



Sevora HC 713

High Performance Grinding Oil

Description; Description

Sevora HC 713 is one of an advanced range of neat oils based on BP's unique hydrocracked base oils. It is formulated for high speed and form grinding operations. The combination of the specially refined (hydrocracked) mineral oil and carefully designed additive package reduces fuming and enhances wheel life by maximising cooling at the wheel/workpiece interface.

Sevora HC 713 forms part of a series of machining oils developed by BP especially for these types of high speed profile grinding operations.

Sevora HC 713 is chlorine free.

Applications; Applications

Sevora HC 713 is particularly recommended for the deep grinding of heat treated alloy steels and flute grinding of twist drills. Used with CBN or classic grinding wheels, it can considerably reduce surface burns and therefore prolong wheel life.

To obtain the best performance with Sevora HC 713, 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

- Prolonged grinding wheel life
- Inherently low-fuming
- Consistent ground finish and dimensional accuracy
- Good separation of suspended metal fines

- Rapid shedding of entrained air
- Low-foaming potential
- Low odour for operator comfort
- Chlorine free

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

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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 :
Sevora HC 713			
Appearance at 20°C			bright clear liquid
Colour			yellow
Density at 15°C	ISO3675, ASTM D1298	kg/m ³	838
Kinematic Viscosity at 20°C	ISO3106, ASTM D445	mm ² /s	27
at 40°C			13
at 100°C		4.1	
Viscosity Index	ISO2909, ASTM D2270		136
Pour Point	ISO3016, ASTM D97	°C	-24
Flash Point (COC)	ISO2592/ASTM D92	°C	202
Copper Corrosion	ISO2160/ASTM D130		1A

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.

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