

TECHNICAL DATA SHEET

HOCUT® 4260

WATER SOLUBLE METALWORKING FLUID

HOCUT® 4260 is advanced, heavy duty, boron-free and formaldehyde-free emulsion technology giving very long sump-life.

A special additive package greatly enhances machining performance and extends tool life compared to conventional products. HOCUT® 4260 is effective when machining aerospace aluminum or fiber composite airframe structural components as well as engine components made of Titanium alloys or Inconel.

Applications

HOCUT® 4260 is an advanced, high lubricity metal removal fluid specially formulated for machining and grinding of a wide range of materials including aerospace aluminum alloys, high-alloy steels, stainless steel, composite materials, titanium and other high temperature alloys for engine parts. In doing so, a proprietary lubricant package reduces tool wear in difficult to machine alloys. In machining and grinding operations where low foam is a required, HOCUT® 4260 successfully resists foaming in a wide range of water hardness. The EHS profile represents the elimination of boron and other undesirable chemical components. The high biostability of HOCUT® 4260 eliminates the need for regular tankside biocide additions where that is desired.

Recommendation for Use

Heavy duty machining 8 to 10%

Health, Safety and Handling

Please consult the Safety Data Sheet (SDS) for information on storage, safe handling and disposal. The conditions or methods of handling, storage, use and disposal of the product are beyond our reasonable control - we assume no liability for any ineffectiveness of the product or any injury or damage, arising out of or in connection with these conditions.

Benefits

- Versatile : facilitates machining of fiber composites, aero aluminum alloys, ferrous alloys, stainless steel, titanium and other high heat aerospace materials
- High detergency: leaves parts and working environment clean
- Extended tool life : anti-wear additive package minimizes tool wear, saving tooling costs
- Very long sump-life: new HOCUT® 4000 series emulsion technology extends coolant life minimizing waste disposal and direct labor
- Inhibits aluminum staining: can be used for sensitive alloys e.g. 7000 series
- Very low foaming: ideal for the highest speeds and pressures in soft to hard water
- Favorable EHS profile: Free from boron, formaldehyde, chlorine, secondary amine, and phenol

Properties

PROPERTY	TYPICAL VALUE	UNIT
Appearance	Pale yellow liquid	
Density	0.99 8.3	g/cc lbs/gal
Refractometer Factor	1.6	
Typical pH in use	9.0	



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Approvals

HOCUT® 4260 holds the following approvals and conformities:

- Airbus AIMS 12-10-0000 and 80T-30-4010 : ASTM F483 ; ASTM F1110; Table A7.1
- Airbus AIPI 01-02-003 : Aluminium Elementary Parts NCF1378
- Airbus AIPI 03-11-001 : Conforms to the requirements
- Boeing BAC 5008 cat. 5 & 6 (independent lab testing): conforms
- Bombardier BAMS 569-001: Class A, C, D: approved
- Dassault: approved
- SAFRAN Aircraft Engines: PR 6300 approved on all materials
- Messier Dowty (SAFRAN Equipment): approved PCS4001/PCS4002

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