

HOCUT 3274

Data Sheet

MULTIPURPOSE EMULSIFIABLE FLUID WITH HIGH CONTENT OF E.P. ADDITIVES

HOCUT 3274, mixed with water, forms a steady milky emulsion featuring high cutting properties and very low foam tendency even at high concentration and high working pressure.

HOCUT 3274 is designed for heavy metal working operations on ferrous alloys, stainless steel, aluminium and bronze performing good surface finishing.

HOCUT 3274 has been formulated for usage in medium hardness water.

For severe operations, such as deep drawing, broaching, etc., it is available a strengthened version named HOCUT 3276 containing sulphurized E.P. additives.

CHEMICAL-PHYSICAL CHARACTERISTICS

NEAT	
Appearance	Amber fluid
Viscosity at 40°C [mm ² /sec]	48÷60
Specific gravity at 15.5°C	0.9950÷1.005
Mineral oil content [%]	approx. 36%
EMULSION	
Appearance	Milky
pH at 3% distilled water	9.5-10.0
Antirust test [DIN 51360/2]	3% pass

CONCENTRATION OF USE	
TURNING - MILLING [%]	3÷5
DRILLING - REAMING [%]	6÷10
CONCENTRATION DETERMINATION	
Refractometric factor	1.2

STORAGE

HOCUT 3274 maintains its chemical-physical and technical characteristics if stored in a sheltered place at temperatures ranging -5°C÷+40°C for a maximum period of six months.

HEALTH & SAFETY

No toxic or carcinogenic, teratogenic or mutagenic known materials are contained in HOCUT 3274 such as nitrosamines, phenols, polyichlorinated diphenyl, heavy metals, polinuclear hydrocarbons.

WASTE TREATMENT

HOCUT 3274 cannot be directly discharged. Follow national or local instructions.