

# HOCUT 4646

Water soluble metalworking fluid

## DESCRIPTION

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%

## TYPICAL PHYSICAL PROPERTIES

Concentrate Appearance	Amber oil	
Specific Gravity @ 20°C	0.97	
Refractometer Factor	1.4	
Emulsion Appearance	Translucent	
pH in Use	8.9-9.5	
Min. Anti-Corr. Protection limit (o – o)	3.5%	DIN 51360/2

## 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

## 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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