



## Emulsichem Lubricants Pvt. Ltd.

### CASE STUDY OF HONIKUT-70

Date	01/02/2007
Name of the organization	Bajaj Auto Ltd.
Address	Akurdi, Pune 411 037.
M/c. no. & make for study	Fasselar HMX 400
Type of operation	Gear teeth honing
Material removal	50 to 70 Micron
Thickness of sheet	NA
Type of material	Steel 16mn CUGN Harden to 60 HRC
Type & make of tools used	Fasselar honing wheel
Recommended product	HONIKUT-70
Date of charging coolant	04/12/2006
Dilution (water : oil)	NA
Compared with existing product	HONEX-7 (Shell)

### OBSERVATIONS & COMMENTS

- Honikut-70 gave excellent finish and very good flushing properties.
- No dust was settled on honing wheel, it was flushed very rapidly. Machine area gets cleaned. Oil has no stickiness.
- Oil pressure/flow was very good and all the dust on wheel and machine area was carried to the centrifuge.
- Job finish was upto the required Ra value.
- No foaming was observed.
- 2000 gears are super finished in each shift per day.