

# SPARTAN CHEMICALS

11 Spring Gardens  
Silsden, Keighley  
West Yorkshire  
BD20 0DJ  
Landline 01535657621  
**MOBILE 07 774 480335**

E.Mail [billleagleson76@gmail.com](mailto:billleagleson76@gmail.com)

E-MAIL [sales@spartanchemicals.co.uk](mailto:sales@spartanchemicals.co.uk)

Web Site [www.spartanchemicals.co.uk](http://www.spartanchemicals.co.uk)

## SPARCOOL M 40 BFEP LU 405

The meaning of the term '*general purpose machining*' has changed significantly in recent times. No longer does this refer to an old capstan lathe on which 'odd job' machining is carried out Sparcool M40 BFEP reflects this trend in that it is truly an 'all round' water-mix metalworking fluid able to deal easily with high chromium steels and nimonic alloys, as well as mild steel, and many operations where neat oils have been utilised. Sparcool M40 BFEP with its blend of surface active and hydrodynamic lubrication additives is suitable for use on more arduous machining operations such as drilling and tapping, in addition to general machining.

Sparcool M40 BFEP provides the clean working environment and long sump life expected of a modern bio-stable fluid, and is Boron Free, Triazine Free, Phenol free, Formaldehyde free, and Contains no long chain Chlorinated Paraffin's. These features improve the operator working environment whilst removing the need for 'post machining' cleaning operations.

### Specification

Appearance of Concentrate	Amber liquid
Specific Gravity @ 20°C	0.97
pH @ 3% (Distilled Water)	9.5
Reichert Performance @10% dil	NR: 27m - 1.71Kg/mm <sup>2</sup>
Anti – corrosion by IP287	3.0% Break Point
Refractometer Correction Factor	1.0

### Application

Sparcool M40 BFEP should not be used at concentrations less than its specified break point.

Maximum machining performance can be achieved at concentrations up to 12% however, the majority of operations will be completed with concentrations in the range 3 - 6%.

### Advantages

Improved surface finish, better tool life.

Can be used to replace neat cutting oils on moderate operations.

Permits higher cutting speeds.

Excellent lubricity and wetting properties.

**Machining Operations** in addition to general machining Include: Screw cutting, reaming, gear cutting, broaching, deep hole boring.

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