



Sevora 546 L

Neat Cutting Oil

Description; Description

Sevora 546 L is a higher viscosity, neat cutting oil formulated from a solvent refined basestock. It contains a balanced, specially selected additive package to confer

extra lubricity. It is a clear transparent light coloured oil, allowing easy sight of the workpiece and will not cause staining of copper based alloys.

Applications; Applications

Sevora 546 L is recommended for the majority of general machining operations on ferrous and nonferrous metals, especially in operations where complex tooling or intermittent cutting is taking place. It can also be used for gear cutting operations on copper-based alloys.

To obtain the best performance with Sevora 546 L, it is recommended to filter the oil regularly. This treatment avoids recycling metal fines and prolongs tool life and maintains surface finish.

Main Benefits; Main Benefits

- Suitability for machining of a wide range of ferrous and nonferrous metals
- Good observation of the tool/workpiece area
- Very low tendency to stain yellow metals

- Low tendency to form mists in service
- Low odour for operator comfort
- High cooling rate with reduced friction
- Enhances tool life and surface finish

Storage; Storage

All packages should be stored under cover. Where outside storage is unavoidable drums should be laid horizontally to avoid the possible ingress of water and the obliteration
; All packages should be stored under cover. Where outside storage is unavoidable drums should be laid horizontally to avoid the possible ingress of water and the obliteration

of drum markings. Products should not be stored above 60°C, exposed to hot sun or freezing conditions.; of drum markings. Products should not be stored above 60°C, exposed to hot sun or freezing conditions.

Health, Safety and Environment; Health, Safety and Environment

Health, safety and environmental information is provided for this product in the Materials Safety Data Sheet. This gives details of potential hazards, precautions and First Aid measures, together with environmental effects and disposal of used products.; Health, safety and environmental information is provided for this product in the Materials Safety Data Sheet. This gives details of

BP Lubricants and Special Products Ltd. or its subsidiaries will not accept liability if the product is used other than in the manner or with the precautions or for the purpose/s specified. Before the product is used other than as directed, advice should be obtained from the local BP office.; BP Lubricants and Special Products Ltd. or its subsidiaries will not accept liability if the product is

potential hazards, precautions and First Aid measures, together with environmental effects and disposal of used products.

used other than in the manner or with the precautions or for the purpose/s specified. Before the product is used other than as directed, advice should be obtained from the local BP office.

Typical Characteristics; Typical Characteristics

| | Test Methods; Test Methods | Units; Units | Grade ;; Grade : |
|------------------------------|--------------------------------------|--------------------|------------------|
| | | | Sevora 546 L |
| Appearance | | | clear |
| Colour | | | amber |
| Density at 15 °C | ISO3675/ASTM D1298 kg/m ³ | 883 | |
| Kinematic Viscosity at 40 °C | ISO3106/ASTM D445 | mm ² /s | 44 |
| Flash Point (COC) | ISO2592/ASTM D92 °C | | 222 |
| Copper Corrosion | ISO2160/ASTM D130 | | 1A |
| Neutralisation Number | ASTM D664 | mgKOH/g | 0.2 |
| Reichert at 1500N | Reichert | mm ² | 7.4 |
| 4-Ball Weld Load | ASTM D2783 | N | 2500 |

The above figures are typical of those obtained with normal production tolerance and do not constitute a specification.

This Data Sheet and information it contains is considered to be accurate at the date of printing. No warranty or representation, expressed or implied, is made as to the accuracy or completeness of the data and information contained in this publication.; This Data Sheet and information it contains is considered to be accurate at the date of printing. No warranty or representation, expressed or implied, is made as to the accuracy or completeness of the data and information contained in this publication.

It is the User's obligation to evaluate and use products safely and within the scope advised in the data sheet and to comply with all applicable laws and regulations. No statement made in this publication shall be construed as a permission, recommendation or authorisation given or implied to practice any patented invention without a valid licence.; It is the User's obligation to evaluate and use products safely and within the scope advised in the data sheet and to comply with all applicable laws and regulations. No statement made in this publication shall be construed as a permission, recommendation or authorisation given or implied to practice any patented invention without a valid licence.

The Seller shall not be responsible for any loss or damage resulting from any hazards or risks identified in the data sheet and which are associated with petroleum products concerned (provided that this disclaimer shall not affect any statutory rights of the Buyer of the petroleum products concerned).; The Seller shall not be responsible for any loss or damage resulting from any hazards or risks identified in the data sheet and which are associated with petroleum products concerned (provided that this disclaimer shall not affect any statutory rights of the Buyer of the petroleum products concerned).

BP Lubricants and Special Products Limited
Witan Gate House Lubricants Helpline: 0845 - 6031080
500/600 Witan Gate Fax: 0845 - 6031070
MILTON KEYNES
MK9 1ES © BP Oil UK Ltd.; BP Lubricants and Special Products Limited
Witan Gate House Lubricants Helpline: 0845 - 6031080
500/600 Witan Gate Fax: 0845 - 6031070
MILTON KEYNES
MK9 1ES © BP Oil UK Ltd.

Date Created: 06/05/1993 08:13:10 Last Modified: 04/10/2005