

METAL WORKING FLUIDS AND LUBRICANTS



sutton[®]

SUPERIOR SINCE 1917

At Sutton Tools Pty. Ltd., we are proud to partner with Quaker Houghton – a global leader in industrial process fluids – to bring world-class metalworking solutions to the Australian manufacturing industry.

For over 100 years, Sutton Tools has been at the forefront of cutting tool innovation, supporting Australian manufacturers with precision tooling and technical expertise. Our collaboration with Quaker Houghton represents a natural extension of our commitment to quality, performance, and customer-centric solutions.

Quaker Houghton's advanced metalworking fluids are trusted by industry leaders around the world for their ability to enhance machining performance, extend tool life, and improve workplace safety and environmental outcomes. Their comprehensive portfolio of cutting-edge fluids is backed by rigorous research, deep industry knowledge, and a global support network - available locally through Sutton Tools.

This brochure provides a selection of Quaker Houghton's metalworking fluid range, selected specifically to meet the evolving demands of Australian industry. Whether you're machining high-performance alloys or managing complex production environments, we are confident you will find a solution that delivers measurable value.

We look forward to helping you optimise your operations with products that are not only high-performing, but also supported by local expertise and global innovation.

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HOCUT® 4260

WATER SOLUBLE METALWORKING FLUID

HOCUT® 4260 is advanced, heavy duty, boron-free and formaldehyde-free emulsion technology giving very long sump-life.

A special additive package greatly enhances machining performance and extends tool life compared to conventional products. HOCUT® 4260 is effective when machining aerospace aluminum or fiber composite airframe structural components as well as engine components made of Titanium alloys or Inconel.

Applications

HOCUT® 4260 is an advanced, high lubricity metal removal fluid specially formulated for machining and grinding of a wide range of materials including aerospace aluminum alloys, high-alloy steels, stainless steel, composite materials, titanium and other high temperature alloys for engine parts. In doing so, a proprietary lubricant package reduces tool wear in difficult to machine alloys.

In machining and grinding operations where low foam is a required, HOCUT® 4260 successfully resists foaming in a wide range of water hardness. The EHS profile represents the elimination of boron and other undesirable chemical components. The high biostability of HOCUT® 4260 eliminates the need for regular tankside biocide additions where that is desired.

Recommendation for Use

Heavy duty machining 8 to 10%

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.

Sutton Product Code	Description
QUHOC4260DL	HOCUT® 4260, 205LT. DRUM

Benefits

- Versatile : facilitates machining of fiber composites, aero aluminum alloys, ferrous alloys, stainless steel, titanium and other high heat aerospace materials
- High detergency: leaves parts and working environment clean
- Extended tool life : anti-wear additive package minimizes tool wear, saving tooling costs
- Very long sump-life: new HOCUT® 4000 series emulsion technology extends coolant life minimising waste disposal and direct labor
- Inhibits aluminum staining: can be used for sensitive alloys e.g. 7000 series
- Very low foaming: ideal for the highest speeds and pressures in soft to hard water
- Favorable EHS profile: Free from boron, formaldehyde, chlorine, secondary amine, and phenol

Properties	Typical Value	Unit
Appearance	Pale yellow liquid	
Density	0.99 8.3	g/cc lbs/gal
Refractometer Factor	1.6	
Typical pH in use	9.0	

Approvals

HOCUT® 4260 holds the following approvals and conformities:

- Airbus AIMS 12-10-0000 and 80T-30-4010 : ASTM F483 ; ASTM F1110; Table A7.1
- Airbus AIPI 01-02-003 : Aluminium Elementary Parts NCF1378
- Airbus AIPI 03-11-001 : Conforms to the requirements
- Boeing BAC 5008 cat. 5 & 6 (independent lab testing): conforms
- Bombardier BAMS 569-001: Class A, C, D: approved
- Dassault: approved
- SAFRAN Aircraft Engines: PR 6300 approved on all materials
- Messier Dowty (SAFRAN Equipment): approved PCS4001/PCS4002

HOCUT® 795 B-EU

WATER MISCIBLE METALWORKING FLUID

HOCUT® 795 B-EU is advanced, high lubricity, boron and formaldehyde-free emulsion technology giving ultra-long sump-life and enhanced machining performance compared to conventional products.

HOCUT® 795 B-EU is part of the HOCUT® 795 B product range, one of the world's best selling and multi-approved aerospace sector coolants.

HOCUT® 795 B-EU is approved by Rolls Royce, BAE Systems, SNECMA, Messier Dowty and VIAM.

Other HOCUT® 795 B range approvals include Boeing, Bombardier, NASA, Goodrich and United Engines. A full list of aerospace approved products is available on request.

Applications

HOCUT® 795 B-EU is recommended for difficult machining of all aerospace materials including sensitive aluminium alloys, titanium, inconel, and high alloy steels.

The high lubricity emulsion contains a sophisticated additive package which provides outstanding machining characteristics with extended tool-life.

The formula is also non-staining to sensitive aluminium alloys especially for components with long cycle times.

Ultra long-life makes the product 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 product is designed primarily for soft water.

