

Hocut 3290

High Lubricity Chlorine and Sulphur Free Soluble Oil

Hocut 3290 is based upon latest technology chlorine-free high performance lubricity agents blended with severely refined mineral oils. The resultant rich milky emulsion is extremely low foaming and provides excellent corrosion protection. The product also has a very effective package for bacteria protection to give extended and predictable sump life in single sump machines

Application Profile

The high performance characteristics of Hocut 3290 make it ideal for machining aluminium and its alloys, and on medium to heavy duty machining of alloy steels. Hocut 3290 is specifically designed for creep feed grinding operations and the high pressure coolant systems associated with modern CNC machine tools.

Benefits

- * High lubricity
- * Stable milky emulsion
- * Resistant to bacteria
- * No sticky residues
- * Chlorine-free
- * Excellent cutting performance
- * Extremely low foaming
- * Diethanolamine free

Recommendations for Use

Creep Feed Grinding	5% - 10%	Conforms to CSS131
Heavy duty machining	5% - 10%	Conforms to CSS129

Typical Properties

Concentrate	Appearance	Clear amber fluid
	Specific Gravity at 15.5°C	0.94
Emulsion (at 3%)	Appearance	Stable milky emulsion
	Odour	Bland
	pH (in use)	8.9 - 9.3
	Corrosion Protection	IP 125 Pass at 1.0% IP 287 Break Point 2.0%

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.

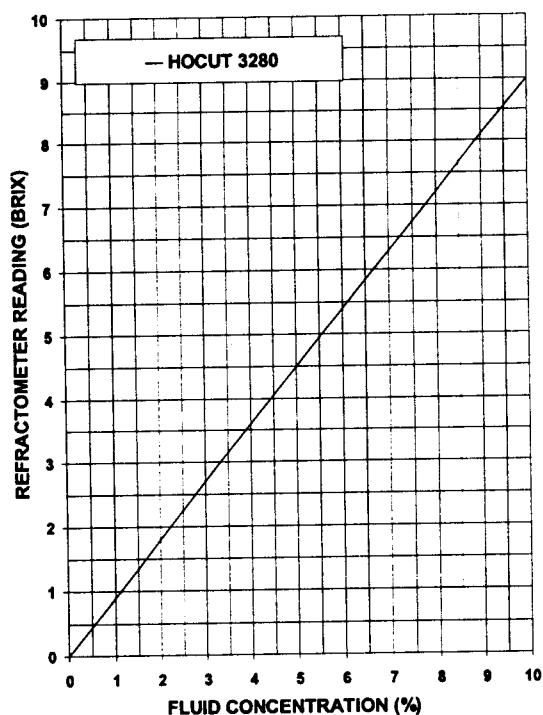
Contamination

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.

Fluid Concentration Chart



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.

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