

Hocut® 4650

Heavy-duty machining and grinding fluid for use with all metals including automotive grade cast aluminum

DESCRIPTION

Many of today's modern machine shops require the use of one coolant capable of working in many applications on a wide variety of metals. **Hocut 4650** is such a product. It is a versatile product that can be used with many machines including Kingsburys, Bullards, bar machines, lathes, chucks, centerless and cylindrical grinders. Whether you're cutting high or low carbon steels, alloy steels such as 4130 and 4140; cast iron, nodular iron and gray iron; 300 and 400 series stainless steel, **Hocut 4650** is the choice. It is especially suitable when machining automotive grade aluminum cast alloys including 308, 319, 356, 380, 384 and 390. **Hocut 4650** contains an additional ingredient to aid machining of ferrous alloys.

Hocut 4650 is compatible with hard water, is clean running and biostable, which assures long, odor-free sump life. It provides corrosion protection without staining and affords good lubrication for machine ways and indexing mechanisms. Low foaming characteristics make **Hocut 4650** an excellent choice for gun drilling and other high pressure applications.

RECOMMENDED USE CONCENTRATION

Machining	5 to 10%
Grinding	5%

DATA (TYPICAL VALUES)

Appearance, Neat	Amber color liquid
Appearance, 5% Emulsion	Milky emulsion
Typical in-use pH	8.9 - 9.3

FEATURES / BENEFITS

- Clean running/low foam
- Reduced disposal cost/less down time/operator acceptance
- Excellent corrosion protection
- In-process protection of machinery and parts
- Excellent machining capabilities
- Increased tool life; improves surface finish

CONCENTRATION CHECKS

The refractometer factor for **Hocut 4650** is 1.0. Multiply the refractometer reading by this factor to obtain the emulsion concentration in percent.

HEALTH AND SAFETY

Refer to SDS for proper handling and disposal. Please note that the SDS includes handling, health and disposal information which should be passed on to your employees, and to anyone else who comes in contact with our product. Additional advice can also be obtained from your local Houghton representative.

NOTE: Read and understand all precautions on container labels before using this product.

DM 14.08 US



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