

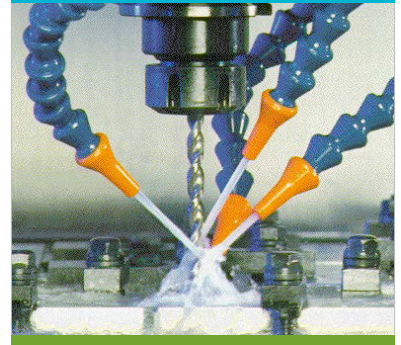
# LUBRICUT 4235

## METALWORKING FLUID

### ▷ PRODUCT DESCRIPTION

**Lubricut 4235** is a synthetic metalworking fluid designed for grinding and light duty machining of ferrous metals such as cast iron, grey iron, and high alloy steel. Lubricut 4235 can also be used for light to medium duty operations on copper alloys. This product has very good fines settling characteristics that prevent build up on grinding wheels. It provides an optimum balance of lubricity and detergency for quality finishes on machined parts. A special corrosion inhibitor package gives excellent protection against rust and corrosion of grey-iron while leaving a very light, fluid film. Performance characteristics can be optimized by controlling concentration between 3% and 6%.

### APPLICATION



#### COMPATIBLE METALS

- Cast Iron
- Carbon Steel
- Tool Steel
- Stainless Steel
- Titanium
- Bronze
- Copper
- Brass

#### MACHINING CAPABILITIES

- Milling
- Turning
- Sawing
- Drilling
- Reaming
- Tapping
- OD/ID/Centerless Grinding

#### ALL METAL SAFE

No

#### REFRACT INDEX

2.9



## TYPICAL PROPERTIES

Fluid Type	Synthetic
Appearance	Clear liquid or blue
Odor	Mild chemical odor
Specific Gravity, 60°F (15.6°C)	1.045
Weight, lb/gal., 60°F (15.6°C)	8.70
Freezing Point	32°F (0°C)
pH (concentrate)	9.40
pH (5% dilution)	9.00
Alkalinity, concentrate (meq/gram)	1.8

NOTE: Product remains stable through five (5) freeze/thaw cycles

## PRODUCT APPLICATION / USAGE

Lubricut 4235 is recommended for general purpose machining of aluminum alloys, non-ferrous and aluminum alloys, and tougher exotic alloys (both non-ferrous and ferrous).

Operation	Carbon Steels, Cast Iron	High Alloy Steels	Copper Alloys
Milling, Drilling, Turning	4%	5%	4%
Form Milling, Sawing	5%	5 – 6%	4 – 5%
Grinding: I.D., O.D., Centerless	4%	5%	4%

## MIXING DATA

Lubricut 4235 metalworking fluid with water for use. Add product to water with moderate agitation for mixing. 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	3.7	2.3	1.9	1.6	1.2
Drops 0.5N HCl	23	14	12	10	8

## PRODUCT CODE

2668200000

## HEALTH AND SAFETY

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