

# PRODUCT DATA

## HOCUT 787BN

### HEAVY-DUTY MACHINING AND GRINDING FLUID FOR USE WITH ALL METALS INCLUDING AUTOMOTIVE GRADE CAST ALUMINUMS

Many of today's modern machine shops require the use of one coolant capable of working in many applications on a wide variety of metals. **HOCUT 787BN** is such a product. Its versatility can be demonstrated by machines and metals on which it can be used. These include Kingsburys, Bullards, bar machines, lathes, chuckers, centerless and cylindrical grinders. Whether you're cutting high or low carbon steels, alloy steels such as 4130 and 4140; cast iron, nodular iron and gray iron; 300 and 400 series stainless steel, **HOCUT 787BN** is the choice. It is especially suitable when machining automotive grade aluminum cast alloys including 308, 319, 356, 380, 384 and 390.

**HOCUT 787BN** is compatible with hard water, is clean running and biostable, which assures long, odor-free sump life. It provides corrosion protection without staining and affords good lubrication for machine ways and indexing mechanisms.

#### FEATURES

- \* Clean running
- \* Excellent corrosion protection
- \* Excellent machining capabilities

#### BENEFITS

- \* Reduced disposal cost/less down time
- \* In-process protection of machinery and parts
- \* Increased tool life; improves surface finish



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**TYPICAL PHYSICAL AND CHEMICAL PROPERTIES**

Appearance	
Neat	Hazy amber color liquid
5% Emulsion	Whitish emulsion
pH, 5% Dilution	9.4
Pounds per Gallon, 60°F	8.1

**RECOMMENDED USE CONCENTRATION**

Machining	10:1 to 20:1
Grinding	20:1 to 25:1

**CONCENTRATION CHECKS**

The refractometer factor for **HOCUT 787BN** is 1.1. Multiply the refractometer reading by this factor to obtain the emulsion concentration in percent.

**HOCUT 787BN** may also be checked by splitting the emulsion. Put 80 ml. of emulsion into a 100 ml. graduated cylinder. Add sodium bisulfate to the cylinder until the level of salt reaches the 10 ml. mark on the bottom. Shake thoroughly to dissolve as much salt as possible. Allow the emulsion to stand for approximately 30 minutes, preferably in a hot water bath, to obtain a sharp oil split. Determine the number of milliliters of oil that have been split out from the emulsion. Multiply the number of milliliters by 1.25 to estimate the emulsion concentration.

In checking emulsion concentration, whether by the refractometer, or salt split method, tramp oil will show up as part of the total oil.

**SHELF LIFE**

Under normal conditions, the recommended shelf life for **HOCUT 787BN** is six (6) months.

**SHIPPING INFORMATION**

**HOCUT 787BN** is shipped in 55 (U.S.) gallon (208 liter) steel drums and in bulk.

**SHIPPING CLASSIFICATION**

Metal Cutting and Drawing Compound

**STORAGE/HANDLING/DISPOSABILITY**

No health or safety hazards exist when **HOCUT 787BN** is stored, used and disposed of in accordance with instructions given on the Material Safety Data Sheet for this product.

**WARRANTY**

The information given here is considered to be correct and is offered for your consideration, investigation and verification. No warranties are expressed or implied, since the use of our products is beyond our control. Statements concerning the use of Houghton products are not to be construed as recommending the infringement of any patent.

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