

# LUBRICUT 1144 CF

SEMI-SYNTHETIC METALWORKING FLUID:  
HIGH PERFORMANCE FOR ALL METALS – CHLORINE FREE

## ▶ PRODUCT DESCRIPTION

**Lubricut 1144 CF** is a high performance and versatile, chlorine-free, semi-synthetic based metalworking fluid designed specifically for demanding precision applications of both ferrous and aluminum alloys. Formulated with the latest chemical innovations for lubricity, wetting, and corrosion prevention available, Lubricut 1144 CF establishes the standard for superior performance without the need for chlorine. The unique emulsifier and detergency package prevents bacterial problems and hard water soap formation typical of traditional soluble oil metalworking fluids. Lubricut 1144 CF also utilizes a very high viscosity base oil blend for increased boundary film lubrication and superior film strength on machined/ground surfaces. Lubricut 1144 CF incorporates a synthetic surface lubricant technology which offers comparable performance to traditional soluble oils containing chlorine, sulfur, or phosphorus.

Lubricut 1144 CF, enhanced with specialized corrosion inhibitors, offers outstanding corrosion protection/anti-staining properties on aerospace and automotive aluminum alloys. When cleanliness and performance are your priorities, Lubricut 1144 CF is the product of choice.

## ▶ FEATURED BENEFITS

- Sulfonate Free Chemistry: Will not produce “Monday Morning Odors”. The biostable chemistry maintains the pH eliminating objectionable odors.
- Hard Water Stable: Lubricut 1144 CF has twice the hard water stability of traditional soluble oils thereby maintaining a stable emulsion for better wetting and lubricity
- Additive Independent: No need for tank side pH buffers, emulsifiers, or costly and hazardous biocides
- Chlorine Free Chemistry: Lubricut 1144 CF eliminates the need for chlorine with a unique blend of synthetic esters and high molecular weight base oils
- Excels at maintaining tolerances and finishes at very high speeds & feed rates above 10,000 RPM
- Triazine free

## ▶ APPROVALS

- Super-compliant for California SCAQMD Rule 1144

## 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  
Roll Forming  
Medium-Duty Stamping & Drawing

### HIGH PRESSURE COOLANT CAPABILITY

Yes

### ALL METAL SAFE

Yes

### REFRACT INDEX

1.3





## TYPICAL PROPERTIES

Fluid Type	Semi-synthetic
Appearance	Amber liquid
Odor	Mild odor
Specific Gravity, 60°F (15.6°C)	1.013
Weight, 60°F (15.6°C)	8.45 lbs/gal.
pH (10% dilution)	9.60
Biostability	Excellent
VOC, ASTM E 1868	30.1 grams/liter

Product separates upon freezing. Thaw completely at room temperature and mix thoroughly prior to use.

## PRODUCT APPLICATION / USAGE

Lubricut 1144 CF is recommended for general purpose and high performance machining and grinding of ferrous and non-ferrous alloys.

Operation	Carbon Steels, Cast Iron	High Alloy Steels	Aluminum Alloys
Milling, Drilling, Turning	6–8%	9–12%	7–15%
Reaming, Light Duty Broaching, Tapping, Sawing	6–9%	8–13%	8–14%
Grinding: I.D., O.D.	6–7%	6–8%	6–9%

## MIXING DATA

Lubricut 1144 CF 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. Product concentration can easily be monitored by refractometer.

Concentration	15.0%	12.5%	10.0%	7.5%	5.0%
Refractometer Reading	11.5	9.6	7.7	5.75	3.85

## PRODUCT CODE

23120D0000

## HEALTH AND SAFETY

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