

HOCUT 4260

Water soluble metalworking fluid

DESCRIPTION

HOCUT 4260 is advanced, low to medium 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, titanium alloys or fiber composites.

This product holds the following approvals and conformities:

- Airbus AIMS 12-10-001 (80T-30-4010 - ASTM F1110 - ASTM F483) : conform
- Boeing BAC 5008 cat. 5 & 6: conform
- Bombardier BAMS 569-001: A : conform
- Dassault: approved
- SAFRAN Engine PR 6300 : All materials
- SNECMA : Hot corrosion Ti, Al & Ni alloys : Conform

APPLICATIONS

HOCUT 4260 is recommended for low to medium 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-sump 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 (10°dH - 70 °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 too.

RECOMMENDATION FOR USE

Low to medium duty machining 5 - 8 %

TYPICAL PHYSICAL PROPERTIES

Concentrate Appearance	pale yellow	
Specific Gravity @ 20°C	0.99	DIN 51757
Refractometer Factor	1.5	HIM 53
Emulsion Appearance	Translucent	
pH in Use	9.5	DIN 51369

BENEFITS

- o **Versatile** : can process very various materials, ranking from fiber composites, to aero aluminium alloys as well as ferrous alloys
- o **High detergency** : leaves clean parts and working environment
- o **Extended tool life** : thanks to antiwear additive package tool wear is minimized, saving tooling costs
- o **Very long sump-life** : new HOCUT 4000 series emulsion technology extends intervals between clean outs
- o **Very stable emulsion** : fewer additive treatments and lower usage costs
- o **Inhibits aluminium staining** : can be used for sensitive alloys eg 7000 series
- o **Very low foaming** : ideal for the highest speeds and pressures in soft to hard water (10°dH - 70°dH)
- o **Excellent EHS profile** : boron, formaldehyde, chlorine and phenol-free. Contains only TRGS 611 approved amines

RELATED PRODUCT

Water soluble coolants are complemented by our full range of high quality, speciality production fluids including energy saving wash chemicals , low misting neat cutting oils, non-VOC rust preventives and long life heat treatment fluids. Fluidcare services complete our value added portfolio with a range of expert services and equipment to help reduce costs and improve productivity. For more information, please contact your local Houghton representative.

STORAGE

Please refer to section 7 of Safety Data Sheets for handling and storage information, including product shelf life. Product should be stored under cover in clean, dry conditions and protected from frost. Recommended storage temperature is usually between 5°C and 40°C unless otherwise specified. Use stock in delivery rotation.

HEALTH AND SAFETY

Safety data sheets are available in accordance with Regulations (EC) No 1907/2006 Annex II and (EC) No 1272/2008.

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