

YUMATE® HEC-30
Premium Quality
Chlorinated EP-Type Machining Fluid

PRODUCT DATA SHEET

GENERAL DESCRIPTION:

YUMATE® HEC-30 is a premium quality, water soluble, extreme pressure type machining fluid. **YUMATE® HEC-30** contains a chlorinated extreme pressure additive which allows for superior metalworking performance. **YUMATE® HEC-30** is formulated for machining of aluminum alloys, cast iron and steel. **YUMATE® HEC-30** would be recommended for those difficult machining operations requiring additional EP performance. If required, **YUMATE® HEC-30** may be used at higher using concentrations for more severe machining operations such as Gun Drilling or Reaming without causing foaming problems. **YUMATE® HEC-30** will provide optimum performance in water of up to 500 ppm hardness and can be easily cleaned off with **YUMAGE** series cleaners.

BENEFITS:

- **Premium Quality Formulation with Chlorinated Extreme Pressure Additives.**
- **Excellent Bio-Resistant Formulation.**
- **Hard Water Stable.**
- **Low Foaming Formulation.**
- **Safe to Use - No Nitrites or Phenols.**

PROPERTIES:

Color (ASTM)	L2.0
Appearance (Concentrate)	Light Brown Liquid
(Diluted).....	White Emulsion
Specific Gravity (20/20 °C).....	0.95
pH (10% Concentration)	9.5
(5% Concentration)	9.5

USING PROCEDURES:

Aluminum Alloys, Cast Iron

General Machining:.....	5%-7%
Gun Drilling, Reaming, Tapping:.....	8%-10%

Steel Alloys:

General Machining:.....	5%-7%
Gun Drilling, Reaming, Tapping.....	8%-10%

MATERIAL SAFETY:

YUMATE® HEC-30 is suitable for use on most ferrous metals and aluminum.
YUMATE® HEC-30 is not recommended for use on copper and copper alloys. Do not use on Magnesium.

CONCENTRATION CONTROL:

Refractometer: BRIX 1.0

YUMATE® HEC-30
Premium Quality
Chlorinated EP-Type Machining Fluid

PRODUCT DATA SHEET

STORAGE:

Keep in a cool, dry area. Do not freeze.

PRECAUTIONS:

Please refer to the label and Material Safety Data Sheet for all warnings, recommendations for safety equipment, and other regulatory information.

AVAILABILITY:

Pails, Drums, Totes, Bulk

YUMATE® HEC-30
 Premium Quality
 Chlorinated EP-Type Machining Fluid

PRODUCT DATA SHEET
PRODUCT USE REFERENCE GUIDE

YUMATE® HEC-30@ 5-15%									
Work Material			Carbon Steel C=0.3% up & Soft Alloys	Carbon Steel C=0.3% less	High Alloy Steel	SU3 Heat resisting steel & Steel Titan Alloys	Al Al Alloys	Cast Iron	Copper Bronze Brass
Machining Method and Tool									
Turning	Single Point Bite	Carbid e	√	√			√		
		HSS	√	√	√	√	√		
	Cut-Off Bite	Carbid e	√	√			√		
		HSS	√	√	√	√	√		
	Formed Bite	Carbid e	√	√			√		
		HSS	√	√	√		√		
Milling	Facing Mill	Carbid e	√	√		√	√		
		HSS	√	√		√	√		
	Side Cutter	Carbid e	√	√			√		
		HSS	√	√	√		√		
	End Mill	Carbid e							
		HSS			√		√		
Drilling	Twist Drill	Carbid e			√			√	
		HSS	√	√	√		√	√	
	Gun Drilling	Carbid e					√	√	
Boring	Single Point Bite	Carbid e					√		
		HSS					√	√	
	Reamer	Carbid e					√	√	

YUMATE® HEC-30
Premium Quality
Chlorinated EP-Type Machining Fluid

PRODUCT DATA SHEET

YUMATE® HEC-30@ 5-15%									
Work Material			Carbon Steel C=0.3% up & Soft Alloys	Carbon Steel C=0.3% less	High Alloy Steel	SU3 Heat resisting steel & Steel Titan Alloys	Al Al Alloys	Cast Iron	Copper Bronze Brass
Machining Method and Tool									
		HSS					√	√	
Broaching		HSS							
Threading	Tap	HSS					√	√	
	Chaser	HSS					√	√	
	Bite	HSS					√	√	