Recommendation for Use

Medium duty machining 5-7%

Heavy duty machining 8-10%

Heavy duty grinding 6-10%

Health, Safety and Handling

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Benefits

- High lubricity : sophisticated package of mineral oil and polar additives extend tool-life
- Ultra long sump life : Special '795' technology extends intervals between clean outs
- Very stable emulsion : fewer additive treatments and lower usage costs
- Boron-free : no SVHC classification under REACH Prevents staining of aluminium during long cycle times : higher quality parts with fewer rejects
- Very low foaming : ideal for the highest speeds and pressures in soft water
- Boron, formaldehyde, chlorine and phenol-free. Contains only TRGS611 approved amines : excellent EHS profile

Properties	Typical Value	Unit
Concentrate Appearance	Hazy amber oil	
Specific Gravity @20°C	0.94	DIN 51757
Refractometer Factor	1.1	HIM 53
Emulsion Appearance	Opalescent	
pH @6%	8.7-9.2	DIN 51369

Sutton Product Code	Description
QUHOC795BEUDL	HOCUT® 795 B-EU, 205LT. DRUM
QUHOC795BEUPC	HOCUT® 795 B-EU, 20LT. PAIL

HOCUT® 795 MPB

HIGH PERFORMANCE, CLEAN, BIO-RESISTANT MACHINING & GRINDING COOLANT

Houghton's international research and development team have produced a totally new high technology machining and grinding coolant: HOCUT® 795 MPB. HOCUT® 795 MPB provides excellent heavy duty, clean running machining performance on both ferrous and non-ferrous metals without the use of chlorinated or sulphurised compounds. It has unique resistance to bacteria and fungal growth that is achieved without the use of traditional biocides.

Applications

HOCUT® 795 MPB is a versatile, high oil, semi-synthetic metal removal fluid for medium to heavy duty machining and grinding of ferrous and nonferrous metals. HOCUT® 795 MPB is targeted for automotive applications especially for machining cast iron and powdered metal parts without forming sticky residues common with these materials.

HOCUT® 795 MPB is non-staining of automotive grade cast aluminum alloys including 308, 319, 356, 380, 384, and 390. Low foaming characteristics make HOCUT® 795 MPB an excellent choice for high pressure applications.

Recommendation for Use

The recommended usage concentration of HOCUT® 795 MPB for Machining is from 20:1 (5%) to 10:1 (10%) and for Grinding is from 33:1 (3%) to 20:1 (5%).

Quaker Houghton strongly advises that you contact your Sales Representative to discuss before commencement of use.

Health, Safety and Handling

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Benefits

- Excellent biostability for long sump-life, reduced purchase and waste treatment costs
- Excellent corrosion protection for in process protection of machinery and parts.
- Excellent machining capabilities for increased tool life; improves surface finish.
- Enhanced lubricity provides extended tool life and reduces tooling cost.
- Provides improved part finish which reduces overall cost through reduced rework and scrap rates
- Biostable formulation extends sump life indefinitely, reducing waste treatment and recharge costs.
- Allows grinding wheels to run clean with less loading which saves money by extending time between wheel dressing and wheel changes.

Properties	Typical Value	Unit
Appearance (neat)	Clear blue liquid	Visual
Specific Gravity	0.966	[ASTM D4052]
Appearance (diluted)	Translucent blue emulsion	Visual
pH @5%	9.6	[ASTM E 70]
Brix factor	1.3	
Viscosity, Kinematic @40°C	30	cSt [ASTM D 445]

Sutton Product Code	Description
QUHOC795MPBDL	HOCUT® 795 MPB, 205LT. DRUM
QUHOC795MPBPC	HOCUT® 795 MPB, 20LT. PAIL

HOCUT® 795 MP-AU

HIGH PERFORMANCE, CLEAN, BIO-RESISTANT MACHINING & GRINDING COOLANT

Houghton's international research and development team have produced a totally new high technology machining and grinding coolant: HOCUT® 795 MP-AU. HOCUT® 795 MP-AU provides excellent heavy duty, clean running machining performance on both ferrous and non-ferrous metals without the use of chlorinated or sulphurised compounds. It has unique resistance to bacteria and fungal growth that is achieved without the use of traditional biocides.

Applications

HOCUT® 795 MP-AU is a versatile, high oil, semi-synthetic metal removal fluid for medium to heavy duty machining and grinding of ferrous and nonferrous metals. HOCUT® 795 MP-AU is targeted for automotive applications especially for machining cast iron and powdered metal parts without forming sticky residues common with these materials. HOCUT® 795MP-AU is non-staining of automotive grade cast aluminum alloys including 308, 319, 356, 380, 384, and 390. Low foaming characteristics make HOCUT® 795 MP-AU an excellent choice for high pressure applications.

Recommendation for Use

The recommended usage concentration of HOCUT® 795 MP-AU for Machining is from 20:1 (5%) to 10:1 (10%) and for Grinding is from 33:1 (3%) to 20:1 (5%).

Quaker Houghton strongly advises that you contact your Sales Representative to discuss before commencement of use.

Health, Safety and Handling

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Benefits

- Excellent biostability for long sump-life, reduced purchase and waste treatment costs
- Excellent corrosion protection for in process protection of machinery and parts.
- Excellent machining capabilities for increased tool life; improves surface finish.
- Enhanced lubricity provides extended tool life and reduces tooling cost.
- Provides improved part finish which reduces overall cost through reduced rework and scrap rates
- Biostable formulation extends sump life indefinitely, reducing waste treatment and recharge costs.
- Allows grinding wheels to run clean with less loading which saves money by extending time between wheel dressing and wheel changes.

Properties	Typical Value	Unit
Appearance (neat)	Clear amber liquid	Visual
Specific Gravity	0.95	[ASTM D4052]
Appearance (diluted)	Translucent white emulsion	Visual
pH @5%	9.6	[ASTM E 70]
Brix factor	1.3	
Viscosity, Kinematic @40°C	20.6	cSt [ASTM D 445]

Sutton Product Code	Description
QUHOC795MPAUDL	HOCUT® 795 MP-AU, 205LT. DRUM

HOCUT™ 5630

OPERATOR FRIENDLY SYNTHETIC METALWORKING FLUID

HOCUT™ 5630 is a fully synthetic machining and grinding fluid with state of art technology. Its excellent lubricity provide great performance for Aluminium machining. It also can be used for difficult materials general machining. The mineral oil-free solution provides great cleanability and excellent tramp oil rejection.

