

# TECHNICAL DATA SHEET

## HOCUT® 4940

### WATER SOLUBLE METALWORKING FLUID

HOCUT® 4940 is advanced, high lubricity, boron-free and formaldehyde-free emulsion technology giving very long sump-life.

A special additive package gives greatly enhanced machining performance compared to conventional products and is particularly effective on difficult aerospace materials including aluminium, nickel and titanium alloys..

This product holds the following approvals and conformities:

- Airbus AIPS00-00-010 & A2MS 569-001
- Alenia: conformance
- Boeing BAC 5008 cat. 5&6: conformance
- Bombardier BAMS 569-001 class A, C, D: approved
- Grob: approved
- Messier Bugatti Dowty: PCS 4001 / PCS 4002
- Motor Sich : approved
- Pratt Whitney (UTC): PWA 36604
- Rolls Royce : CSS 129, CSS 131
- Safran / Snecma : 455-201-0-00 & PR 6300
- SAE Aerospace: ASTM F1100/F945/F519/F483

#### Benefits

- High lubricity : sophisticated package of mineral oil and polar additives extend tool-life
- Very long sump-life : new HOCUT 4000 series emulsion technology extends intervals between clean outs
- Very stable emulsion : fewer additive treatments and lower usage costs
- Inhibits aluminium staining : can be used for sensitive alloys eg 7000 series
- Very low foaming : ideal for the highest speeds and pressures in soft water
- Excellent EHS profile : Boron, formaldehyde, chlorine and Phenol-free. Contains only TRGS 611 approved amines

#### Health, Safety And Handling

Please consult the Safety Data Sheet (SDS) for information on storage, safe handling and disposal. The conditions or methods of handling, storage, use and disposal of the product are beyond our reasonable control - we assume no liability for any ineffectiveness of the product or any injury or damage, arising out of or in connection with these conditions.

#### Typical Physical Properties

PROPERTY	TYPICAL VALUE	UNIT
Concentrate Appearance	Amber oil	
Specific Gravity @20°C	0.93	DIN 51757
Refractometer Factor	1.05	HIM 53
Emulsion Appearance	Milky white	
pH @6%	8.9-9.5	DIN 51369

#### Applications

HOCUT® 4940 is recommended for heavy duty machining of a wide range of aerospace materials including aluminium alloys (series 2000 and 7000 in particular), high alloy steels and difficult aerospace materials such as titanium and nickel alloys.

The product is 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.

The versatile formulation is designed to give low foam in soft water.

#### Recommendation For Use

Medium duty machining 6-8 %

Heavy duty machining 8-10 %

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