

HOCUT® 400-K

Heavy Duty Chlorine-Free Machining and Grinding Fluid for use with all Metals including Automotive Grade Cast Iron

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 400-K** is such a product. Its versatility can be demonstrated by machines and metals on which it can be used. These include 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 400-K** is the choice. It is especially suitable when machining automotive grade aluminum cast alloys including 308, 319, 356, 380, 384 and 390.

HOCUT 400-K is compatible with hard water, is clean running and biostable, which assures long, odor-free sump life.

FEATURES

- Very high stability – extending the fluid life
- Good cooling properties that provide sufficient tool life and part geometry
- Excellent detergency – resulting in clean parts, clean machines and assisting in creating a more pleasant working environment
- Non Staining on Aluminium cast alloys
- Very low foam – guaranteeing problem free working operations and allowing high pump pressures and flow rates
- Good separation of tramp oil – which as a result can easily be removed as thus supporting a long fluid life
- Increase tool life; improves surface finish

TYPICAL VALUES

Product Appearance	Clear Fluid
Emulsion Appearance @5%	Translucent White
pH @5 %v/v	9.2
Specific Gravity @15°C	1.020 kg/L
Brix Concentration Factor	1.6
Mineral Oil content:	< 10%

HEALTH AND SAFETY

Refer to MSDS for proper handling and disposal. Please note that the MSDS 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.



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This document contains information based on data that is believed to be correct. However, the product may not be applicable to all uses and operating environments. No warranty or guarantee is expressed or implied.

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REFERENCES

HOCUT 400-K is suitable for all removal and grinding operations as well on standalone machines and in central systems.

HOW TO USE

The concentration of **HOCUT 400-K** varies depending on the type of machining operation, the water hardness and the required inter-operational corrosion protection.

General machining :	4 – 6 %
Severe cutting operations :	5 – 10 %
Grinding :	4 - 5 %

This may be customised to suit individual needs or solutions, which may vary from time to time. Houghton strongly advises that you contact your Sales Representative to discuss before commencement of use.

SHELFLIFE & AVAILABILITY

Under normal conditions the recommended shelf life for **HOCUT 400-K** is a minimum of Twelve (12) months, unless otherwise specified. The product should be stored inside (5 -40°C) for no more than 1 year and be protected from freezing.

HOCUT 400-K is available in Pail, Drum or Tote. Other sizes may be available upon request , please contact your Houghton sales representative.

RELATED PRODUCTS

- HOUGHTO-SAFE 600®: Water Glycol HFDC fluids
- COSMOLUBRIC®: Polyol or Vegetable HFDC fluids
- HOUGHTO-SAFE 1000®: Phosphate Ester HFDC fluids
- CUT-MAX®: Straight cutting oils
- GARIA™: Straight cutting oils
- MACRON™: Straight cutting and honing oils
- EXCELENE™: Straight cutting and honing oils
- DASCOLENE™: Straight OEM approved cutting oils
- HOCUT®: Water miscible metalworking fluids
- DASCOOL™: Water miscible metalworking fluids
- ADRANA™: Micro-emulsion metalworking fluids
- SITALA™: Semi-Synthetic metalworking fluids
- METALINA™: Synthetic metalworking fluids
- HOUGHTO-GRIND®: Straight and water miscible grinding fluids
- HOUGHTO-DRAW®: Straight and water miscible drawing stamping and forming fluids.
- CINDOL™: Straight and water miscible drawing and forming fluids especially for Aluminum parts.
- FENELLA™: Straight and water miscible drawing, stamping and forming fluids.
- CERFA-KLEEN®: Water miscible cleaning fluids
- CALLINA™: Water miscible cleaning fluids
- RUST VETO®: Straight and water miscible rust preventive fluids.
- ENSIS™: Straight and water miscible rust preventive fluids.



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