Applications

HOCUT™ 5630 suitable for aluminium, medium to low carbon steel, stainless steel and high temperature steel alloy grinding. It's also used in machining process for Al 319, 380, 390, LY12, etc. auto aluminium and aerospace plus electronics Al alloy such as 6061, 6063, 7075. HOCUT™ 5630 can also used for other materials, like copper, Ti alloys for turning, milling, drilling, tapping with good lubricity, cooling and detergency.

Recommendation for Use

HOCUT™ 5630 recommend operation concentration

Grinding: 3 - 7%

Machining Al and difficult materials: 6 - 12%

Health, Safety and Handling

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Benefits

- Suitable to be used for difficult machining materials thanks to its unique lubricity
- Low foam; no need for antifoam even running at high speed and high flow machining
- Can be used for multi-material and different process, which help reduce your SKU
- Very quick and complete tramp oil rejection help ensure excellent detergency on parts and machines without oil mist.
- Low pH helps provide aluminium protection and is friendly to operators

Properties	Typical Value	Unit
Appearance (neat)	Clear yellow liquid	Visual
Specific Gravity	1.07	[ASTM D4052]
Appearance (diluted)	Translucent liquid	Visual
pH @8%	7.95	[ASTM E 70]
Brix factor	1.7	

Sutton Product Code	Description
QUHOC5630DL	HOCUT® 5630, 205LT. DRUM
QUHOC5630PC	HOCUT® 5630, 20LT. PAIL

QUAKERCOOL™ 590 HM

SEMI-SYNTHETIC METALWORKING FLUID

QUAKERCOOL™ 590 HM is a semi-synthetic metal working fluid that combines synthetic polar lubricants, high performance corrosion protective agents and other additives. The product is specifically designed for machining of ferrous and non ferrous materials and is suitable for brass and copper-containing alloys.

Applications

QUAKERCOOL™ 590 HM is a high-performance semi-synthetic metalworking fluid designed for medium to heavy-duty machining operations.

Typical applications include-CNC Machining (Turning, Milling, Drilling), Tapping and Threading, Boring and Reaming in Aerospace, Automotive and General Engineering.

Suitable for materials- Mild and Alloy Steels, Stainless Steels, Aluminium Alloys (good stain resistance), Copper Alloys (low staining formulation).

QUAKERCOOL™ 590 HM mixes well with hard water and emulsions are completely stable.

Recommendation for Use

QUAKERCOOL™ 590 HM should be used in the Concentration range: 4-8 %.

Health, Safety and Handling

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Benefits

- Good cooling capacity
- Good bioresistance.
- Very stable emulsion.
- Excellent filterability.
- Very fast tramp oil rejection properties.
- Very good foam control
- Imparts smooth finish and improved tool life when machining aluminium and stainless steel.
- Clean-running: reduces residue and sticky deposits
- Operator and machine-friendly

Properties	Typical Value	Unit
Appearance (neat)	Amber liquid	Visual
Specific Gravity	0.944	[ASTM D4052]
Appearance (diluted)	White opaque emulsion	5%v/v
pH @5%	8.7	[ASTM E 70]
Brix factor	1.45	

Sutton Product Code	Description
QUQ590HMDL	QUAKER® 590 HM, 205LT. DRUM
QUQ590HMPC	QUAKER® 590 HM, 20LT. PAIL

QUAKER 3755 BIO

BIOSTATIC SEMI-SYNTHETIC MACHINING AND GRINDING FLUID

QUAKER 3755 BIO is a versatile, general purpose, semi-synthetic, machining and grinding fluid. It is suitable for use on a wide range of metal removal operations for both ferrous and aluminium alloys. QUAKER 3755 BIO Enhanced lubrication allows the product to provide superior micro finish on high alloyed steel and aluminium, while offering the versatility to handle heavy-duty application on typical ferrous alloys as well.

Applications

QUAKER 3755 BIO low foaming micro emulsion resists air entrapment. This decreases the risk of pump cavitation and ensures the fluid's lubricating and cooling properties are delivered to the work zone. This prevents premature pump wear, improves quality and productivity. Machines are kept cleaner due to the excellent detergency of the product. It has good fines handling properties and does not produce sticky residues. This results in better visibility and working conditions. Grinding wheels remain clean and free cutting. Biostatic approach handles microbiological growth without biocide additions. And contributes to insuring the products corrosion protection is sustained.

Recommendation for Use

QUAKER 3755 BIO is suitable for machining & grinding operations on cast iron, steel alloys.

Concentration range:

- Machining 4-8%
- Grinding 3-5%

Health, Safety and Handling

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Benefits

- Provides stable lubrication for high quality surface finish.
- Excellent corrosion protection for the machined parts, DIN chip <3%.
- Leaves no sticky residues on the workpiece.
- Biostatic.
- Triazine free.
- Contains no Phosphorous, Sulphur or Chlorine.
- Low environmental impact, meets WGK class 1

Properties	Typical Value	Unit
Appearance (neat)	Clear amber fluid	Visual
Specific Gravity	0.98	[ASTM D4052]
Appearance (diluted)	Milky emulsion	5%v/v
pH @5%	9.5	[ASTM E 70]
Brix factor	1.1	
Total Alkalinity	112	mgKOH/g

Sutton Product Code	Description
QUQ3755BIODL	QUAKER® 3755 BIO, 205LT. DRUM
QUQ3755BIOPC	QUAKER® 3755 BIO, 20LT. PAIL

