

## SPF 3340

### SEVERE DUTY METALWORKING FLUID

#### Description

SPF 3340 is a neo-synthetic metalworking fluid designed for high wear applications. The product has enhanced anti-wear/extreme pressure properties with performance equal to many oil based formulations.

This highly engineered fluid has replaced oil based products in sever applications such as broaching, gun drilling, pull boring, trepanning and low RPM tapping.

Efficient lubricity is achieved through the use of highly refined mineral oils and polymeric wetting agents. SPF 3340 incorporates a number of extreme pressure and anti-wear agents designed to provide protection at various temperatures of the tool and work piece interface.

SPF 3340 provides extended sump life and is an excellent choice to replace heavy sulfurized oils in flooded circulated systems.

#### Features & Benefits

- Excellent for severe duty applications
- Capable of replacing oil in low RPM operations
- No strong sulfur smell
- Applied cost savings over oil
- Eliminates the need to centrifuge oil off parts
- Significant sump life stability

#### Health & Safety

See the most recent MSDS which is available directly from Precision Fluids, your local salesman, or authorized distributor. Precision Fluids uses only raw materials not listed as carcinogenic by IRAC.

#### Physical Data

Appearance:	Clear Amber
Diluted Appearance:	Translucent Amber
Solubility	Water
Odor:	Mild Industrial
Specific Gravity:	1.01
Concentrate pH:	9.8
pH, 5 % dilution:	9.5
Freeze/Thaw Cycle:	Passed 3x

#### Application & Usage

Precision Fluid recommends using our Super Green cleaner before adding SPF 3340 to a machine.

The recommended concentration for SPF 3340 is 25% for optimum results. However, best results for any operation can only be determined through testing.

Maintaining the coolant at its optimum concentration is achieved through daily refractive index checking.

No special precautions are necessary with respect to seals or valves.

#### Refractive Index Monitoring (2.5X multiplier)

Percent	Ratio	Refractometer Reading
10	9 to 1	4.0
15	7 to 1	6.0
20	4 to 1	8.0
25	3 to 1	10.0

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