



Sevora 916 H

Extreme Pressure Neat Cutting Oil

Description; Description

Sevora 916 H is a low viscosity, high performance extreme pressure neat cutting oil, formulated from a high quality solvent refined mineral oil. The product is a clear transparent golden colour.

Sevora 916 H contains a balanced additive package chosen specially to suit deep hole drilling operations, low levels of odour and fuming tendencies during service.

Applications; Applications

Sevora 916 H is recommended for deep-hole drilling on medium strength steels and some tough aluminium alloys. It can also be used in other applications where a low viscosity product is required. Sevora 916 H contains active sulphur and therefore should not be used for

machining copper alloys. To obtain the best performance with Sevora 916 H, it is recommended that the oil is filtered regularly. This treatment avoids recycling metal fines and prolongs tool life and maintains surface finish.

Main Benefits; Main Benefits

- Capability of machining in arduous operating conditions
- Excellent anti-wear and extreme pressure properties despite absence of chlorine
- Easy tool/workpiece observation

- Low viscosity for economical fluid circulation
- Low tendency to form oil mists in service
- Low viscosity increases penetration at the tool/workpiece interface.
- High heat removal rate

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
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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

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Typical Characteristics; Typical Characteristics

	Test Methods; Test Methods	Units; Units	Grade ; Grade :
			Sevora 916H
Appearance			clear
Colour			brown
Density at 15 °C	ISO 3675, ASTM D1298	kg/m ³	880
Viscosity KV @ 40 °C	ISO 3106, ASTM D445	mm ² /s	18
Flash Point (COC)	ISO 2592, ASTM D92	°C	179
Copper Corrosion	ISO 2160, ASTM D130		4A
Neutralisation Number	ASTM D664	mgKOH/g	1.6
Reichert at 1500N	Reichert	mm ²	7.6
4-Ball Weld Load	ASTM D2783	N	5000

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

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