

Product Data Sheet

Hocut B50S

Biostable Semi-synthetic Coolant

Hocut B50S is a blend of severely refined mineral oils, corrosion inhibitors and biostable additives. Upon dilution, the resulting translucent emulsion offers excellent sump life and good machining characteristics.

Application Profile

A wide range of machining and grinding applications will benefit from the use of Hocut B50S with its features of low foaming and excellent resistance to bacterial attack. Hocut B50S is a highly versatile product and can be used in single sump machines or in centralised systems. Most metals and alloys can be successfully used with Hocut B50S, with the emulsions offering good inter-stage corrosion protection.

Benefits

- | | | | |
|---|--------------------|---|-------------------------------|
| * | Extended sump life | * | Maintains machine cleanliness |
| * | Low foaming | * | Cost-effective |
| * | Chlorine-free | * | Good corrosion protection |
| * | Rejects tramp oil | * | No sticky residues |

Recommendations for Use

Grinding 3 - 4% General Machining 3 - 5%

NB Good concentration control is essential when using Hocut B50S. If concentration becomes too low, poor sump life may be experienced, whereas high concentrations could lead to potential problems as outlined in the Health and Safety Data Sheet.

Typical Properties

Concentrate	Appearance	Stable amber fluid
	Specific Gravity at 15.5°C	1.04
Emulsion at 3%	Appearance	Translucent emulsion
	Odour	Lavender
	pH (in use)	9.5
	Corrosion Protection:	IP125 2.0% Pass IP287 2.5% (Break Point)

GENERAL DATA

Concentration Control

To achieve optimum performance, freedom from micro-organisms and corrosion it is essential that coolants are maintained at the recommended concentration. The concentration can be monitored on a day to day basis using a refractometer and the Fluid Concentration Chart. More accurate values can be obtained using laboratory titration methods. Your Houghton Representative can advise on overall fluid control within our comprehensive Fluid Management System.

Mixing

Use coolant mixing valves where possible. When mixing by hand slowly add concentrate to water whilst stirring vigorously. Coolants should not be mixed in the machine sump. Avoid using chilled water.

Top Up

Coolant concentration may increase in use due to water evaporation. To maintain the recommended concentration, top up should be made with a more dilute concentration and not by water alone.

Water Quality

Coolant performance can be affected by extremes of water quality. Hard water (in excess of 300 ppm CaCO₃) and high levels of chlorides and sulphates can reduce the stability of emulsions and reduce corrosion protection. Your Houghton Representative can advise on local water quality.

Contamination

Where possible avoid contamination from foreign matter and other fluids. Remove swarf and tramp oil from the machine sumps frequently.

Disposal

Discarded metal working coolants may be removed by a competent waste contractor. Alternatively, the product may be treated by conventional oil separation and effluent disposal methods. Specific advice is available on request. Product concentrate or diluted fluid should not be introduced into waterways. It is advisable to consult the Local Water Authority regarding disposal.

Storage

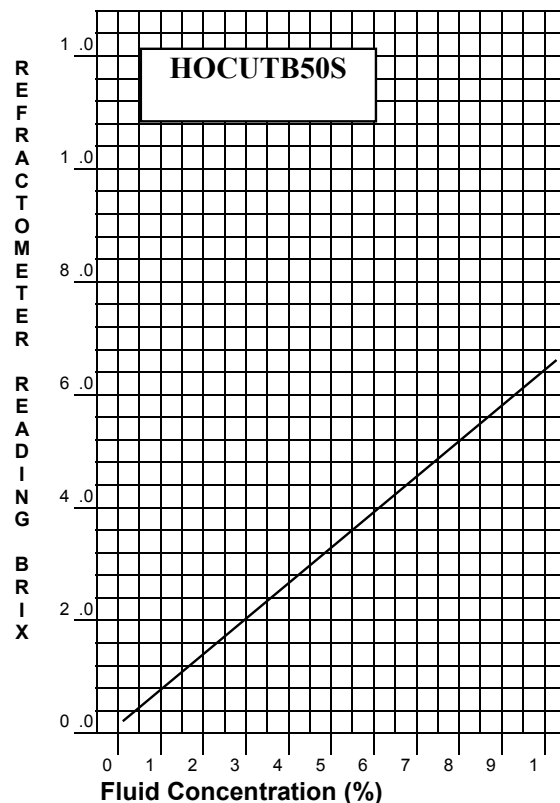
Metal working coolants should be stored indoors in clean, dry conditions. Protect from frost. Recommended storage temperature is between 5°C and 35°C. If temporarily stored outdoors, do not place drums upright. Tops should be replaced on all containers when not in use.

All drums, tanks and containers should be clearly marked with product names. Use stock in delivery rotation. As with all metal working coolants, a shelf life of six months can be anticipated.

Health and Safety

Health and Safety Data Sheets are supplied to customers to comply with Section 6 of the Health and Safety at Work Act 1974, and should be closely studied prior to handling or use of the product. Copies are available from your Technical Health and Safety Officer. Various other advisory publications are available from the Health and Safety Executive and Her Majesty's Stationery Office.

Fluid Concentration Chart



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