HOCUT® 787 B-AU

HEAVY DUTY BIO-RESISTANT MACHINING AND GRINDING FLUID

HOCUT® 787 B-AU is the latest addition to the line of new technology Bio-resistant machining and grinding coolants exclusive to Houghton. HOCUT® 787 B-AU combines the unique bio-resistance and lubricity of the Hocut 700 series with heavy duty extreme pressure performance providing one coolant capable of working in many applications on a wide variety of metals. Its versatility is demonstrated by the machines and metals on which it can be used. These include Kingsburys, Bullards, bar machines, lathes, chucks, centreless and cylindrical grinders and the latest high pressure CNC machining centres. 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 and alloys such as 356- T6, 368, 380 and 390 cast aluminum

Applications

HOCUT® 787 B-AU is compatible with hard water, is clean running and uniquely bio-resistant which assures long, odor-free sump life unobtainable with traditional bio-stable and other water soluble fluids. HOCUT® 787 B-AU provides corrosion protection without staining and affords excellent lubrication for machine ways and indexing mechanisms. Low foaming characteristics make HOCUT® 787 B-AU ideal for high speed CNC machines and high pressure coolant systems.

Recommendation for Use

The recommended usage concentration of HOCUT® 787 B-au for Machining is from 14:1 (7%) to 7:1 (15%) and for Grinding is from 33:1 (3%) to 20:1 (5%). This may be customised to suit individual needs or solutions, which may vary from time to time. Quaker Houghton strongly advises that you contact your Sales Representative to discuss before commencement of use.

Benefits

- Clean running
- Reduced disposal cost/less down time
- Excellent corrosion protection
- Excellent machining capabilities
- In process protection of machinery and parts
- Increased tool life and improved surface finish

Health, Safety and Handling

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Properties	Typical Value	Unit
Appearance (neat)	Clear amber liquid	Visual
Specific Gravity	1.030	[ASTM D4052]
Appearance (diluted)	Translucent white emulsion	Visual
pH @5%	9.1	[ASTM E 70]
Brix factor	1.00	
Viscosity, Kinematic @40°C	20.6	cSt [ASTM D 445]

Sutton Product Code	Description
QUHO787BAUDL	QUAKER® 787B-AU, 205LT. DRUM
QUHO787BAUPC	QUAKER® 787B-AU, 20LT. PAIL

HOUGHTO-GRIND® 60

SYNTHETIC GRINDING COOLANT

HOUGHTO-GRIND® 60 is a synthetic chemical grinding fluid formulated to give maximum rust protection, no foam, no petroleum oil and using surface active compounds to keep the wheel clean. It is used by diluting with water, forming a greenish transparent solution.

HOUGHTO-GRIND® 60 minimises any tendency to emulsify tramp oils. A layer of oil can be separated from the working solution by skimming off the surface and when coolant is spent, solutions are easily disposed of by simple checks before discarding to sewer. The solutions in use are hard water stable and provide long sump life, with excellent rust resistance. Low foam properties are also experienced.

Applications

HOUGHTO-GRIND® 60 is mixed with water and applied to the grinding application. With no oil present, oil misting is eliminated and disposal problems common with soluble oils are eliminated. The transparent solution stays transparent to translucent in use allowing operators to see close tolerance surface grinding.

Recommendation for Use

HOUGHTO-GRIND® 60 is mixed with water: Grinding: 3 - 5%.

HOUGHTO-GRIND® 60 solutions are most easily checked using a pocket refractometer. Multiply the refractometer reading, taken at room temperature by factor 2.1 to obtain product concentration.

Health, Safety and Handling

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Benefits

- Superior rust protection
- Won't foam
- Nitrite free
- Diluted with water in use
- Clear solution in use - long sump life
- Petroleum oil free

Properties	Typical Value	Unit
Appearance (neat)	Slightly hazy fluorescent green liquid	Visual
Specific Gravity	1.09	[ASTM D4052]
Appearance (diluted)	Clear greenish solution	3%v/v
pH @100%	10.4	[ASTM E 70]
Brix factor	2.1	

Sutton Product Code	Description
QUHOGRIND60DL	HOUGHTO-GRIND® 60, 205LT. DRUM
QUHOGRIND60PC	HOUGHTO-GRIND® 60, 20LT. PAIL

CUT-MAX® 570

GIVES NICKEL ALLOYS BETTER FINISH, MAKES MACHINING FASTER, EASIER

Base oils for CUT-MAX® 570 are highly selected premium grade refined stocks. The organic diluent and carrier for the chlorine has exceptional wetting and penetrating characteristics to insure an effective flow of the coolant to the chip-tool interface.

CUT-MAX® 570 has a high chlorine content that is stable, effective and provides needed anti-welding and extreme pressure characteristics. Other Additives are compounded into the base to give excellent machining characteristics at all cutting speeds, and under heavy-duty conditions. In addition, a special anti-mist additive has been incorporated in CUT-MAX® 570 to help you meet the 5 mg/m3 limitation on oil mist that OSHA imposes

Benefits

- Faster cutting of difficult alloys - Reduces cycle times and process costs
- More production, longer tool life
- Enhanced lubricity provides extended tool life and reduces tooling cost.
- Provides improved part finish which reduces overall cost through reduced rework and scrap rates

Applications

CUT-MAX® 570 is excellent on broaching and other difficult operations on steel and steel alloys.

CUT-MAX® 5001AM

LOW VISCOSITY NEAT CUTTING OIL

CUT-MAX® 5001AM is a low viscosity neat cutting oil formulated with extreme pressure and anti-mist additives.

