

## Hocut WS 9003

### Medium Duty Synthetic Machining and Grinding Fluid



#### WHAT IT DOES:

**Hocut WS 9003** is a light to medium duty synthetic machining and grinding fluid specially formulated for the machining of carbide. Its unique additive package minimizes the cobalt leaching common with many other synthetic coolants. It can be used on a wide variety of ferrous metals. **Hocut WS 9003** contains no chlorine, sulfur or phosphorus additives. It has excellent corrosion protection at concentrations as low as 50:1 and is virtually non-foaming.

#### WHERE TO USE IT:

**Hocut WS 9003** is recommended for use on a wide variety of ferrous metals.

#### PERFORMANCE BENEFITS:

**Hocut WS 9003** has been specifically formulated to deliver the following performance benefits:

- Superior Tool Life
- Excellent Sump Life
- Operator Friendly
- Non-Foaming
- Excellent Corrosion Protection
- Minimal cobalt leaching



2080 FERRISS ROAD NORTH, HARROW, ONTARIO, CANADA N0R 1G0

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## TECHNICALLY SPEAKING:

Property	Hocut WS 9003
Appearance	Clear blue liquid
pH @ 5%	9.3
Refractive Index (RI) Factor	Multiply RI by 3.1 for concentration %
Density, lbs./US Gallon	8.5
Specific Gravity	1.02

These are typical figures and do not constitute a specification.

	Recommended Concentration	Refractometer Reading
Grinding	3 – 6%	1.0 – 1.9
Machining	6 – 10%	1.9 – 3.2

### Handling & Safety Information

For information on the safe handling and use of this product, refer to the Material Safety Data Sheet obtainable from Commonwealth Oil Corporation.

### Proper Mixing and Care of Coolants

- ◆ Always pre-mix before adding it to the machine.
- ◆ If mixing by hand, always **add the coolant concentrate** to water, and then agitate.
- ◆ For best results a proportioner should be used.
- ◆ Since water evaporates from the coolant, the concentration will increase over time. To maintain the recommended concentration, makeup coolant should be pre-mixed at half the % concentration as the initial refill.
- ◆ Protect product from freezing.



### The Effects of Water Quality on Emulsion Stability

To obtain the best performance from any water miscible metalworking fluid, good quality water is essential. Water hardness is a key determinate of water quality. It is typically measured in parts per million (PPM) of calcium carbonate and varies by region of the country. The ideal water hardness range is between 75 PPM and 175 PPM. For soft water (less than 75 PPM), the metalworking fluid may foam. Exceptionally hard water (above 200 PPM) can have a de-stabilizing effect on the coolant. For high water hardness, we recommend using a hard water version of our coolant. In addition to water hardness, high levels of chloride ions can adversely affect the rusting inhibiting characteristic of the coolant. Our lab can help you determine the quality of your water.

## Available in Pails, Drums and One-Way Bulk Containers

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