

# TECHNICAL DATA SHEET

## HOCUT® 4646

### WATER SOLUBLE METALWORKING FLUID

HOCUT® 4646 is an advanced, semi-synthetic, boron and formaldehyde-free emulsion technology giving ultra-long sump-life and enhanced machining performance compared to conventional products.

#### Applications

HOCUT® 4646 is a general purpose semi-synthetic coolant suitable for light to medium duty machining and grinding of ferrous materials.

HOCUT® 4646 is also suitable for light duty machining of aluminium alloys.

Ultra long-life makes the product suitable for both centralised systems and single-sump machines while the advanced boron-free technology extends emulsion life without the need for regular biocide treatments.

HOCUT® 4646 is designed for soft to hard water quality typically 5-30 German degrees.

#### Recommendation For Use

Light to medium duty ferrous machining 5-10%

Ferrous grinding 5-6%

Light duty aluminium machining 5-10%

#### Benefits

- Versatile performance : ideal for all general machining and grinding operations on ferrous materials
- Very high detergency : maintains clean conditions when machining cast iron
- Very long sump-life : new HOCUT® 4000 series emulsion technology extends intervals between clean outs
- Very stable emulsion : long fluid life, fewer additive treatments and lower usage costs
- Very low foaming : designed for high pressures and flow rates in both soft and hard water
- Does not stain aluminium : can be used for Multi-metal applications
- 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	Amber oil	
Specific Gravity @20°C	0.97	DIN 51757
Refractometer Factor	1.4	HIM 53
Emulsion Appearance	Translucent	
pH @6%	8.9-9.5	DIN 51369

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