The extreme pressure properties of CUT-MAX® 5001AM provide excellent tool life and surface finish on a wide variety of metals and applications. The low odour and anti-mist properties of CUT-MAX® 5001AM provides improved conditions for machine operators.

CUT-MAX® 5001AM is widely used in repetition engineering shops and suitable for use in all CNC and multi-spindle machines. CUT-MAX® 5001AM is used neat in all types of applications.

Benefits

- High Flash Point
- Non-Staining
- Low Odour
- Light coloured
- Low Viscosity
- Good flushing action
- Pleasant to use
- Ideal for rationalisation

Health, Safety and Handling

Refer to SDS for proper handling and disposal. Please note that the SDS includes handling, health and disposal information which should be passed on to your employees, and to anyone else who comes in contact with our product. Additional advice can also be obtained from your local Quaker Houghton representative.

NOTE: Read and understand all precautions on container labels before using this product.

Properties	5001AM	570
Appearance	Clear Amber Fluid	Clear Dark Red Fluid
Viscosity cSt @ 40°C	25	42
Flash Point °C	>150	182
Density @ 15°C	0.87 kg/L	
Specific Gravity	1.00	

Sutton Product Code	Description
QUCUTMAX570PC	CUT-MAX® 570, 20LT. PAIL
QUCUTMAX570DL	CUT-MAX® 570, 205LT. DRUM
QUCUT5001AMPC	CUT-MAX® 5001AM, 20LT. PAIL
QUCUT5001AMD	CUT-MAX® 5001AM, 205LT. DRUM

CUT-MAX® 226S

STRAIGHT CUTTING OIL

CUTMAX® 226S is a heavy duty straight cutting oil fortified with sulphur, chlorine and extreme pressure additives. This highly compounded oil gives excellent lubricity and efficient anti-weld, as well as high chemical activity, giving excellent machining characteristics at all cutting speeds, and under heavy duty conditions.

Applications

Use CUT-MAX® 226S as received for heavy duty applications.

Can be diluted with low viscosity oil for lighter operations.

CUT-MAX® 226S is suited for medium and difficult machining of ferrous metals, heavy duty automotive machining, milling, broaching, gear cutting, hobbing and cold heading.

Benefits

- Low Viscosity
- Medium to heavy duty machining
- Suitable for a wide range of materials
- Long tool life
- Light coloured, Low odour

CUT-MAX® 206S

STRAIGHT CUTTING OIL

CUTMAX® 206S is fortified with sulphur and chlorinated wax type extreme pressure agents, blended into highly refined petroleum oil to give excellent surface finish to machined components. The sulphurised additive is especially formulated to remain completely soluble in the petroleum oil base and coupled with the chlorinated wax and low fluid viscosity, provides good coolant flow, prolonging cutting tool life.

CUTMAX® 206S is used for medium and difficult machining of ferrous metals - heavy duty automatic machining, milling, broaching, gear cutting, hobbing, forming cold heading and is ideal also as a coolant for gun grilling.

Health, Safety and Handling

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NOTE: Read and understand all precautions on container labels before using this product.

Benefits

- Heavy duty machining and forming ferrous metals
- Fortified with extreme pressure additives
- Excellent tool life and surface finish

Properties	206S	226S
Appearance	Clear Dark Brown Fluid	Clear Amber Fluid
Viscosity cSt @ 40°C	13.5	30
Density @ 15°C	0.88 kg/L	0.89 kg/L

Sutton Product Code	Description
QUCUTMAX206SPC	CUT-MAX® 206S, 20LT. PAIL
QUCUTMAX206SDL	CUT-MAX® 206S, 205LT. DRUM
QUCUTMAX226SPC	CUT-MAX® 226S, 20LT. PAIL
QUCUTMAX226SDL	CUT-MAX® 226S, 205LT. DRUM

CINDOL® 869R

VEGETABLE OIL BASED LUBRICANT

CINDOL® 869R was developed specifically as high performance lubricant for Aluminium machining and forming.

Due to its vegetable oil base, CINDOL® 869R is ideal for use in metal working operations where biodegradability and operator health and safety are of prime importance.

Use as supplied in place of petroleum based fluids. CINDOL® 869R can also be used for forming, machining, drawing and blanking on most ferrous and nonferrous metals. CINDOL® 869R is suitable for application by swab, spray, mist and flood.

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NOTE: Read and understand all precautions on container labels before using this product.

Benefits

- Environmentally friendly
- Biodegradable
- 100% User friendly
- Low odour
- Excellent lubricity
- Cost effective

Property	Typical Value
Appearance	Clear Liquid
Odour	Bland
Density @ 15°C	0.920
Viscosity cSt @40°C	35
Flash Point (Closed Cup)	>200

Sutton Product Code	Description
CINDOL869RPC	CINDOL® 869R, 20LT. PAIL

M800 CUTTING COMPOUND (VENOM)

CUTTING LUBRICANT - FLUID, PASTE AND SPRAY

Venom Endurance+ Cutting Fluid

Venom Endurance+ Cutting Fluid is a highly efficient cutting and lubricating fluid. Formulated to increase tool life and enhance cutting performance in a broad range of metals including carbon steel, aluminium alloys, copper, brass, bronze and stainless steel. Mild clinging action helps fluid adhere to the tool and part when vertical work is required.

Venom Extreme Power Cutting Paste

Formulated for superior tool life and cutting performance in carbon steel, aluminium alloys, copper, bronze, stainless steel, nickel, titanium and other super alloys.

Venom Extreme Power Cutting Paste is a high performance low melting point lubricant specifically designed to adhere to the cutting edges, even when using additional coolants.

