

TECHNICAL DATA SHEET

HOCUT® 4260

WATER SOLUBLE METALWORKING FLUID

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

A special additive package gives greatly enhanced machining performance and extends tool life, compared to conventional products. HOCUT® 4260 is particularly effective on machining aerospace airframe structural components in aluminium alloys and fiber composites, but also for engine elements made of titanium alloys and inconel.

This product holds the following approvals and conformities:

- Airbus AIPS00-00-010 & A2MS 569-001
- Boeing BAC 5008 cat. 5 & 6: conform
- Bombardier BAMS 569-001: A, C & D: approved
- Dassault: DGQT 1.7.0.0092
- Rolls Royce: CSS 129, CSS 131
- SAFRAN Engines / SNECMA : 455-201-0-00 & PR 6300
- SAFRAN Landing Systems: PCS 4002 steels, titanium & aluminium alloys, hard Cr grinding

Applications

HOCUT® 4260 is recommended for low to heavy duty machining including high speed of a wide range of aerospace materials including aluminium alloys (series 2000 and 7000 in particular), fiber composites, but also ferrous alloys. HOCUT® 4260 is suitable too for grinding applications.

The product is suitable for both centralised systems and single-ump machines while the advanced boron-free technology extends emulsion life without the need for regular biocide treatments.

The versatile formulation is designed to give low foam and no soaps in soft to hard water (3°dH - 40 °dH cumulated hardness).

Its operator-friendly EHS profile and its non-staining & corrosion-free properties make HOCUT® 4260 particularly efficient on aero structural airframe components. An advanced antiwear additive extends the tool life.

Recommendation For Use

Low to medium duty machining 5-8 %

Heavy duty machining 7-12%

Grinding 5-10%

Benefits

- Versatile : it can be used on all of the Aerospace materials and applications.
- High detergency : leaves clean parts and working environment
- Extended tool life : thanks to antiwear additive package tool wear is minimized, saving tooling costs
- Very long sump-life : new HOCUT 4000 series emulsion technology extends intervals between clean outs
- Very stable emulsion : fewer additive treatments and lower usage costs
- Inhibits aluminium staining : can be used for sensitive alloys eg 7000 series
- Very low foaming : ideal for the highest speeds and pressures in soft to hard water (3°dH - 40°dH)
- Excellent EHS profile : boron, formaldehyde, chlorine and phenol-free. Contains only TRGS 611 approved amines

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.

Typical Physical Properties

PROPERTY	TYPICAL VALUE	UNIT
Concentrate Appearance	pale yellow	[-]
Specific Gravity	985	Kg/m3 @ 20°C
Refractometer Factor	1.5	%°Brix
Emulsion Appearance	Translucent	
pH @6%	9.5	[-]

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