



Sevora HC 916

Extreme Pressure Neat Cutting Oil

Description; Description

Sevora HC 916 is a low viscosity, high performance extreme pressure (EP) neat cutting oil, based on BP's unique hydrocracked base oils. The product is a clear transparent golden colour, has very little odour and does not contain any added chlorine or zinc.

Sevora HC 916 incorporates a balanced additive package chosen specially to cope with difficult machining operations. The product reduces the levels of mist and fumes usually produced during machining operations.

Applications; Applications

Sevora HC 916 is suitable for a variety of operations - milling, turning, deep hole drilling - on medium strength steels and some tough aluminium alloys. It can be used in other applications where a low viscosity cutting oil with low fuming characteristics is required.

To obtain the best performance with Sevora HC 916, it is recommended to filter the oil regularly. This treatment avoids recycling metal fines and prolongs tool life and maintains surface finish.

Sevora HC 916 contains active sulphur and should not be used for machining copper alloys.

Sevora HC 916 can be used in both individual machine tools or in centralised systems.

Main Benefits; Main Benefits

- Low tendency to form oil mists in service
- Capability of machining in arduous operating conditions
- Low viscosity increases penetration at the tool - workpiece interface
- Excellent swarf/oil separation properties

- Low viscosity for economical fluid circulation
- Easy tool/workpiece observation
- Excellent anti-wear and extreme pressure properties despite absence of chlorine
- 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

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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.

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Typical Characteristics; Typical Characteristics

	Test Methods; Test Methods	Units; Units	Grade ;; Grade :
Sevora HC 916			
Appearance at 20°C			bright clear liquid
Colour			amber
Density at 15 °C	ISO3675, kg/m ³ ASTM D1298		840
Kinematic Viscosity at 20 °C	ISO3106,	mm ² /s	30
at 40°C	ASTM D445		15
at 100°C			3.5
Viscosity Index	ISO2909, ASTM D2270		131
Pour Point	ISO3016, ASTM D97	°C	-24
Flash Point (PMC)	ISO2719, ASTM D93	°C	189
Copper Corrosion	ISO2160, ASTM D130		4A
Neutralisation Number	ASTM D664	mgKOH/g	0.12
Reichert at 1500N	Reichert	mm ²	2.2
4 Ball Weld Load	ASTM D2783	N	5200

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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Date Created: 14/02/1998 21:07:43 Last Modified: 04/10/2005