Health, Safety and Handling

Refer to SDS for proper handling and disposal. Please note that the SDS includes handling, health and disposal information which should be passed on to your employees, and to anyone else who comes in contact with our product. Additional advice can also be obtained from your local Quaker Houghton representative.

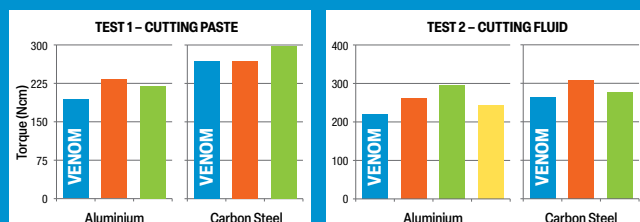
NOTE: Read and understand all precautions on container labels before using this product.

Benefits

- Reduces torque and friction for up to 2X tool life
- Produces extremely high quality surface finish
- Mild clinging action adheres to tool and part when vertical work is required
- Cutting paste has low melting point to adhere to cutting edge for greater tool protection
- Environmentally friendly mineral oil base with 10% organic coconut oil. Free from Trichloroethane
- Low odour

Product Code	Description
M8000050	LUBRICANT M800 VENOM FLUID, 50mL.
M8004000	LUBRICANT M800 VENOM FLUID, 4LT.
M8000250	LUBRICANT M800 VENOM FLUID, 250ML.
M8000400	LUBRICANT M800 VENOM PASTE, 400G.
M8000300	LUBRICANT M800 VENOM AEROSOL, 300G.

Tests indicate Sutton Tools Venom requires less torque – it performed up to 30% better than its competitors



Tests were conducted using a M6 forming tap in Carbon Steel and Aluminium. The results clearly indicate less torque* was required using Sutton Tools Venom Cutting Fluid and Paste compared with leading brands on the market.

*Less torque indicates improved performance.



STA-PUT® 68, STA-PUT® 220

TENACIOUS FLUID LUBRICANTS

STA-PUT® SERIES are specialty lubricants blended from highly refined mineral oils containing oiliness, tackiness and extreme pressure additives.

STA-PUT® SERIES are designed for use as slideway lubricants on machine tools to eliminate or minimise “stick-slip” problems enabling finer adjustment of cutting tool feeds and improved surface finish of the work pieces. STA-PUT® SERIES is ideal too to lubricate air-tools such as rock drills, chippers, reamers, hammers, pavement breakers etc

Applications

- STA-PUT® Series may be applied in numerous ways:
- Rock Drilling Lubricators
- Hand Oiling - Combination splash and force feed systems
- Sight Feed Oilers - Ratchet type mechanical lubricators
- Bath Systems - Wick feed oilers, Mechanical force
- Feed Oilers - Felt oiling pads
- Splash Pans - Multiple wick boxes with long tubes
- Swabs - To convey oil to bearings
- STA-PUT® 220 should not be used for ring-oiled electric motors, generators etc.

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Benefits

- Superior Lubrication - Air Operated Tools
- Slide-way Lubricant - Machine Tools
- EP Agents Added - Minimises “Stick-Slip”
- Tacky Additive for Cohesion and Adhesion
- High Oiliness Factor
- High Film Strength for Greater Shock Loads

STA-PUT Properties	68	220
Viscosity cSt @ 40°C (ASTM D445)	68	220
Viscosity cSt @ 100°C (ASTM D445)	8.8	18.4
Pour Point °C	-21	-12
Density @ 15°C kg/L (ASTM D1298)	0.880	0.90
Flash Point °C	>200	>200

Sutton Product Code	Description
STAPUT68DL	STA-PUT® 68, 205LT. DRUM
STAPUT68PC	STA-PUT® 68, 20LT. PAIL
STAPUT220PC	STA-PUT® 220, 20LT. PAIL

QUANTOL DRIVE 32, 46, 68, 100 & 150

HIGH PERFORMANCE PREMIUM HYDRAULIC OILS

QUANTOL DRIVE Hydraulic Oils 32, 46, 68, 100 & 150 are formulated with high quality neutral oil base and specially chosen additives to give excellent anti-wear performance.

In the high pressure, high temperature Vickers pump test the wear results obtained indicate that these oils have excellent anti-wear properties and therefore the ability to significantly reduce pump wear.

Applications

- Hydraulic systems requiring maximum anti-wear protection.
- Machine shops where water contamination or condensation can cause corrosion in oil based systems.

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NOTE: Read and understand all precautions on container labels before using this product.

Benefits

- Rust protection superior or equivalent to the best premium quality conventional hydraulic oil
- Good water separation
- Excellent oxidation resistance
- Zinc free product

Properties	32	46	68	100	150
Specific Gravity	0.86	0.87	0.87	0.86	0.89
Viscosity cSt @ 40°C	32	46	68	100	150
Pour Point	-18	-15	-12	-10	-10
Flash Point °C	>200	>200	>220	>220	>220

Sutton Product Code	Description
QUDRIVEAW1068PC	QUANTOL DRIVE AW1068, 20LT. PAIL
QUDRIVEAW1068DL	QUANTOL DRIVE AW1068, 205LT. DRUM
QUDRIVEAW1046PC	QUANTOL DRIVE AW1046, 20LT. PAIL
QUDRIVEAW1046DL	QUANTOL DRIVE AW1046, 205LT. DRUM
QUDRIVEAW1032PC	QUANTOL DRIVE AW1032, 20LT. PAIL
QUDRIVEAW1032DL	QUANTOL DRIVE AW1032, 205LT. DRUM

RUST VETO® 377DGHF

RAISES WATER OFF WET METAL TO PREVENT RUST WITH A VERY THIN FILM

RUST VETO® 377DGHF is a Polar-type, water displacing fluid which actually raises water off wet metal to coat the entire metal surface with an economical, long-lasting film. It slides under the most microscopic drops of water to spread a thin film of rust preventive.

