




---

## Sevora HC 712

### High Performance Neat Cutting Oil

---

#### Description; Description

Sevora HC 712 is one of an advanced generation of neat cutting oils using BP's unique hydrocracked base oils and incorporating new chlorine free extreme pressure (EP) additive technology.

Sevora HC 712 is a light brown, low viscosity, extreme pressure (EP) neat cutting oil, formulated using hydrocracked mineral base oil only. It is a multi purpose product, formulated for use in heavy duty machining operations on both ferrous and non ferrous metals.

---

#### Applications; Applications

Sevora HC 712 is suitable for a very wide range of machining operations - normal and high speed - with a variety of different feedstocks. It can be used in bar turning, milling, turning, thread rolling operations on medium and high tensile steels. It can be also used for the machining of non ferrous materials such as aluminium and copper based alloys.

used in deep hole drilling and some honing applications.

To obtain the best performance with Sevora HC 712, it is recommended to regularly filter the oil. This treatment avoids recycling metal fines and prolongs tool life and maintains surface finish.

The low viscosity of Sevora HC 712 ensures excellent flushing performance hence the product can also be

Sevora HC 712 can be used in both individual machine tools or in centralised systems.

---

#### Main Benefits; Main Benefits

- Low mist generation even under high speed operations
- Low tool wear and improved surface finish
- Excellent oxidation stability offers long service life
- Multi purpose usage - allowing product rationalisation

- Low viscosity means improved swarf/oil separation
- Low odour and aromatic content (<1.0%) for operator acceptability
- Chlorine and zinc free ensures lower disposal costs

---

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

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 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 :
			<b>Sevora HC 712</b>
Appearance			clear liquid
Colour			light brown
Density at 15 °C	ISO3675, ASTM D1298 kg/m <sup>3</sup>		843
Kinematic Viscosity at 20 °C	ISO3106,	mm <sup>2</sup> /s	27
at 40°C	ASTM D445		14
at 100°C			3.4
Viscosity Index	ISO2909, ASTM D2270		137
Flash Point (PMC)	ISO2719, ASTM D93	°C	182
Pour Point	ISO3016, ASTM D97	°C	-27
Copper Corrosion	ISO2160, ASTM D130		1A
Neutralisation Number	ASTM D664	mgKOH/g	0.36
Reichert at 1500N	Reichert	mm <sup>2</sup>	3.0
4 Ball Weld Load	ASTM D2783	N	4400

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

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

**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.**

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: 14/02/1998 19:55:51 Last Modified: 04/10/2005