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ISO-21469 Compliant.

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PRODUCT DATA

LUBRIPLATE CUT-N-COOL

HEAVY-DUTY WATER SOLUBLE CUTTING AND GRINDING FLUID

DESCRIPTION

LUBRIPLATE CUT-N-COOL combines the machining efficiency of a cutting oil with the cooling ability of water all in one product. LUBRIPLATE CUT-N-COOL is a heavy duty water extendable sulfur-chlorinated metalworking coolant formulated to offer outstanding performance in difficult machining and grinding operations involving hard-to-work metals such as stainless steel, tool steels and high nickel alloys. LUBRIPLATE CUT-N-COOL may be used on all metals except magnesium, copper and some bronze alloys, which may be stained.

ADVANTAGES

- ⇒ Used to replace Straight Oils in most operations.
- ⇒ Increases Tool Life
- ⇒ Excellent Corrosion Inhibition
- ⇒ Excellent Finish in Machining and Grinding Operations
- ⇒ Better Cooling than Oils
- ⇒ More Economical than Straight Oil

APPLICATIONS

LUBRIPLATE CUT-N-COOL is suited for all types of machining processes including turning, milling, tapping, reaming, broaching, hobbing, and sawing. This product also works well in the various grinding processes, including centerless, cylindrical, surface, internal, belt and disc.

LUBRIPLATE CUT-N-COOL will perform as well as straight oil in most applications

RECOMMENDED STARTING DILUTIONS

Centerless, ID, OD, Surface Grinding	33:1 (3%)
Milling, Drilling, Turning	20:1 (5%)
Tapping, Reaming, Sawing	10:1 (10%)

When mixing coolant, it is best to use an automatic proportioner which accurately and thoroughly mixes coolant. Always replenish the coolant with a mixture of coolant and water, not just coolant or water. Never add coolant concentrate directly to the sump.



TYPICAL TEST DATA

PROPERTY	TEST METHOD	TYPICAL RESULTS*
Appearance	Visual	Dark Brown Liquid
Residual Film	Visual	Soft, Fluid
pH @ 20:1 (5%)		9.3 ± 0.3
API Gravity	ASTM D-287	14.3
Lbs./Gallon		8.1 ± 0.1
Sulphur		1 - 2
Chlorine		4 - 5
Flash Point - COC	ASTM D-92	320°F/160°C

CONCENTRATION

Concentration	3% (1:33)	4% (1:25)	5% (1:20)	6% (1:17)
Refractometer Reading	3.6	4.8	6.0	7.2
Concentration	7% (1:14)	8% (1:12)	9% (1:11)	10% (1:10)
Refractometer Reading	8.4	9.6	10.8	12.0

(An optical refractometer may be used for determining concentration)

STORAGE

Store product at ambient/room temperature.

PACKAGING AVAILABLE

Carton 4/1 Gallon Jugs
5 Gallon Pail
55 Gallon Drum

Part No.

L0514-057
L0514-060
L0514-062