RUST VETO® 377DGHF is a real multi-purpose product.

Applications

Use RUST VETO® 377DGHF across the board for indoor protection of critical surfaces or for packaged materials. Examples are hardware, ball bearings, dies, tools, fixtures, gauges, polished steel, phosphatised surfaces and idle or stored machinery.

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NOTE: Read and understand all precautions on container labels before using this product.

Benefits

- Displaces water
- Excellent coverage reduces cost
- Compatible with lubricants
- Easy to remove
- High flash point
- Use with wet metal Metal doesn't need to be completely dry when RUST VETO® 377DGHF is applied
- Economical Fine film and attraction for metal make RUST VETO® 377DGHF "creep" across the metal's surface, spreading over a large area.
- Ideal for bi-metals Can be used safely with many combinations of ferrous or non-ferrous metals and alloys with no reaction.
- Long-lasting film - RUST VETO® 377DGHF has an anti-oxidant additive. It won't break down and corrode metal. Resists oxidation even under long-term storage. Its affinity for metal means the film adheres to the surface, handling won't wipe the film off.
- Withstands 100% humidity @ 40°C for more than 30 days.
- Offers 18-24 months protection indoor (unwrapped)

Properties	Typical Value	Units
Appearance	Light Yellow thin film	220
Film Character	Soft	18.4
Flash Point	90	°C
Density @15°C	0.850	kg/L

Sutton Product Code	Description
QURV377DGHFPC	RUST VETO® 377DGHF, 20LT. PAIL

RUST VETO® 4214HF

WATER DISPLACING RUST PREVENTATIVE

RUST VETO® 4214HF utilizes special polar compounds held up in petroleum solvent, such that wet components to be treated for rust protection can simply be immersed, the moisture is displaced leaving a residual rust preventive film following evaporation of solvent.

RUST VETO® 4214HF is particularly effective where there is alkaline acid or solvent emulsion rinse water left on components to be treated.

RUST VETO® 4214HF releases displaced water at an extremely rapid rate and leaves a very thin, transparent protective film.

RUST VETO® 4214HF is particularly suited to protect ferrous surfaces from rust. It displaces water on parts which have been cleaned in alkaline cleaners such as CERFA KLEEN HST or HPW. After the wash rinse the cleaned parts are dipped in RUST VETO® 4214HF. A thin film deposited will give protection under normal conditions, indoors, for up to 12 months.

Care should be taken to avoid excessive evaporation of solvent by keeping the rust preventive holding vessel covered when not in use

Applications

PROTECTIVE PROPERTIES

- Water Displacement - Meets Government requirements (Spec. MIL-C-16173-D Grade 3)
- Humidity Cabinet (38°C) - 30 Days (minimum)
- RUST VETO® 4214HF is applied by spray, dip or brush
- If a lower flash point product may be acceptable, RUST VETO® 4214 is available (flash point 35°C)
- When the rust preventive film is required to be removed, a simple clean with petroleum solvents such as turps, kerosene by wipe or dipping or by the use of heated alkaline cleaners.

Benefits

- Exceptional stability - even in acid or alkaline conditions
- Extremely fast acting water displacement
- Rapid separation from water
- Good long-term indoor protection
- Transparent film enhances surfaces

Health, Safety and Handling

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NOTE: Read and understand all precautions on container labels before using this product.

Properties	Typical Value	Units
Appearance	Red/Brown thin liquid	
Film Character	Thin, Transparent, Oily	
Flash Point	66	°C
Density @15°C	0.850	kg/L
Water Separation	Very Rapid	
Removability	Remove with petroleum solvents	

Sutton Product Code	Description
QURV4214HFPC	RUST VETO® 4214HF, 20LT. PAIL

MACHINE TOOL CLEANER-AU

FAST SOLVENT DETERGENT ACTION CLEANER

MACHINE TOOL CLEANER-AU is a powerful, effective cleaner for machine tools and central coolant systems. Mix it with water for use. This makes a quick acting solvent-detergent solution that removes grease and gummy deposits from machine surfaces. It also purges caked residue and scum from coolant sumps, lines and fittings. Use it to clean return trenches and main reservoirs in central coolant systems

Applications

Five simple steps to clean your machine:

- Dump old fluid from your system.
Add enough fresh water for thorough circulation.
- Add 3 - 6 litres MACHINE TOOL CLEANER-AU per 100Lt. of water in sump. Quantity required depends on the condition of the equipment.
- Circulate solution for one to two hours, or until all deposits are loosened.
Make sure that all surfaces to be cleaned are reached by the solution. For caked deposits use high pressure flow to loosen. Residual deposits may trap live bacteria that will re-infect the system so clean thoroughly.
- Drain – flush with fresh water.
- Add fresh coolant to the machine system.

For optimum effectiveness – add 0.5 – 1Lt. MACHINE TOOL CLEANER-AU per 100 litres to the system 24 hours before the final cleaning above.

Benefits

- Water based - non-flammable
- Cleans grease dirt from machine surfaces
- Ideal cleaner - central coolant systems
- Cleans scum from machine sumps

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NOTE: Read and understand all precautions on container labels before using this product.

Properties	Typical Value
Appearance	Clear amber liquid
pH @ 2%	9.8
Flash Point °C	Not Applicable
Density @15°C	1.00

Sutton Product Code	Description
QHMACTCAU-PC	MACHINE TOOL CLEANER, 20LT. PAIL

COOLANT TEST CASE

COOLANT MAINTENANCE TO TRGS 611 STANDARD

The Hoffman Group Coolant Test Kit provides an efficient in-house solution to monitoring coolant quality, featuring 100 test strips designed to measure nitrite, nitrate, total hardness, and pH levels.

