

LUBRICUT 4265

METALWORKING FLUID

▷ PRODUCT DESCRIPTION

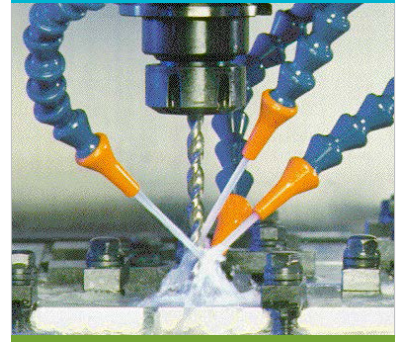
Lubricut 4265 is an optimum balance of lubricity and detergency for both machine cleanliness and high quality finishes on machined parts. Lubricut 4265 has a unique blend of polymeric lubricants and extreme pressure additives for optimum performance on difficult operations. A special corrosion inhibitor package gives excellent protection against rust and corrosion of grey iron, cast iron, and steel. Lubricut 4265 is stable in both hard and soft water and will not foam. Lubricut 4265 comes packaged as a highly concentrated form.

Lubricut 4265 does not leave a sticky or tacky residue on machined parts. The residue is very oillike and will not gum up ways or stick switches. Lubricut 4265 rejects most tramp oils which may be easily removed with an oil skimmer. Lubricut 4265 is a premium, cost effective metalworking fluid designed to reduce consumption, improve tool life, performance, and finishes.

▷ FEATURED BENEFITS

- Runs clean
- Low consumption
- Synthetic polymeric lubricant
- Non-tacky residues
- Economical to use
- Environmentally safe (no nitrites, phenols, DEA, or petroleum oils)
- Longer sump life
- Non-foaming
- Improved tool and wheel life
- Improved surface finishes
- Rejects tramp oil
- Excellent rust protection

APPLICATION



COMPATIBLE METALS

Cast Iron
Carbon Steel
Tool Steel
Stainless Steel
Aluminum
Titanium
Inconel
Bronze
Copper
Brass

MACHINING CAPABILITIES

Milling
Turning
Sawing
Drilling
Reaming
Tapping
OD/ID/Centerless Grinding
Burnishing
Light Duty Hobbing & Broaching
Medium-Duty Stamping & Drawing

HIGH PRESSURE COOLANT CAPABILITY

Yes

ALL METAL SAFE

Yes

REFRACT INDEX

2.1



TYPICAL PROPERTIES

Fluid Type	Synthetic
Appearance	Clear liquid
Odor	Mild chemical
Specific Gravity, 60°F (15.6°C)	1.068
Weight, lb/gal., 60°F (15.6°C)	9.3
pH (5% dilution)	8.7
Alkalinity	2.5 meq/g

PRODUCT APPLICATION / USAGE

Lubricut 4265 is recommended for general purpose machining of ferrous and non-ferrous metals.

Operation	Carbon Steels, Cast Iron	High Alloy Steels	Tool Steels	Aluminum Alloys
Milling, Drilling, Turning	4–5%	5–7%	5–7%	8–12%
Tapping, Sawing	4–6%	5–6%	4–5%	10–12%
Reaming, Broaching, Gun Drilling	6–8%	6–8%	6–8%	N/A

MIXING DATA

Lubricut 4265 metalworking fluid is to be mixed with water for use. Always add product concentrate to the water, not water to product concentrate. Add with mild agitation. The ideal concentration ratio should fall between 3% and 6% and can easily be monitored by refractometer or alkaline titration using the Chemtool titration kit.

Concentration	10%	6%	5%	4%	3%
Refractometer Reading (factor = 1.72)	5.75	3.50	3.00	2.25	1.75
Drops 0.5N HCl (factor = 0.38)	26	15	13	11	8

PRODUCT CODE

2667100000

HEALTH AND SAFETY

For health and safety guidance, please refer to the Chemtool SDS (Safety Data Sheets).