

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 is enhanced with specialized corrosion inhibitors which offer 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 and feed rates above 10,000 RPM.**
- **Triazine free**

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
Specific Gravity, 60°F (15.6°C)	1.013
Weight, lb/gal., 60°F (15.6°C)	8.45
pH (10% dilution)	9.60
Biostability	Excellent

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, Milling, 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).