It also includes empty spray bottles (3 pcs.), measuring jug for taking samples, thermometer and a summary of the Technical Rules for Hazardous Substances, TRGS 611.

Hoffmann Group offer replacement strips for each of the tests offered, please refer to the Sutton Product Code Order table.



Sutton Product Code	Description
HF084310	HOFFMANN COOLANT TEST CASE (COMPLETE)
HF084311	HOFFMANN NITRITE TEST STRIPS (100 PCS.)
HF084312	HOFFMANN NITRATE TEST STRIPS (100 PCS.)
HF084313	HOFFMANN HARDNESS TEST STRIPS (100 PCS.)
HF084314	HOFFMANN PH TEST STRIPS (100 PCS.)
HF084315	HOFFMANN PH-NITRITE TEST STRIPS (100 PCS.)

PORTABLE REFRACTOMETER (ANALOG)

PERFORM FAST, ACCURATE COOLANT CONCENTRATION CHECKS

The Hoffmann Group Analog Portable Refractometer is designed for precise measurement of emulsion concentrations within a 0–32% range, optimized for use with water-miscible cooling lubricants (WSO).

Supplied with a protective carry bag, pipette and operating instructions.



Sutton Product Code	Description
HF084320ANALOG	PORTABLE REFRACTOMETER, ANALOG

MIXER FOR COOLING LUBRICANT EMULSION

UNIVERSAL FITMENT FOR DRUMS AND PAILS

The Hoffmann Group Mixer is equipped with a Universal Screw Fastening Set making it compatible with all standard commercial drums and pails. A precision needle valve enables accurate adjustment of the mixing ratio, ensuring high repeatability with flow rates up to 370 liters per hour.

The system is supplied with an outlet hose and concentrate suction tube for universal fitment to drums and pails.

The mixer is manufactured with 1/2" water inlet and integrated safety non-return valve, a 1/2" outlet for mixed product, and a 3/8" connection for the concentrate.



Sutton Product Code	Description
HF084370	VENTURI MIXER FOR WATER SOLUBLE OIL



DOSATRON PUMP EMULSIFIER

INTEGRATED PUMP OFFERING PRECISE DOSING

The Dosatron pump (D3IL10VF) is integrated into the water circuit and utilises the pressure and flow of the water as its sole source of power. Driven in this manner, the Dosatron can dose various types of additives directly into the metal working fluid supply to one or several conventional or CNC machines. The precision and reliability of the Dosatron pump eliminates any risk of errors in the dosing and preparation of products such as mixtures and solutions. It is not affected by the inherent variations of a fluid (pressure, flow rate, temperature, inlet height and viscosity).

Constant attention to quality at all stages of the pump's manufacture, both in terms of the materials used, testing and inspection procedures applied, ensures an optimum response to the needs of metalworking machine tool users.



Technical Specifications	D3IL10VF
Operating flow rate	10l/h MINIMUM - 3m³/h MAXIMUM
Max. operating temperature	40°C
Operating water pressure	0.5 - 6 BAR
Dosing percentage range	1% - 10%
Connection	3/4" MALE BSP/NPT

Sutton Product Code	Description
QUD3IL10VF	DOSATRON, D3IL10VF PUMP

COMPREHENSIVE FLUID ANALYSIS AND MONITORING

As part of our commitment to providing end-to-end support, Quaker Houghton delivers comprehensive metalworking fluid analysis through Sutton Tools to help maintain optimal performance and extend fluid life.

Their expert technical team assists in identifying issues such as tramp oil contamination, bacterial or fungal growth, and pH imbalances—factors that can significantly affect machining efficiency, tool life, and operator safety.

By regularly monitoring these parameters, Quaker Houghton helps you maintain cleaner systems, reduce downtime, and ensure consistent product quality. This proactive approach to fluid management, delivered in collaboration with Sutton Tools, is just one of the ways we support our clients in achieving reliable, high-performance manufacturing outcomes.

Regular fluid testing helps detect issues such as:

- Tramp oil
- Microbial contamination
- pH imbalance—factors that can impact machining performance and safety.

Early identification of these issues helps:

- Reduce downtime
- Extend fluid life
- Maintain consistent product quality.

To begin monitoring your fluids, contact Sutton Tools to request a complimentary fluid sample bottle.

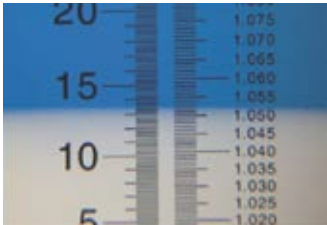


Sutton Product Code	Description
499970209	FLUID SAMPLE BOTTLE WITH MAIL CAN

Need help getting started? Sutton Tools also offers training on how to check your metalworking fluids and take accurate fluid samples.

Their expert team can guide your staff through simple, effective procedures to monitor fluid condition, and recognize early warning signs.

Contact Sutton Tools today to arrange on-site or remote training tailored to your team’s needs and operational goals.



As part of the fluid monitoring service, Sutton Tools provides a detailed Coolant Report for each sample submitted.

This report documents the current condition of the coolant—including key parameters such as concentration, pH, microbial activity, and contamination levels—offering a clear snapshot of system health. It also includes expert recommended actions to help you maintain optimal fluid performance, address emerging issues, and extend coolant life. These insights enable data-driven decisions that support efficient, reliable machining operations.

Together with Sutton Tools, we’re committed to helping you achieve cleaner systems, longer tool life, and more reliable manufacturing results.



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brochure



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