

# TECHNICAL DATA SHEET

## HOCUT® 3745

### VERSATILE SEMI-SYNTHETIC BASED METALWORKING FLUID

HOCUT® 3745 is an economical soluble cutting fluid intended for a broad range of applications in both ferrous applications and aluminum. Containing no chlorine, this product is highly biostable, compatible in very soft water and hard water delivering a resilient emulsion and high quality surface finish on aluminum.

#### Applications

Machining in 50 ppm to 500 ppm hardness water where system emulsion stability and resistance to biological growth are important for manufacturers not using treated water. HOCUT® 3745 does not stain aluminum, offers clean operation forming very little soap, low foaming in soft water and solid lubricity. On the ALE-2 CNC work center, HOCUT® 3745 effectively drilled holes and reamed to surface roughness of <0.6 um at varying speeds.

#### Recommendation for Use

Recommended starting concentration of 5 to 10% for machining aluminum or ferrous parts.

HOCUT® 3745 should be added to water creating an emulsion for use as a machining coolant.

#### Benefits

- A lubricant formulation delivering excellent surface finish and long tool life
- Reliable resistance to metal staining
- A stable emulsion up to 1500 ppm hardness conditions. Can compensate for the effects of modern high magnesium containing aluminum alloys and house hard water
- Runs clean and doesn't form residues and soap associated with non-ferrous machining
- Reliable resistance to biological growth for extended sump life and recycling programs

#### 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.

#### Properties

PROPERTY	TYPICAL VALUE	UNIT
Appearance	Amber liquid	
Density at 15.5°C	0.9926	g/cc
pH at 5%	9.8	
Refractometer Factor	1.5	

All reasonable care has been taken to ensure this publication is accurate upon issue. Such information may be affected by changes subsequent to issue. This Technical Data Sheet is to be used solely for this product. Prior to any use, consult the Safety Data Sheet (SDS) for information on hazard risks and product use parameters. All liability and all warranties express or implied are hereby excluded as to product performance results, the accuracy of these data including any warranty of merchantability or fitness for any purpose.

