Hazardous Materials (GefStoffV)

Subject to modification of the technical data. Please refer to the material safety data sheet for additional information or contact our application engineers.

Edition

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